

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-000541**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 03-Dec-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 3 / 39**HSR's:** 1 / 19**NCR's:** 0 / 16

Item	Title	Detail
1	Critical Weld Repairs (CWRs)	CWR-026 114m Tower Mock-up Interior Splice Plate A75-3 R1>10% length CWR-028 114m Tower Mock-up Skin Plate "A" A58-1 R1>10% length CWR-029 114m Tower Mock-up Skin Plate "A" A58-3 R1>10% length
2	Heat Straightening Requests (HSRs)	HSR (CT)-019 89m Tower Mock-up Skin Plate MUSB-MA23
3	Major component movement	OBG Production: Welding floorbeams, Weld T-Stiffeners to Skin Plates Drilling and tack welding T-Stiffeners. 77m Tower Mock-up: No welding observed. 89m Tower Mock-up: Welding Longitudinal Stiffener to Skin Plate, Tack Welding of Cross Bracing – ZPMC unaware this was SPCM. 114m Tower Mock-up: Fitting Skin Plates to temporary diaphragm. Lower segment fit-up complete. Deck Plate Mock-up: Heat Straightening Splice.
4	Meetings attended	Caltrans met with ABF and ZPMC at 1300 to discuss issues and the schedule for the next three days. ZPMC asked about the Status of CWR's 26, 28 and 29. Caltrans stated this was approved earlier in the day. ZPMC asked about the status of HSR 19. Caltrans stated this was approved earlier in the day. ZPMC stated they would provide 2 day advance notice of resumption of 24

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hour a day shift work.

Batch 5 of rolled shapes is scheduled for verification this afternoon.

ZPMC asked about the status of the OBG and Tower Dimensional Verification Plans. ABF and Caltrans stated they would check on the status. Caltrans stated the QC Inspectors on the shop floor did not appear to know that the Cross Bracing for the 89m Tower Mock-up was SPCM. ABF and ZPMC stated they would make sure this was communicated to all of the inspectors. ABF stated they are still working on the Lead QC Submittal. ABF informed Caltrans that one HPS 485W plate (07100921N) that was already submitted to Caltrans failed supplemental Charpy-V Notch impact testing. ABF and ZPMC to generated an internal NCR and return this and other failed plates to the mill.

5 Key conversations

QA spoke with ABF Representative John Hamer regarding the cracking observed in the gap between the run-off tab and the PJP weld on the Stiffener to Skin Plate Welds on the 89m Tower Mock-up. The cracks are transverse and appear to be due to weld shrinkage. ZPMC is currently using one plate to form the run-off areas for two welds through a cope hole. QA and Mr. Hamer discussed that this creates a shrinkage problem that could be resolved by either using two separate run-off tabs or by changing the cutout of the cope hole to include run-off areas. Mr. Hamer was aware of the issue and stated he would look at the joint to determine the best solution. Consequent changes to the Fabrication Procedures may be required.

6 Quality Assurance Inspectors per shift

6 Day Shift (Acuna, Dawson, Brannon, Hernandez, Franco, Tracy)
3 Swing Shift (Berger, Croff, Jobes)
0 Graveyard Shift (Cancelled by ZPMC)

7 Logistics

QA inspector Scott Croff and Ken Jobes stayed on Changxing Island on Sunday night. The normal ferry at the end of the swing shift was cancelled due to heavy fog.

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer