

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000368**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 17-Oct-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 0 / 21**HSR's:** 0 / 6**NCR's:** 0 / 11

Item	Title	Detail
1	Major component movement	<p>77m Tower Mock-up: No welding observed.</p> <p>89m Tower Mock-up: Performing repairs to interior corner plate.</p> <p>114m Tower Mock-up: QC performed UT testing of Skin Plate PJP Butt welds.</p> <p>Closed-rib Weld Trials: QA observed grinding of tack welding of 5 closed-ribs to deck plate for the Closed-rib Weld Trials. Welding to begin at 0700 tomorrow.</p>
2	Meetings attended	<p>QA met with ABF and ZPMC at 1400 to discuss the schedule for the next two days:</p> <p>77m Tower Mock-up: Skin A awaiting CWR for 3rd time repair, Begin Welding Diaphragm flange plate butt joints pending 2 additional flange plates from Wuxi Boiler (in shipping).</p> <p>89m Tower Mock-up: Weld Skin Plate Butt Joints, Beveling Skin Plates.</p> <p>114m Tower Mock-up: Work pending resolution of stiffener to skin plate repair rate.</p>
3	Key conversations	<p>ABF Level III Steve Lawton spoke with QA about the new MT Powder that ZPMC is using. Mr. Lawton informed QA that the manufacturer recommends a maximum operating temperature of 150 degrees Fahrenheit. This is not sufficient to use for performing the root pass MT of the PJP joints at elevated temperatures.</p>

Caltrans met with ABF and ZPMC at 1300 to discuss issues related to

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# DAILY PROJECT JOURNAL

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fabrication:

ZPMC asked about the status with ABF of their internal NCR for welding of HPS material with an incorrect electrode. ABF stated that ZPMC needs to revise to include cause and preventative measures.

ZPMC had questions regarding documentation of the root gap and angle for the weld trial. Caltrans confirmed the actual dimensions should be recorded after fitting and the angle measured on the rib prior to fitting.

ZPMC requested clarification on the Caltrans response to their closed-rib WPS. Caltrans stated the final WPS shall be based upon the parameters qualified in the Closed-rib Weld Trials.

ZPMC notified ABF and Caltrans that starting tomorrow they will be welding until 10pm on the PJP stiffener to skin plate welds for the 89m Tower Mock-up.

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4	Other important observations	ZPMC performed UT testing of a Closed-rib sample as part of a preliminary proof of their Closed-rib UT procedure. ZPMC identified 12 areas which were scribed on the part and identified with the associated amount of penetration. The area of closed-rib was cut and delivered to ABF for further testing. The rib will be UT examined by both ABF and Caltrans prior to having macro-etch samples taken at the scribed areas.
5	Quality Assurance Inspectors per shift	6 Day Shift (Acuna, Brannon, Hasler, Hernandez, McClendon, Viars) 3 Swing Shift (Berger, Dixon, Franco)
6	Logistics	Due to the start of the first Closed-rib Weld Trial tomorrow, the Issues Meeting has been rescheduled until Friday.

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**Inspected By:** McClary,David

Quality Assurance Inspector

**Reviewed By:** Lowry,Patrick

QA Reviewer

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