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KEN-23

INTER-OFFICE MEMORANDUM

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AT

DATE October 31, 1967

FROM O. A. Finsand
O.A. Finsand

COPIES TO

AT Middletown Construction

JOB NO. 7100

SUBJECT Kaiser Engineer's Weekly Field Activity Report

Transmitted herewith is the subject report for the week ending October 31, 1967.

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KAISER ENGINEERS
WEEKLY FIELD ACTIVITY REPORT
Week Ending October 31, 1967

WEATHER: Generally fair and cool in early part of period with rain the last two days.

Client: Armco Steel Corporation

Location: Middletown, Ohio

Job Number: 6471

TEMPERATURE: Maximum - 70 degrees
Minimum - 27 degrees

JOB VISITORS

R. J. Wolf, W. E. Burger, C. B. Bluementhal, J. F. Chajnowski, N. R. Garder, S. Montell, Barbara Stengel, D. H. Wheeler, J. Heiades, J. Zorena, T. Zygmuntowicz

SUMMARY FORCE REPORT

	Kaiser Engineers Exempt	Kaiser Engineers Non-Exempt	Subcontractors	Foothill Electric	Total
Management	5	3		1	9
General Supervision	16	3	23	6	48
Field Engineering	47	23	11	16	97
Warehs. & Mtl. Control	4	7		1	12
Survey	2	19	4		25
Office Srv. & Repro.	1	7			8
Clerical			17	19	36
Craft *	___	1,514	1,209	655	3,378
TOTAL	75	1,576	1,264	698	3,613

* Average for week of men on payroll.

Average for week of Crafts is as follows:

Kaiser Engineers	1,415
Subcontractors	1,159
Foothill Electric	623
Total Crafts Working	3,197

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WEEKLY FIELD ACTIVITY REPORT
Week Ending October 31, 1967

PROJECT PROGRESS

1. 7148 - HOT STRIP MILL

1.1 Excavation and Backfill: 1,806 cubic yards of backfill was completed during the period for a total to date of 894,782 cubic yards.

1.2 Concrete: 27 cubic yards of concrete was placed during the period for a total to date of 209,858 cubic yards. Period concrete consisted mainly of: grouting for the slab reject transfer car and a few isolated pours throughout the Hot Strip Mill.

1.3 Structural and Miscellaneous Steel: A work force of 70 men continued during the period on installation of miscellaneous steel in the Hot Strip Mill. At column line 1, the slab reject car rails were completely grouted in place and the slab reject car installed on the rails. The slab reject car is scheduled to complete and be ready for operation on November 15. Test operations were in progress during the period on slab transfer car 2 before placing it in operation. Modification to the cable reel has been accomplished on this transfer car and the cable guide will be installed when delivered next period. Operation of transfer car #1 and 2 is still dependent on final electrical work which is presently in progress. In the furnace area, the temporary platforms for conveying brick were removed at furnace #1 and 2 and the grating was installed at furnace #1. The furnace #2 stile between pushers 1 and 2 was also installed. In the downcoiler area, installation of grating and handrail continued during the period. This work is 95% complete. At the coil conveyor trenches between the Hot Strip Mill and the Green Coil Storage Building, the handrail installation is complete. In the Roll Shop Area, installation of floor plate and grating continued in the #2 roll grinder area. In the pump house and clarification building, miscellaneous work related to safety requirements continued throughout the period. Progress was also continued during the period on handrail and platform installation at Scale Pit 3. The miscellaneous steel installation at this scale pit will complete next period. At column line 1, progress continued on cover plate installation over the steam trench. An estimated 80 tons of miscellaneous iron remains to be installed in the Hot Strip Mill excluding extra work orders. This miscellaneous iron is scheduled to be installed by November 15th. Progress will continue on authorized extra work orders in the Hot Strip Mill as required.

1.4 Roofing and Siding: 5,000 square feet of siding was installed in the Waste Heat Boiler Area of the Hot Strip Mill during the period for an overall total to date of 658,693 square feet.

