

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-000492**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 23-Nov-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 0 / 30**HSR's:** 0 / 10**NCR's:** 0 / 14

Item	Title	Detail
1	Other important observations	At 0930 hours I went on a Fabrication Shop-Walkthrough with Peter Dautermann. In the shop we observed the following: (1) ZPMC was working on the 89-m skin plate stiffener welds. ZPMC continues to weld the PJP welds of Skin Plates A and E in the 1G position with skin plate secured to the A-frame fixture. As previously discussed with ABF, this is not in accordance with the Mock-Up Fabrication and Welding Sequence which shows ZPMC will weld the PJP welds in the 2G position (with a gantry welder) with the skin plate laying flat. We also observed ZPMC welding the first skin plate stiffener to Skin Plate C of the 89-m mock-up with the gantry welder mentioned above. (2) ZPMC was using a block of concrete (approximate weight 3-Tons) in preparation to heat the plate and use the block's weight to remove the distortion from the plate. We requested to see the Heat Straightening Request (HSR) which did not approve the use of active pressure during heating. The Quality Control Inspector informed the Production Foreman to remove the block before performing the heat straightening. This issue will be brought up to ABF during the meeting today.
2	Meetings attended	At 1300 hours I attended the Daily Stand-Up/Issue Meeting. The following items were discussed: (1) ZPMC asked about the three OBG CWR's submitted on 21-NOV-07. CT replied these were approved as noted and returned to ABF on 22-NOV-07. ABF to look into why these were not transmitted to ZPMC (2) ZPMC requested the status of approval for material Batch 41. ABF indicated they were still reviewing the documentation due to the amount of material in this batch. (3) ABF requested ZPMC to make the necessary corrections to the Batch 5 Check Sample documentation in order to expedite the samples to the lab. (4) ZPMC discussed their position regarding the welding of the 89-m Skin Plate Stiffeners PJP welds in the 1G position. ZPMC agreed the welds were made out-of-sequence with the Mock-Up Fabrication and Welding Sequence plan but stated that since they were allowed to do the repairs in

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the 1G position, then it would also be acceptable to weld the Skin A and E welds in the 1G also. ABF stated this procedure violated the contract because it was not the method that was approved or will be used in production. ZPMC then stated that due to a lack of direction from ABF regarding their new procedure, they moved forward in a manner they preferred. ABF then stated they would like to discuss this with ZPMC internally. (4) METS discussed the importance of heat straightening in accordance with the approved HSR. METS also discussed the difference between the use of active and passive mechanical means when heat straightening.

Inspected By: Smith,Ryan

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer
