

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-000580**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 08-Jan-2008**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** /**HSR's:** /**NCR's:** /

Item	Title	Detail
1	Major component movement	<p>OBG Production:</p> <p>Tack welding and welding Stiffeners to Skin Plates.</p> <p>77m Tower Mock-up:</p> <p>Grinding and back gouging corner welds.</p> <p>89m Tower Mock-up:</p> <p>Welding web to skin plates.</p> <p>114m Tower Mock-up:</p> <p>Grinding welds for UT testing.</p> <p>Deck Plate Mock-up:</p> <p>ZPMC is in the process of cutting the Macro-etch specimens.</p>
2	Key conversations	<p>Caltrans Level III's David McClary and John Kinsey met with ABF Level III Steve Lawton and Level II Warren Buehler to discuss the development data for the Closed-rib UT procedure. ABF presented the data and explained that there appears to be a very accurate correlation between their data and actual closed-rib UT readings for the closed-ribs welded using the same joint fit-up and welding process to be used in production. However, when ZPMC attempted to induce LOP artificially in the 3mm to 5mm range by increasing the size of the land (also resulting in increase root opening) the results no longer appear to be within the required accuracy. ABF intends to submit the UT data from the samples welded with the same joint fit-up and welding process to be used in production. This data is intended to qualify the accuracy of the UT procedure within contract requirements for 80% penetration and greater. ABF intends to continue procedural development in the 60% to 80% range using either samples from the Closed-rib Weld Trial, Deck Mock-up or new welded samples with the same joint configuration and tolerances to be used in production. QA</p>

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## DAILY PROJECT JOURNAL

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expects a submittal by the end of this week for the range qualified and giving details of further development to take place.

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3 Other important observations

Surveyors for both ABF and Caltrans were on-site today to discuss dimensional control and verification.

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4 Logistics

QA was informed the 1030 pm ferry was cancelled, however the weather cleared and the ferry was in operation.

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**Inspected By:** McClary, David

Quality Assurance Inspector

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**Reviewed By:** Lowry, Patrick

QA Reviewer