1.5 Heating and Ventilating: At the Hot Strip Mill bag houses, power wiring and lighting for bag houses1 through 5 and bag house 15 in the slab storage area was essentially completed during the period. Piping con-

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tinued in four of these six bag houses throughout the period and this piping is scheduled to complete by November 15. Bag houses 3, 8 and 9 are complete and ready for operation. Electrical progress was continued during the period on bag houses 6, 7 and 14. No period progress was evident on the remaining bag houses. Norm Woolley (Contractor for Heating and Ventilating Units at Director Rooms and Offices throughout the Hot Strip Mill) maintained an average work force of 10 men during the period. Installation of diffusers at the scheduling office air conditioning system was accomplished during the period. This system is now in operation and ready for final balancing. Instrument work was accomplished for the computer room heating and ventilating system. This system is also in operation. At the finishing mill office complex, steam was connected to the heating and ventilating unit this period, but instrument air is required for automatic operation. At the pump house air conditioning unit, steam was connected to the unit this period. Progress was also evident at the clarification building air conditioning unit on electrical work and instrumentation. The gas fired heaters in the clarification building are installed and the piping complete. Some electrical disconnections are needed to complete these units before they are ready for operation. In the boiler house control room, the heating and ventilating fan unit was delivered to the job site. This fan is scheduled for installation next period and the system is scheduled to complete by November 6. The heating unit for the grease house is scheduled to be installed between November 7 and 14.

1.6 Mechanical: During the period, Eichleay Corporation maintained an average work force of 75 men on mechanical installation in the Hot Strip Mill. In the furnace area, the installation of all mechanical equipment is complete with the exception of operating the rams and setting the fore and aft limit switches and completing the bridge tables to the furnace skids at furnace #2 and 3. Installation of the dry scale removal system continued during the period. Erection of the dry scale hopper structure at column line 3 east of E-line is in progress. Some modifications will be necessary on the Sauerman drag bucket on the delivery side before it can be completed. In the rougher area, remedial work continued on the rougher #4 edgers for United Engineering. Remedial work for edgers 2 and 3 were successfully completed. In the finisher area, rework of the finishing mill main drive motors continued during the period under the direction of Westinghouse. The Westinghouse schedule has been established for dismantling and returning all seven finishing mill main motor stators to the Pittsburgh factory by truck for examination and check out and returning them to the job site for re-installation. This schedule arranges for the following order: F2 motor to be shipped first and returned by November 6, F4 to be returned to the job site November 7, F1 to be returned to the job site by November 10, F6 to be returned to the job site by November 15, F3 to be returned to the job site by November 19, F5 to be returned to the job site by November 23 and F7 to be returned to the job site by November 27. Progress continued during the period on

machining of the quick roll change rams for the finishers at the Armco Machine Shop. In the downcoiler and runout area, rework was continued during this period on the runout table motor bases and motor installation continued as bases became available. The mechanical installation of the signode coil bander is essentially complete. This unit can be energized and supplied with plant air for testing before grouting can be accomplished. Progress continued during the period on the chain and drive installation for the coil conveyors in the Green Coil Storage Building. Delivery of the necessary material for completing the revision to the radial turn conveyor #6 has not arrived at the job site. Mechanical installation of this conveyor will be completed as soon as the Link-belt delivery is received. Percentage completion for mechanical items in the Hot Strip Mill are as follows: the slab loading and charging tables, 100%; pusher and skids, 97%; delivery tables, 100%; extractors, 100%; slab reject car, 75%; vertical scalebreaker, 100%; roughing mill 1, 97%; roughing mills 2 through 6, 100%; crop shear, 95%; scalebreaker, 100%; finishing mills, 97%; hot runout tables, 90%; downcoilers, 97%; coil conveyors, 75% and roll grinders 50%. Assembly of roll grinder 3 continued throughout the period. At Scale Pit 3, mechanical installation of the Link-belt wet scale removal system is in progress and is scheduled to complete late in November. Coupled tests were completed for pusher 1 and finishing mill main motor 5. Uncoupled tests were accomplished for finishing mill motor 3 and crop shear.

