

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-000721**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 20-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, Fitting and welding stiffeners to floor beams, QA UT of floor beams revealed indications near the weld toe. ZPMC has not ground the weld as required by the Special Provisions to eliminate these indications, Machining, beveling and bending closed-ribs, Fitting closed-ribs to deck panels, ZPMC performed closed-rib welding on 1 PMT tests for Gantry 1, and Deck Plates DP110-002 and DP326-001. No welding was conducted on Gantry 2. Splice welding Side Plates in OBG Assembly Shop</p> <p>Tower Production:</p> <p>Cutting Skin Plates and Vertical Stiffeners, Heat straightening diaphragm plates. Heat straightening was conducting using an active force without engineer approval, Fit-up and welding diaphragm plates.</p> <p>77m Tower Mock-up: No work observed.</p> <p>89m Tower Mock-up: MT of stiffener lugs revealed cracks in the fillet welds. ZPMC to attempt another demonstration of the opposite diaphragm.</p> <p>114m Tower Mock-up: Waiting for corner splice plates. No work observed.</p>
2	Key conversations	<p>QA and ABF conducted a joint training session detailing to inspection of PMT tests. Items covered included: Production panels welding are not to begin until after the associated PMT test has passed visual and UT testing.</p>

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The acceptance criteria for visual and UT testing shall be in accordance with the letter issued by ABF detailing the agreement between ABF and Caltrans with the exception that 100mm of overlap is allowed per weld. Macro etches are required to show a minimum of 80% penetration. Anomalies in tack welds are not cause for rejection, but will be brought to the engineer's attention.

3 Quality Assurance Inspectors per shift Approximately 70% of the QA staff was performing Quality Control functions.

Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer
