

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 22-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	Major component movement	<p>OBG Production:</p> <p>Welding floorbeams, Drilling and cutting T-Stiffeners.</p> <p>77m Tower Mock-up: Welding stiffener plates between diaphragms.</p> <p>89m Tower Mock-up: Welding Longitudinal Stiffener to Skin Plate, Welding shear links.</p> <p>114m Tower Mock-up: Weld Longitudinal Stiffener to interior splice plates.</p> <p>Deck Plate Mock-up: Preparing deck splice.</p> <p>2nd OBG Weld Trial: ZPMC cut the samples representing areas with rejectable overlap, marginal overlap and acceptable convexity. The etching and meeting regarding overlap is scheduled for tomorrow, 11-23-07.</p>
2	Meetings attended	<p>Caltrans met with ABF and ZPMC at 1300 to discuss issues and the schedule for the next three days.</p> <p>ZPMC asked about the status of BCWR-001, 002 and 003. Caltrans stated their review was almost complete and a response would be issued today.</p> <p>ZPMC asked about HSR request 4, 8 and 11 submitted on November 12th and 15th to ABF. After some research, ZPMC clarified that these were closing document submittals. Caltrans will check on the status of the submittals.</p> <p>ZPMC stated that submitted Check Sample Batch 5 to ABF today. The</p>

DAILY PROJECT JOURNAL

(Continued Page 2 of 3)

batch consists of 47 samples which represent all of the material submitted to Caltrans to date. Also included are the two heats that were put into production prior to sampling. Check Sample Batch 4 was cut today and is scheduled to be shipped to the lab tomorrow.

ZPMC informed ABF and Caltrans that they have submitted WQCP Addendum B-8 to ABF yesterday. This addendum includes welder qualifications conducted for 4G SMAW and 1G FCAW (non-standard with ceramic backing). ZPMC stated both of these were critical for their production schedule.

ABF asked ZPMC about the status of the audit request for the furnace and bending for the Tower diaphragms proposed to take place at the Changxing Island facility. ZPMC stated they were preparing the MSFQA and request help from ABF to identify the sections required.

ZPMC informed ABF and Caltrans that the machining of the 89m Tower Mock-up Diaphragms at the Zhang Jiang base in Pudong was scheduled to begin on Monday, November 26th and would last approximately 5 days. Caltrans discussed the change of weld details. Several revisions have been made to the weld details for production, but these changes may not be reflected on the mock-up drawings.

3	Key conversations	QA spoke with ABF Level III Steve Lawton and ZPMC Level III Steven Kang about the UT procedure development. The group discussed required items in the UT procedure for referencing development testing regarding correction factors and information needed in the report forms. ABF now has two sets of calibration standards (one received by Caltrans today) that have been manufactured with EDM and surface ground. The group was optimistic about the progress of development with the new standards and agreed to form a working group once the draft UT procedure was ready in order to expedite the approval process. Mr. Lawton expressed the need for consistent bevels and root faces on the production and weld monitoring test ribs. QA brought up the suggestion from Caltrans Engineer Keith Devonport regarding additional supports on the beveling machine adjacent to the milling heads. The current support conditions allow the ribs to flex which create machining "chatter" resulting in tearing of the material and inconsistent surfaces on the bevel.
4	Other important observations	QA observed ZPMC UT Technician performing testing incorrectly using "finger dampening" (prohibited by Special Provisions) and improper scanning techniques. QA addressed this with ABF Level III Steve Lawton. Mr. Lawton stated he would address the issue.
5	Quality Assurance Inspectors per shift	4 Day Shift (Acuna, Hernandez, McClendon, Tracy) 3 Swing Shift (Berger, Dixon, Croff) 2 Graveyard Shift (Franco, Jobes)

Inspected By: McClary, David

Quality Assurance Inspector

DAILY PROJECT JOURNAL

(Continued Page 3 of 3)

Reviewed By: Lowry,Patrick

QA Reviewer