INTER-OFFICE MEMORANDUM

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AT

DATE December 5, 1967
FROM O. A. Finsand
O.A. Finsand
AT Middletown Construction
JOB NO. 7100

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SUBJECT Kaiser Engineers' Weekly Field Activity Report

Transmitted herewith is the subject report for the week ending December 5, 1967.

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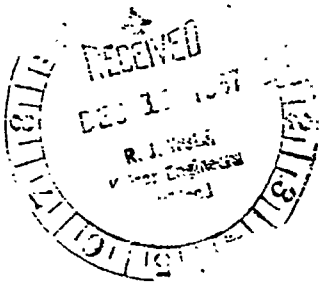

KAISER ENGINEERS
WEEKLY FIELD ACTIVITY REPORT
Week Ending December 5, 1967

WEATHER: Generally cold throughout the period with snow and rain in early part.

TEMPERATURE: Maximum - 45 degrees
Minimum - 20 degrees

CLIENT: Armco Steel Corporation

LOCATION: Middletown, Ohio

JOB NUMBER: 6471

JOB VISITORS

L. H. Misner

SUMMARY FORCE REPORT

	Kaiser Engineers Exempt	Kaiser Engineers Non-Exempt	Subcontractors	Foothill Electric	Total
Management	5	3		1	9
General Supervision	14	3	23	6	46
Field Engineering	48	21	11	16	96
Wareha. & Mtl. Control	4	7		1	12
Survey	2	16	4		22
Office Srv. & Repro.	1	6			7
Clerical			18	16	34
Craft*	—	1,203	1,178	724	3,105
TOTAL	74	1,259	1,234	764	3,331

* Average for week of men on payroll.

Average for week of Crafts is as follows:

Kaiser Engineers	1,107
Subcontractors	1,121
Foothill Electric	689
Total Crafts Working	2,917

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WEEKLY FIELD ACTIVITY REPORT
Week Ending December 5, 1967

PROJECT PROGRESS

1. 7148 - HOT STRIP MILL

1.2 Concrete: 27 cubic yards of concrete was placed during the period for a total to date of 210,693 cubic yards. Period concrete consisted of fill concrete for the rail track at the west end of the clarifier building.

1.3 Structural and Miscellaneous Steel: The miscellaneous ironwork force in the Hot Strip Mill was reduced from 50 ironworkers at the start of the period to 37 at the end of the period. In the furnace area, the 16" steam valve access platform in the boiler house 154 elevation was completed. Work continued on the water shield at furnace #1. The sump cover and support beams were installed in the steam trench at column C-2. In the rougher and finishing areas, work on safety requirements continued throughout the period. The spray hood for the descaling header was installed at rougher #1 and the steam hatch covers and handrail were installed at the accumulator at column D-30. Installation of checker plate continued in the piping trench in the finisher area motor room. Roll rig cover plates were reset in place at the finisher area. In the runout area, progress continued on the D line piping trench cover plates and grating was installed in the coil conveyor sump pits. Remaining ironwork in the Hot Strip Mill consists mainly of additional safety requirements and installation of hatch covers or grating to comply with mechanical progress.

1.4 Roofing and Siding: 1,550 square feet of roofing was placed on the skip hoist structure at scale pit #3 during the period. This completes the roofing on this structure.

1.5 Heating and Ventilating: Steam and air piping installation continued in bag houses 10, 12 and 14 during the period. In bag house 10, the air and steam piping is presently in progress and is scheduled for completion next period. In bag house 12, the air piping is complete and steam piping is scheduled for completion next period. In bag house 14, all piping is complete with the steam test scheduled for early next period. Installation of the heating units in the two Hot Strip Mill grease houses was completed by Norm Woolley during the period. The exhaust fans and power connection will be complete next period. In the switchgear house at the clarification area, the heating units are complete apart from connections to the steamline in the area.

1.6 Mechanical: During the period, Eichleay Corporation increased their work force to an average of 55 men on mechanical installation in the Hot Strip Mill. In the furnace area, the hold-down guides were

installed on extractor #2 and progress continued on the hold-down guide installation for unit #3. In the rougher area, the machining of the delivery side guides for the four-high mills continued during the period. In the finisher area, stators for all the main drive motors have now been returned to the job site. These motors are being installed and recoupled in their permanent position. Clean-up continued on the roll assembly and roll changes for installation and testing during the period. In the run-out area, 20 of the 31 runout table motors have been returned from the Westinghouse factory. These motors are presently being installed. Installation of the chain drives and downenders for the conveyor system continued during the period and the downender bases are scheduled for grouting next period. The redesign components for conveyor 6 are not yet on site. At scale pit #3, the mechanical installation of the wet scale drag system is virtually complete with several guards yet to be installed at the head end of the hoist. The #2 roll grinder in the roll shop has been tested. Delivery of the #3 roll grinder has not yet been made. Uncoupled tests were completed as follows: 5 mill water return pumps in pump pit #4. During the period, the following coupled tests were completed: 4 high pressure descale pumps (coupled to gear box only), 3 flume flushing pumps in scale pits 1 and 2, 4 high pressure mill water pumps in the clarifier pump house, #3 pusher (coupled to gear box only), 1 looper air compressor, 2 condensate recovery pumps in boiler house 3, 50 KW stand-by generators in boiler house 3, #1 turbine driven boiler feed pump in boiler house 3, #1 induced draft fan in boiler house 3, and 2 turbine driven furnace cooling tower water pumps at the clarifier pump house. The following equipment has been accepted and released to Armco for operation: roll grinder #2 in roll shop, crane 315 in roll shop, induced draft fan in boiler house 3, condensate recovery system in boiler house 3, #1 slab reheat furnace, #1 turbine driven boiler feed water pump in boiler house 3, #2 pressure reducing and desuperheating station in boiler house 3, Vanexial vent fan #1 west in boiler house 3, roofing vent fan #1 in boiler house 3, and Vanexial vent fan #1 east in boiler house 3. The P50 and P550 computer checks continued in the R2 and R6 test areas. Roughing mills #1 and 2 were run with rolls installed. The main motor room from column 13 to 33 has been closed off and is now restricted to certain personnel. Slab transfer cars #1, 2 and 3 are now ready to release to Armco together with cranes 301, 304, 306, 307, 310 and 311 including all slab handling equipment.

1.7 Piping: During the period, 2,601 feet of pipe was installed for a total to date of 333,438 feet. 5,933 feet remains to be installed by Kaiser forces in the Hot Strip Mill. Major systems worked on during the period were: grease systems, hydraulic system 18 and 19, furnace cooling water, high pressure descale water, mill low pressure water, oil skimmer system, plant air, steam, heating and ventilating and instrumentation. Hydro testing and flushing is complete on hydraulic system 18 between the suction headers and the top spray retractor cylinders for the runout tables. Installation of jumpers and vents in preparation of the hydro tests of hydraulic system 17 continued during the period. Preparation

for flushing the lube pipe for the #1 air compressor was initiated during the period and the lube console tank is being cleaned. Hot flushing of this system is presently in progress. The hydro test on the high pressure descale system has been completed. Check out is in progress on one pump in scale pit 1 and 2.

1.8 Electrical: Foothill Electric Corporation installed 14,000 lbs. of exposed conduit for a total to date of 1,438,000 lbs. or 95% complete. 42,000 feet of low voltage cable was installed for a total to date of 1,746,000 feet or 99% complete. 760 low voltage cable terminations were made for a total to date of 29,800 or 99% complete. 29,000 feet of control cable was installed for a total to date of 1,802,000 or 97% complete. 1,300 control cable terminations were made for a total to date of 53,900 or 93% complete. 21,000 feet of computer cable was installed for a total to date of 850,000 feet or 90% complete. 600 computer cable terminations were made for a total to date of 27,600 or 92% complete. 5,000 lbs. of lighting conduit and 8,200 feet of lighting wire was installed during the period. 500 lbs. of structure grounding was installed for a total to date of 138,800 lbs. or 98% complete. 5,700 feet of communications wiring was installed during the period. An average work force of 443 men was maintained during this period.

1.9 Miscellaneous Subcontracts: Walker service engineers have completed the installation of the weir plates and the filler plates at the clarifier.

Owens Corning Fiberglas Company continued throughout the period with installation of steam and lube oil systems in the Hot Strip Mill. They have now completed the 24" and 16" steamline leading to the boiler house. Insulation continued on roughers 1 through 6, the fuel oil pump house and the Ric-Wil pipeline to the pickle line.

Delta Pipeline Constructors maintained an average work force of 32 men on service piping in the Hot Strip Mill. During the period, 200 feet of service piping was installed for a total to date of 32,966 feet. 11 airline drops were installed along D and E lines this period. 80 linear feet of 6" well water line and 120 feet of 4" well water line were installed along E line during the period. Delta Pipeline are not able to test the fuel oil pipelines until the anchors outside the pump house and at the valve pits have been completed. On the steamline between the pump house and the Hot Strip Mill, Delta Pipeline is completing the steam expansion pit shrouds and is proceeding north along the 12" steamline.

McGraw Construction Company has completed the installation of monorails in the clarification building and continued with monorails installation in the Hot Strip Mill oil cellar. Work is presently at column 42 with completion scheduled for the end of next week.

WEEKLY FIELD ACTIVITY REPORT
Week Ending December 5, 1967

Salem-Brosius has completed dry-out of furnace #1 and from midnight on December 2, 1967 Armco operators took over the operation of the furnace on automatic control. Adjustment of the air-fuel ratio instrumentation is in progress. Refractory installation for furnace #3 roof and up-take area continued throughout the period. #1 boiler inlet flue refractories which were damaged by water on December 1, 1967 will be repaired by December 6. Installation of furnace #2 drains and burner trim piping continued during the week with gas system testing presently in progress. Problems were encountered on the #1 furnace discharge door operating mechanism and temporary motors have been installed pending the arrival of the heavier replacement motors. Insulation of #1 furnace piping is 92% complete. Painting continued on #1 and 2 furnaces with more of the work being performed on #2 furnace. Progress to date is as follows: furnace #1 is essentially complete; furnace #2, 89% complete and furnace #3, 79% complete for an overall furnace completion of 89% complete. A steam line rupture between #2 and 3 boiler house occurred on December 5, 1967 and this was repaired by the following day.

Babcock and Wilcox started the boil-out of boiler #1 on December 2 and this operation was completed on December 4. At the end of the period, the boiler was not yet cool enought for boil-out inspection and wash-down. The Hartford steam boiler inspector will be on site at the beginning of next period.

Mc Piping (Contractor for the Waste Heat Boiler 2½" and over piping) installed expansion loops in the steam tracing lines on the fuel oil supply and return headers and also installed lube oil piping on unit #2 FD and ID fan drives together with lube oil piping from the bearing. Spring hangers were installed on the steamlines to and from the drive turbines on the two emergency and make-up water pumps.

Norm Woolley (Contractor for the Waste Heat Boiler 2" and under piping) completed the pilot gas system testing on November 30, 1967. Piping progress for the period consisted of drain installation at the FD and ID fans and the boiler safety pans and elbows. The hangers for the pilot gas line were completed together with the steam trap assemblies. This contractor is 98% complete.

Minneapolis-Honeywell (Contractor for the Waste Heat Boiler Instrumentation) have now completed the testing of the stainless steel impulse lines for unit #1 which have been accepted. Calibration of instruments continued as required by the vendor's service engineer. Flow instruments from the 24" steam orifice plate area is virtually complete. This contract is 77% complete.

Babcock and Wilcox continued with insulation of unit #3 fans and ducts, lagging on #2 unit fans and ducts and installation of fan

housing for unit #3. The drive turbines for #3 ID and FD fans have been cleaned and flushed and #3 fan isolator installed. Work is scheduled to resume next period on unit #2 ventilating system duct installation below the 154 elevation floor. This fan and duct system contract is 92% complete.

2. 7146 - SLAB MILL

2.1 Excavation and Backfill: During the period, 410 cubic yards of backfill was placed for a total to date of 214,287 cubic yards.

2.2 Concrete: 133 cubic yards of concrete was placed for a total to date of 46,678 cubic yards. Concrete during the period consisted of the suspended mill aisle slab over the skip hoist drag scale.

2.3 Structural and Miscellaneous Steel: An average force of 27 men installed miscellaneous iron in the slab mill during the period. Installation of the stairway at the north end of scale pit #4 was 80% complete at the close of the period. Progress continued on protector plate for the crop pit. 12 tons of scale track beams at the crop conveyor were installed. The structural canopy at scale pit #4 was completed. All bag house fans were set in place during the period. The main mill motor-generator platforms were in progress throughout the period.

2.6 Mechanical: Eichleay Corporation maintained an average work force of 50 men throughout the period on mechanical installation in the slab mill. The manipulator drive bases have been returned from the factory and are presently being installed. The vertical mill right angle drive has been disassembled and internal components are being crated for shipment back to Mesta for modification. 59 tons of vertical mill rolls were received during the period for a new total to date of 7,352 tons or 96% complete. Major items grouted this period included front mill table #5 and the scarfer rolls.

2.7 Piping: Hunter (Contractor for the Slab Mill Piping) maintained an average work force of 61 men during the period. Progress continued during the period on installation of control air to lube oil systems 3, 6 and 7 in the oil cellar basement. Progress on hydraulic systems 1 and 2 continued with the installation of 2" and larger hydraulic piping and control air piping at the valve stands being worked on during the period. Mill low pressure water piping from the flume trench to tables 17 and 18 is presently being installed. At the slab mill proper, installation continued on the lube oil systems 6 and 7 at the tables. To date, 650 feet of 2" grease headers, 30 blocks and 130 points have been installed at the tables. Hunter is presently prefabricating pipe supports and pipe for the scale pit and the five scale pit pumps were set in place. 1,300 feet of piping was installed during the period for a total to date of 17,050 feet.

2.8 Electrical: 800 lbs. of exposed conduit was installed for a total to date of 69,500 lbs. or 43% complete. 9,200 lbs. of embedded conduit was installed for a total to date of 646,000 lbs. or 99% complete. 200 lbs. of conduit, 500 feet of wire and 40 fixtures were installed during the period. 700 lbs. of structure grounding was installed for a total to date of 22,000 lbs. or 44% complete. An average work force of 113 electricians worked during the period.

3. 7143 - SOAKING PITS

3.2 Concrete: 144 cubic yards of concrete was placed for a total to date of 28,723 cubic yards. Period concrete consisted mainly of the loading dock slabs between column 7.5 and 8.5, 10.5 and 11.5 and 13.5 and 14.5.

3.6 Mechanical: Loftus Engineering maintained an average work force of 160 men on battery installation in the soaking pit facility. Progress continued mainly on battery #6 including piping, electrical and pit component wall brick. Archway and collecting flue brickwork has been completed apart from downtakes for pits 1 through 13. Equipment installed includes: battery #1 recuperator, 1 pit damper, 1 cinder bell door cylinder, batteries #1, 2 and 3 transmitter stations, and 6 Bettis-Bailey pneumatic positioners. Work has been initiated on the platform along the ingot buggy track and also on walls for the electric motor room. At batteries #5 and 6, the equipment installation is 92% complete. Brickwork is 97% complete. The electrical work is 25% complete on battery #6 and 20% complete on battery #5. Piping completion at battery #6 is 82% complete; battery #5, 70% complete; and battery #4, 35% complete.

3.7 Piping: Delta Pipeline Constructors increased their forces to an average work force of 24 men on service piping in the soaking pits during the period. Erection of pipe supports above the mezzanine floor was completed. Five pipe supports were erected along E column for the furnace cooling water piping. The 8" bosh drain piping prefabrication is complete and erection will now start working westward from column Y 16.5. 585 feet of treated water piping has been installed to date, 120 feet of compressed air piping, 65 feet of grease piping installed and 70 feet of 10" natural gas piping installed for an overall total to date of 840 feet.

