

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-000676**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 15-Feb-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>Machining and beveling closed-ribs, Welding Stiffeners to Side Plate, Welding Deck Plate Splices, ZPMC performed welding of a Closed-rib to Deck Production Monitoring Test (PMT). ZPMC welded Deck Panel DP-48. Repairs were performed to the root pass (no repair procedure approved to date – see conversations). After welding of Cover Pass, ZPMC began grinding and preparing for weld repairs. Grinding and repair work was stopped by ABF.</p> <p>Tower Production: No work observed.</p> <p>77m Tower Mock-up: No work observed.</p> <p>89m Tower Mock-up: Welding interior corner stiffener plates.</p> <p>114m Tower Mock-up: Drilling holes for tower splice.</p> |
| 2 | Meetings attended | <p>Caltrans and ABF met to discuss the Production Monitoring Test (PMT) criteria for welding the Closed-rib to Deck Panel PJP welds. The group agreed the Special Provisions allow for production to begin prior to completing testing of the PMT. The ability for ZPMC to proceed with the production GMAW weld is to be based up visual acceptance of the GMAW root pass on the PMT. Proceeding with the production SAW weld is to be based upon visual acceptance of the SAW cover pass on the PMT. Should the PMT cover pass fail to meet the agreed upon visual inspection limits (undercut, overlap, incomplete fusion values based upon the Weld Trial and</p> |

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Deck Plate Mock-up) but not exhibit “gross” discontinuities, welding of production panels may proceed. In this case the first production panel must meet the agreed upon visual inspection limits before production is allowed to continue.

3 Key conversations

QA spoke with ABF Engineer Gang Jiao regarding the repairs being conducted by ZPMC on the GMAW root pass for Deck Panel DP-48. QA stated that Caltrans understood the repair was necessary, but would be writing an incident report to document the occurrence of performing a repair without an approved procedure. ABF and ZPMC will document the repair areas, perform NDT after the weld is complete, and submit a repair procedure as a WQCP addendum.

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