1.7 Piping: During the period, 7,209 feet of piping was installed for a total to date of 311,767 linear feet. 26,907 linear feet remains to be installed by Kaiser forces in the Hot Strip Mill. Major piping systems worked on during the period were: grease, lube oil 10, hydraulic system 17, hydraulic system 18, hydraulic system 16, high pressure descaling water, mill water, furnace cooling water, clarifier sludge piping, clarifier drains, mill high pressure water, plant air, steam and instrumentation. Pickling of lube oil 10 was completed this period and flushing of the system is in progress. Flushing is also in progress on hydraulic system 15. Hydro testing of hydraulic system 16 is underway and preparations are being made to hydro hydraulic system 18 next period. At pump pit 4, installation of three expansion joints on the suction side of the pumps has been completed. One expansion joint has been sent back to the factory for rework and the fifth expansion joint has not been delivered to the job site. It is anticipated that three of these five pumps will be in operation in two weeks. Two pumps at Scale Pits 1 and 2 are now operable. On the high pressure descaling system, eleven new welds on 2" and larger piping was completed during the period with 27 remaining. Seven welds were reworked during the period. 171 1-1/2" Barksdale welds were accomplished this period with 236 remaining. All lube oil systems except ten have been released for insulation. A piping tagging crew is scheduled to start tagging and identification of lube oil systems soon. The #1 air compressor has been grouted in place in the pump house. This unit is scheduled to complete by November 23, 1967. Air compressor #2 was delivered to the job site during the period. The coolers for this unit are scheduled to arrive next period.

1.8 Electrical: Foothill Electric Corporation installed 26,000 lbs. of exposed conduit during the period for a total to date of 1,407,000 lbs. 64,000 feet of low voltage cable was installed for a total to date of 1,541,000 feet or 88% complete. 1,800 low voltage cable terminations were accomplished for a total to date of 26,000 or 84% complete. 46,000 feet of control cable was installed for a total to date of 1,626,000 or 88% complete. 1,600 control cable terminations were accomplished for a total to date of 47,000 or 81% complete. 17,000 feet of computer cable was installed for a total to date of 732,000 or 78% complete. 600 computer cable terminations were accomplished for a total to date of 25,800 or 85% complete. 4,100 lbs. of conduit lighting and 5,000 feet of of wiring for lighting was installed during the period. 1,000 lbs. of structural grounding was installed for a total to date of 132,000 lbs. 425 feet of communication conductor cable was installed and 20 terminations accomplished. Foothill maintained an average work force of 480 men in the Hot Strip Mill during the period.

1.9 Miscellaneous Subcontracts: Bilbrey Masonry's contract for block work in the Hot Strip Mill is now complete.

Moeschl-Edwards received delivery of the remaining roll-up doors for the Hot Strip Mill. Three of these doors were erected during the period. Five doors remain to be erected.

The Blome Glass Company glazed the pedestrian tunnel enclosures and the boiler house control room enclosure during the period.

Owens-Corning Fiberglas continued with insulation of the 165.lb. steam system and lube oil systems in the oil cellar. 300 feet of steam line was insulated during the period for a total to date of 13,900 linear feet. 1,100 feet of Morgoil system #1 was insulated and 590 feet of lube oil system #4 was insulated this period. Insulation was continued during the period on steam systems in the waste heat boiler area. It is estimated that 65% of the steam lines in this area are complete.

Delta Pipeline Contractors installed 2,198 linear feet of pipeline and 16 service drops in the Hot Strip Mill during the period. The total pipe installed to date is 30,219 linear feet. 90 service drops have been installed to date with 207 remaining. 6,668 linear feet of 2" and larger service piping remains to be installed in the Hot Strip Mill. Progress during the period consisted mainly of plant air and oxygen piping.

Ohio Valley Riggers have completed installation of all flocculators in the clarification building. Progress continued during the period by Delta Pipeline Contractors on installation of the fuel oil lines from the fuel oil storage tanks to the pump house. This underground piping is expected to complete in two weeks.

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The FBS Builders continued with installation of refractory at the emergency coil storage area near column line 60 during the period. This will complete his work for the Hot Strip Mill.

Stuart Painting Company is continuing with the painting of structural steel, miscellaneous steel, piping systems, mechanical equipment, electrical equipment and architectural structures throughout the Hot Strip Mill as required and as released by the area engineers.

