

**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-000706**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 10-Mar-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>Fitting and welding T-stiffeners to side plates, Performing Critical Weld Repairs on T-stiffeners, Fitting and welding stiffeners to floor beams, Machining, beveling and bending closed-ribs, Fitting closed-ribs to deck panels, ZPMC performed closed-rib welding on 2 PMT tests for Gantries 1 and 2, and welded Deck Plates DP038-001, DP042-001 and DP037-001.</p> <p>Tower Production:</p> <p>Cutting Skin Plates Heat straightening diaphragm plates, Fit-up and welding diaphragm plates. QA continues to observe issues with being able to achieve and maintain the required pre-heat uniformly on the joints.</p> <p>77m Tower Mock-up: No work observed on this date.</p> <p>89m Tower Mock-up: Grinding of diaphragm corner splice plates. Grinding appears to be excessive and additional grinding will be required.</p> <p>114m Tower Mock-up: QA observed ZPMC jacking the interior of the upper section on the corner splice pieces on Skin Plates A and E.</p>
2	Key conversations	<p>QA spoke with ABF QCM Steve Lawton regarding the marking of Y location for UT testing and identification of station markers for RT. ZPMC had requested QA mark areas on the transverse splices of 5 deck panels. However, no Y location marks were observed on 4 of the 5 panels. Mr.</p>

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Lawton was in agreement of the marking system and helped explain the necessary marking to ZPMC QC.

3 Other important observations

ABF scheduled a demonstration of grinding repairs to overlap on the closed-rib deck panels. The demonstration was performed on a practice panel. It took approximately 30 minutes to grind a 200mm area. The grinding perform did not appear to completely remove the overlap and resulted in the weld being undersized. Overall it did not appear to demonstrate an adequate method for removing overlap without damage to the finished weld or base metal.

QA performed check sampling of batches 47, 52, 54, 55, 57, 58, 59, 60, 62, 65 and 66.

The PQR's scheduled for the Kiswel FCAW Electrode for weld HPS485 to A709 gr. 345 today were cancelled. Upon opening of the FCAW electrode packages, it was discovered the packaging was damaged and the seal lost exposing it to the atmosphere. Re-baking of the electrodes is not possible since the wire is wound on plastic spools. PQR testing is suspended until new electrodes arrive.

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**Inspected By:** McClary,David

Quality Assurance Inspector

**Reviewed By:** Lowry,Patrick

QA Reviewer

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