3.8 Electrical: 3,500 lbs. of exposed conduit was installed for a total to date of 40,000 lbs. or 29% complete. An average work force of 33 men was maintained during the period.

WEEKLY FIELD ACTIVITY REPORT
Week Ending December 5, 1967

4. 7128 - BASIC OXYGEN SHOP AND MOLD YARD

4.1 Excavation and Backfill: 254 cubic yards of backfill was completed during the period for a total to date of 243,654 cubic yards.

4.2 Concrete: 130 cubic yards of concrete was placed for a total to date of 18,955 cubic yards. Period concrete consisted mainly of: fan #1 walls and foundations, track hopper walls, conveyor support piers, scrap scale pit #1 and 2 base slabs and grade beams at the loading dock.

4.3 Structural and Miscellaneous Steel: 407 tons of structural steel was erected at the main B.O.F. building for an overall total to date of 3,932 tons. (This total to date includes the Mold Yard.) At the main B.O.F. building, 1,890 tons of structural steel excluding anchor bolts and base plates has been installed to date. Three erection rigs erected steel on the main B.O.F. Building throughout the period. Four erection rigs are anticipated in the near future. Erection of the office and lab building was completed this period with the exception of the walkway enclosure. C.B. and I. have completed the erection and welding of the bottom half of the nitrogen sphere and progress is continuing on the upper sections.

4.4 Roofing and Siding: 720 square feet of Steelox siding was installed at the Mold Preparation Building for a total to date of 61,640 square feet. 7,490 square feet of red siding was installed along the west side of the Mold Yard Building for a total to date of 8,050 square ft.

4.6 Mechanical: Five additional car loads of crane equipment arrived at the job site this period for the mold yard cranes. The girders and trucks are on site and delivery of the trolleys is expected by next period. Erection of these cranes is scheduled to begin the latter part of next week.

5. 7145 - STRIPPER BUILDING

5.3 Structural and Miscellaneous Steel: Bolt-up of remaining roofing purlins and west side girts was completed this period. Structural erection of this building is essentially completed.

5.4 Roofing and Siding: 8,460 square feet of roofing was installed for a total to date of 18,800 square feet.

5.8 Electrical: Progress was initiated on electrical grounding for the rectifier building and installation of subslab conduit at the rectifier enclosure.

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6. 7150, 7156 and 7159 - PICKLE AREA

6.1 Excavation and Backfill: 188 cubic yards of backfill was accomplished near column 34 in preparation for the stripper dryer foundations.

6.2 Concrete: 699 cubic yards of concrete was placed in the pickle line 4 facility for a total to date of 8,164 cubic yards. 171 cubic yards of concrete was placed in pickle line 5 facility for a total to date of 5,567 cubic yards. At pickle line 4, the #1 and 2 pay [illegible]reel base slab was completed and forming of walls is now in progress. [illegible] base slab for the #2 catenary pit was also poured during the period. The #5 pickle line tank foundations between column 23 and 24 was placed this period. Foundation progress in this area is presently keeping pace with released design information.

6.4 Roofing and Siding: 1,680 square feet of painted siding was installed at the pickle line building for a total to date of 10,510 square feet. Progress continued throughout the period on roof ventilators for the Green Coil Storage facility. Ventilator framing is 80% complete and ventilator sheeting 15% complete.

6.6 Mechanical: Erection of the east end overhead crane at the pickle coil storage building continued throughout the period with girders and trolley now in place. Erection of the west side crane is scheduled to begin next period.

6.7 Piping: McGraw Construction Company continued throughout the period with installation of overhead and underground piping for the Pickle Building roof drain system. The roof drainage system at the Green Coil Storage Building is essentially complete.