Salem-Brosius continued with refractory work and slab reheat furnace #2 up-take area and floor. In furnace #3, refractory installation was continued on the side walls and Detrick roof. Piping was also in progress at furnace #2 and 3 on oil, steam and impulse piping. Electrical power wiring and terminations were also in progress throughout the period on furnace #2 and 3. Painting of furnace #1 is 50% complete and insulation 76% complete. Furnace #1 is in the clean-up stage and preparations are being made for dry-out to begin on November 20th. Furnace #1 is 97% complete, furnace #2 is 85% complete and furnace #3 is 71% complete.

Babcock and Wilcox continued with insulation and lagging of the forced draft and induced draft fans and related ducts at all units. Progress was also evident on the installation of the #3 induced draft fan rotor and fan housing. Progress on the fan and duct installation is 92% complete. Forced draft fan #1 is scheduled for test and check-out the week of November 13th.

The Mo Piping (Contractor for the Waste Heat Boiler 2-1/2" and over piping) is now 97% complete. Pressure testing of the boiler feed piping was accomplished also the desuperheater line testing was completed this period. Progress continued throughout the period on changes and additional hangers as required on the revised Dravo design drawings.

Norm Woolley (Contractor for the Waste Heat Boiler 2" and under piping) is 96% complete. During the period, pressure testing of the instrument air piping and desuperheater piping was completed. Work continued during the period on additions and changes required by recent revised drawing requirements.

Minneapolis-Honeywell (Contractor for the Waste Heat Boiler Instrumentation) is 67% complete. Progress during the period consisted mainly of instrument calibration and tubing terminations at the main control panels and the soot blower panels.

2. <u>7146 - SLAB MILL</u>

2.1 <u>Excavation and Backfill</u>: 3,743 cubic yards of backfill was completed during the period for a total to date of 209,893 cubic yards.

2.2 Concrete: 670 cubic yards of concrete was placed during the period for a total to date of 45,537 cubic yards. During the period, the concrete pours consisted mainly of a crop pit slab near column line 8, skip hoist tower walls, the top lift of the west scale pit wall from 8a to 9.5a, a portion of the pump room slab and roll tilter foundation walls. The scale pit #4 main structure concrete was completed this period.

2.3 Structural and Miscellaneous Steel: The main mill pulpit arrived during the period and was set in place. Support steel for the scarfer pulpit is not expected until early December. The transfer car track rails are 95% complete. Progress was continued during the period on erection of bag houses.

2.6 Mechanical: Eichleay Corporation continued throughout the period with an average work force of 52 men on mechanical installation in the Slab Mill. Progress was continued in all areas of the Slab Mill throughout the period. An estimated 2,880 tons of mechanical equipment has been installed in the Slab Mill to date. 92% of the Slab Mill equipment has been delivered to the job site. Progress to date in the Slab Mill on mechanical installation is as follows: the ingot buggy and drive, 25%; tables, 60%; double manipulator, 15%; the vertical mill, 25%; the horizontal mill, 40%; scarfer, 5%; the slab shear pusher and transfer cars, each, 30%; crop conveyor, 20%; slab scale, 80%; slab pitters, 20%; stationary end stops, 80%; the MG sets and main mill drives, 35%. Eichleay plans to increase their work force in this area in the near future as the work load in the Hot Strip Mill decreases.

2.7 Piping: Hunter (Piping Contractor for the Slab Mill) continued with an average work force of 61 men on installation of Slab Mill piping systems. In the Slab Mill oil cellar, installation of lube oil 3, 6, 7 and 11 continued during the period. Piping installation for hydraulic systems 1 and 2 is also in progress. In the main mill aisle along column line D, header piping was continued for plant air, grease, oxygen and natural gas pipelines. This header piping between column 1 and 18 is 95% complete. Progress was also continued along column line E on natural gas and oxygen headers between column 1 and 18. The natural gas piping is being tested and natural gas is scheduled in the lines for start-up of the motor room heater by November 6. Hunter has been installed 12,045 linear feet of piping to date.

2.8 Electrical: 4,700 lbs. of exposed conduit was installed during the period for a total to date of 15,000 or 12% complete. 10,300 lbs. of embedded conduit was installed for a total to date of 602,600 lbs. or 94% complete. 300 feet of cable tray was installed for a total to date of 16,700 feet. 5,400 feet of lighting wiring was installed during the period. 1,300 lbs. of structural grounding was installed for a total to date of 15,000 lbs. or 30% complete. An average work force of 90 electricians was maintained in this area during the period.

