

**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-000712**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 20-Mar-2008**Location:** Changxing Island, Shanghai, PRC**Submittals(New / Total):****CWR's:** /**HSR's:** /**NCR's:** /

Item	Title	Detail
1	Key conversations	<p>0800-Craig Hager, and I went and discussed the weld profile of the finished 43m elevation plate with Kevin Carpenter. The previous night, METS inspectors performed UT verification of the weld the results were inconclusive due to indications that were in the toe of the weld. ZPMC NDT technicians performed the UT using the "finger dampening" technique which is not allowed by the Special Provisions. We requested that ABF/ZPMC adhere to the Special Provisions, pg 150 "Groove weld surface profiles that interfere with the performance of the NDT procedure or produce questionable test results shall be ground smooth and blended with the adjacent material." Further in reference to the "finger dampening", the Special Provisions states "Finger dampening the ultra-sonic (UT) signal shall not be considered resolution of questionable test results." Mr. Carpenter agreed that the weld would be ground flush.</p> <p>1030-I talked with John Hamer, ABF about the status of the 114m mockup. Mr. Hamer indicated that one new interior corner splice plates (ICSP) were being fabricated. Mr. Hamer called Mr. Ding of ZPMC to verify this information and found that ZPMC intended to fabricate two new ICSP. Mr. Hamer estimated that the fabrication would take 2-3 weeks to complete.</p> <p>1200-Mr. Hamer and Xu Jun, came and discussed a ZPMC proposal to conduct testing on the mockups using strain gauges to determine the locations of residual stress. Mr. Hamer indicated that Dan Raynor, has rejected the testing. I stated that I was not aware of the proposed testing and that ABF has rejected it then the Department would not entertain it.</p> <p>1300-Soononn Low, ABF brought two field change notices for review. Both were revisions to the 77m and 114m mockup fabrication plans.</p> <p>1400-Peter Dautermann asked me to participate in a meeting with Xu Jun</p>

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and other ZPMC representatives to discuss the strain gauge procedure again. ZPMC wanted to perform the procedure in the afternoon. I reiterated that ABF had not discussed the procedure with the Department and I was not in a position to authorize any testing that involved drilling holes into the mockup.

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2 Other important observations

77m-No activity

89m-ZPMC finished welding the fit lug to longitudinal stiffener on Skin B on 3/19/08. Today ABF/ZPMC was performing NDT on the welds. ZPMC finished the visual inspection while I was observing and ABF verified the results. ZPMC was performing preliminary MT on fillet weld and will perform MT on the second fillet weld on 3/21/08. ABF/ZPMC understands that the results of the NDT in the 24 and 48 hour period after welding are not acceptable and results of acceptable welds will only be based on NDT performed 72 hours after the weld has been deposited.

114m-No activity

Bay 4-No NDT on the finished 43m elevation diaphragm. Welding continued welding on the other diaphragm plate in the bay.

Bay 8- ZPMC was working on four (4) diaphragm plates. QA Inspector Sherri Brannon pointed out 3 plates that were being heat straightened using weights. I examined the plates with Scott Kennedy, CT. ZPMC had elevated the end of one plate and placed a 10 ton weight in the center of the plate and was performing heat straightening. The ZPMC HSR does not show the weight as part of the heat straightening process. I took pictures and forwarded them to Dr. Mazen Wahbeh and Ryan Smith. I wanted to verify if using the weight in the manner was considered "passive" or "active". Mr. Smith let me know that in this case it was "active" restraint and was not allowed. I told Ms. Brannon to generate an incident report to document the non conformance.

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**Inspected By:** Ishibashi,Josh

Quality Assurance Inspector

**Reviewed By:** Wahbeh,Mazen

QA Reviewer

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