6.8 Electrical: At the Green Coil Storage facility, progress continued by Lake Erie Electric on the horizontal cable tray along column line C for the overhead cranes. This cable tray is 75% complete. In the Pickle Line Building, the 13.8 KV switchgear and the 2.4 KV circuit breaker have been set in place in the #4 motor room. Installation of high-bay lighting for this building is 30% complete. Completion of electrical gear installation required for overhead crane operations and conveyor operations at the Green Coil Storage facility is dependent on the availability of crane time at the Hot Strip Mill motor room. These items have been stored in the motor room and are presently being loaded and hauled to the Pickle Line Building for permanent installation.

7. UTILITIES

7105 - Water Distribution: Delta Pipeline Constructors continued with installation of underground plant air, natural gas, and oxygen piping between the Hot Strip Mill and the Green Coil Storage Building.

During the period, 160 feet of plant air, 160 feet of natural gas and 200 feet of oxygen piping was installed in this area. 280 feet of furnace cooling water and 200 feet of well water was installed near valve pit #1 this period.

7109 - Pipeline: Delta Pipeline Constructors have requested final inspection of the underground hydrogen, nitrogen and coke oven gas pipelines which are now considered complete and ready for operations.

7110 - Power Distribution: At the main substation, two additional cubicles have been installed this period on the 13.8 KV switchgear. Cable terminations for #14 unit was also complete this period. At the cold finish substation, the present plan is to energize the station on or before December 25, 1967. General Electric will install the 48 volt coils on the outside circuit breaker next period. They plan to complete their testing and adjustments during this time. Adequate design information was finally received on December 7 to enable completion of tele-communications for this substation. At the melt area substation, stringing of the remaining overhead lines was in progress and is scheduled to complete by December 9.

7111 - Sanitary Sewers: In the Steelmaking Area, Delta Pipeline Constructors installed 80 feet of underground cast iron pipe in the locker building vicinity. Progress is also continued on manhole installations related to the B.O.F. laboratory and office building, mainly manholes 579 through 582 and manhole 594. 817 cubic yards of excavation was accomplished for a total to date of 39,477 cubic yards.

7112 - Drainage and Site Development: 8,296 cubic yards of excavation was completed for a total to date of 704,196 cubic yards. 6,431 cubic yards of backfill was completed for a total to date of 959,128 cubic yards. Delta Pipeline Constructors completed installation of manholes 266 through 271 and three inlets in the south area parking lot vicinity. No progress was experienced by John R. Jurgensen on road paving during this period.

7113 - Trackwork: During the period, DHS Corporation installed 608 feet of track laid into the Green Coil Storage Building and 800 feet of track south of scale pits #1 and 2. The total track installed to date is 88,511 feet. Installation of ballast and sub-ballast was also in progress for the above trackwork during the period. 788 cubic yards of backfill was completed for a total to date of 75,093 cubic yards.

7114 - Locker Rooms: David L. Smith Construction Company continued with the installation of ventilation ducts in the south area locker room. The ventilation system for this locker room is essentially completed. The final coat of plaster was applied during the period in the toilet, shower, washroom and office area. Installation of the

lighting fixtures and accoustical ceiling is underway. Progress continued throughout the period on interior painting of this locker room as well. This facility is scheduled to complete the week of December 17. At the Steelmaking Area, the interior masonry walls are complete for the locker room facility. Installation of locker bases was initiated and progress was continued throughout the period on piping and electrical conduit installation.

7186 - Waste Disposal for the Pickle Facility: 128 cubic yards of excavation was accomplished for a total to date of 83,481 cubic yards. 112 cubic yards of backfill was completed for a total to date of 80,049 cubic yards. 525 cubic yards of concrete was placed during the period for a total to date of 744 cubic yards. The period concrete consisted mainly of base slab for the tank farm as well as remaining building column footers. Installation of the outlet pipeline to the lagoon was 50% complete at the close of this period. Completion of the waste disposal building floor slab is contingent on the availability of electrical drawings in order that embedded conduit can be installed as required. Progress in this area is presently keeping pace with released design information.

OAF/sec

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Approved by
G. L. Roberts
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