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Week Ending October 31, 1967

3. 7143 - SOAKING PITS

3.1 Excavation and Backfill: 210 cubic yards of excavation was completed at the Soaking Pits for a total to date of 73,840 cubic yards. 74 cubic yards of backfill was made for a total to date of 113,065 cubic yards.

3.2 Concrete: 155 cubic yards of concrete was placed for a total to date of 28,086 cubic yards. During the period, concrete work consisted mainly of: foundations for the east side cable house trench slab, some D-line footer columns and the Z-line loaking dock wall between column 5.5 and 6.5.

3.3 Structural and Miscellaneous Steel: 12 tons of structural steel was erected for a total to date of 4,207 tons. Ohio Valley completed bolt-up of stair towers at column 12.5 and 5.5 during the period. The ingot buggy support steel bolt-up was also completed during the period. The structural steel for the 107 elevation floor deck south of X-line arrived on the job site this period. Erection to start next period.

3.6 Mechanical: Loftus Engineering continued with good progress in all phases of battery erection during the period. Brickwork was in progress at battery 4 through 1 on archways, collecting flue walls and floors. Refractory work on pits for batteries 5 and 6 is 70% complete. Remaining refractory work will be completed later when heat for dry out in the pits is available. Progress continued during the period on steel erection of pits for batteries 1, 2 and 3. Most of the structural floor framing is installed and bolt-up for the remaining pits is expected to complete in two weeks. Conduit installation for electrical power and lighting in the #4 through 6 battery area continued during the period. Most of the conduit work for battery 6 is completed. The coke oven and natural gas manifolds at batteries 5 and 6 are complete and 85% complete at battery 4. Cooling water for batteries 5 and 6 is 90% complete. Progress was continued throughout the period on all piping systems in the #4 through 6 battery area. Structural erection of the semi-gantry crane 366 was completed by KE forces during the period.

3.7 Piping: During the period, Delta Pipeline Contractors installed 80 feet of 1" underground piping near the east ingot buggy drive houses. Service piping in this area was not in progress during the period since Delta was requested to use their men for priority requirements in other areas. They are scheduled to resume process piping in the Soaking Pit on November 6.

3.8 Electrical: Foothill Electric installed 9,000 lbs. of exposed conduit during the period for a total to date of 51,500 lbs. or 67% complete.

4. 7128 - BASIC OXYGEN SHOP

4.1 Excavation and Backfill: 4,244 cubic yards of excavation was completed during the period for a total to date of 197,343 cubic yards. 7,910 cubic yards of backfill was made for a total to date of 236,914 cubic yards. Excavation during the period included the conveyor support foundations and period backfill was confined mainly to the area west of column line 17.

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4.2 Concrete: 122 cubic yards of concrete was placed for a total to date of 17,649 cubic yards. Concrete pours for the period consisted of grade beams on C-line, stack #2 foundation and the base slab for fan 1. Grouting was completed on the hot metal pit rails as well as some base plates on piers which are supported by piles.

4.3 Structural and Miscellaneous Steel: 368 tons of structural steel was erected at the B.O.F. Building for an overall total of 2,458 tons. Seven columns were erected this period along column line 19, 20 and 21. Girders and floor beams were also erected for one bay in the operating floor level between column line 20 and 21.

4.4 Roofing and Siding: 2,500 square feet of siding was installed at the Mold Preparation Building for a total to date of 39,920 square feet.

5. 7145 - STRIPPER BUILDING

5.3 Structural and Miscellaneous Steel: 41 tons of structural steel was erected for a total to date of 870 tons.

5.6 Mechanical: Erection of the Stripper Building overhead crane continued during the period and all major components were erected in place.

6. 7150, 7156 and 7159 - PICKLE AREA

6.1 Excavation and Backfill: Pile driving for the #2 catenary pit on pickle line 4 was completed this period. Backfill continued during the period for the pickle coil storage building from east to west. This backfill between J and H-line is now 40% complete and is proceeding in advance of structural steel erection of the building.

6.2 Concrete: 261 cubic yards of concrete was placed in the pickle line building for a total to date of 6,588 cubic yards. 172 cubic yards of concrete was placed in the pickle coil storage building for a total to date of 4,484 cubic yards. All concrete work in the pickle coil storage building is complete except for the west side piers and grade beams. Concrete work in the pickle line building consisted mainly of foundations for the #4 pickle line tank and the #5 pickle line [illegible] near column 30.

6.3 Structural and Miscellaneous Steel: 12 tons of structural steel was erected in the Green Coil Storage Building for a total to date of 2,861 tons. Closure of the south aisle was in progress after final erection of major components for crane 404. At the Pickle Coil Storage Building, eight roof trusses have been erected to date. All columns on H-line are in place and eight columns along J-line are erected.

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WEEKLY FIELD ACTIVITY REPORT
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6.4 Roofing and Siding: 4,400 square feet of siding was installed at the Green Coil Storage Building for a total to date of 30,586 square feet. Progress was continued on installation of roof ventilators at the Green Coil Storage Building.

6.6 Mechanical: The cab and hook for crane 404 at the Green Coil Storage Building arrived this period and erection is in progress. This completes all major equipment for the four Green Coil Storage overhead cranes.

6.7 Piping: Progress continued during the period by McGraw Construction Company on installation of the roof drains for the Green Coil Storage Building. These drains are 80% complete. All major columns for this building are grouted.

6.8 Electrical: In the Green Coil Storage Building, installation of cable tray along B-line is complete to column 7. High bay lighting feeder conduit in the Pickle Line Building is 40% complete. Electrical progress was continued during the period by Lake Erie Electric on overhead cranes. Crane 405 in the Pickle Line Area is 99% complete electrically.

7. UTILITIES

7109 - Pipeline: Delta Pipeline Contractors are presently engaged in the final testing of the coke oven gas line system. During the period, they also installed some additional concrete supports at various valve stations as required.

7110 - Power Distribution: R. H. Bouligny maintained progress on power distribution work in the Melt Area and the cold finish station. In the Melt Area switching station, embedded conduit was completed this period and the lighting standards erected. Stringing of conductors to the Melt Area station was continued during the period and is presently 60% complete. The underground electrical duct work between the Melt Area substation and the Basic Oxygen furnace control room was completed this period. Concrete work for manhole 3 was also completed. At the cold finish substation, wire terminations were completed during the period except [redacted] supervisory circuits. The station ground mat was meggered successfully this period.

7112 [redacted] and Site Development: 13,625 cubic yards of excavation was completed for a total to date of 677,360 cubic yards. 12,890 cubic yards of backfill was accomplished for a total to date of 914,122 cubic yards. 6 cubic yards of concrete was placed during the period for a total to date of 919 cubic yards. 1,598 linear feet of 8" corrugated metal pipe and 280 linear feet of 10" corrugated metal pipe was installed in the Steelmaking Area by Delta Pipeline Contractors during the period. Progress was also continued on forming and rebar for the manhole tops in the south area parking lot.

SWEEKLY FIELD ACTIVITY REPORT
Week Ending October 31, 1967

7113 - Trackwork: During the period, DHS Corporation laid 692 feet of flange way in the south area and 182 feet of flange way along the pig machine track. Two turnouts were installed to provide a detour east of the Weighing-In-Motion Scale Area. Construction of this scale pit is in progress.

7114 - Locker Rooms: At the south area locker room, progress continued by David L. Smith Construction Company on the overhead heating and ventilating system. The asbestos panel liners at the exterior walls and soffit angle supports are almost complete. Water piping, plumbing and lighting installation continued during the period. Suspended ceiling installation is scheduled for next period. In the Steelmaking Area, the sculptured paneling and Steelox wall panels were completed during the period. The building generally is closed in from the weather. No interior masonry work is evident yet.

7186 - Waste Disposal for the Pickle Line Facility: Progress continued during the period on forming and rebar setting for the base slab and walls in the tank farm area. Forming of walls and installation of rebar was also evident on the east half of the Waste Disposal Building foundations.

Prepared by: O. A. Finsand
O. A. Finsand

Approved by: for G. L. Roberts
Construction Manager

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