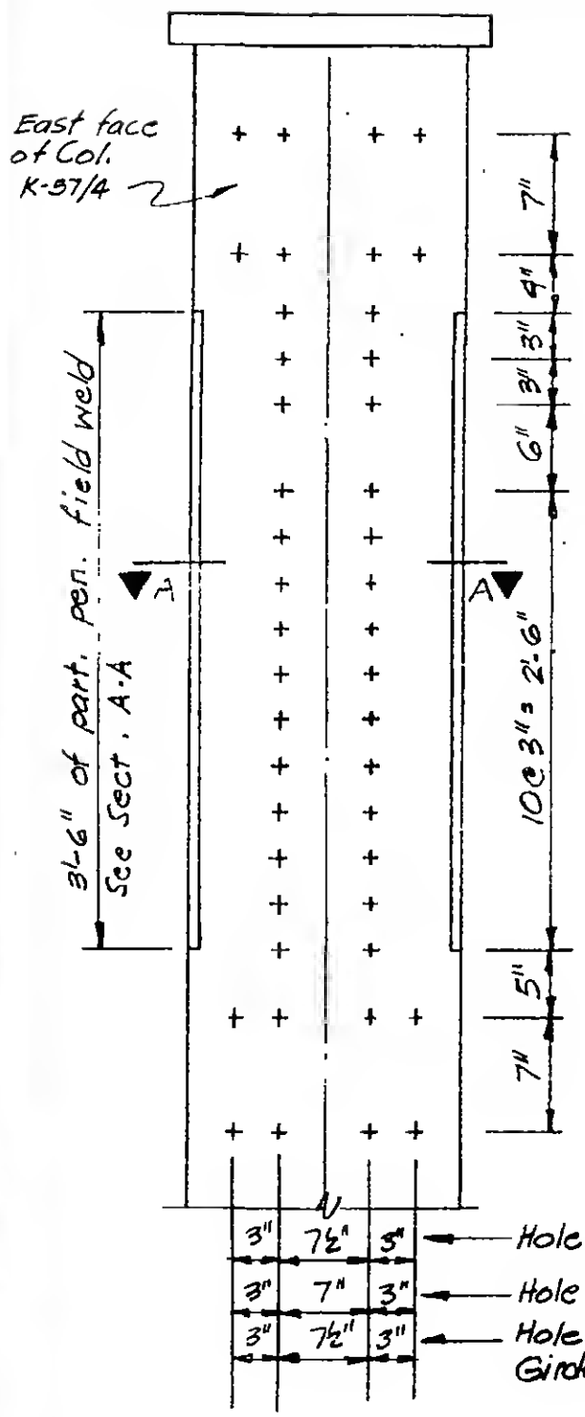
SKILLING, HELLE, CHRISTIANSEN, ROBERTSON — Structural & Civil Engineers

PROJECT: THE WORLD TRADE CENTER | TITLE: EL. 332, ZONE K-5, REPAIR AT E. FACE OF COL. (K-57/4) | DATE: 1-9-74

REVISIONS



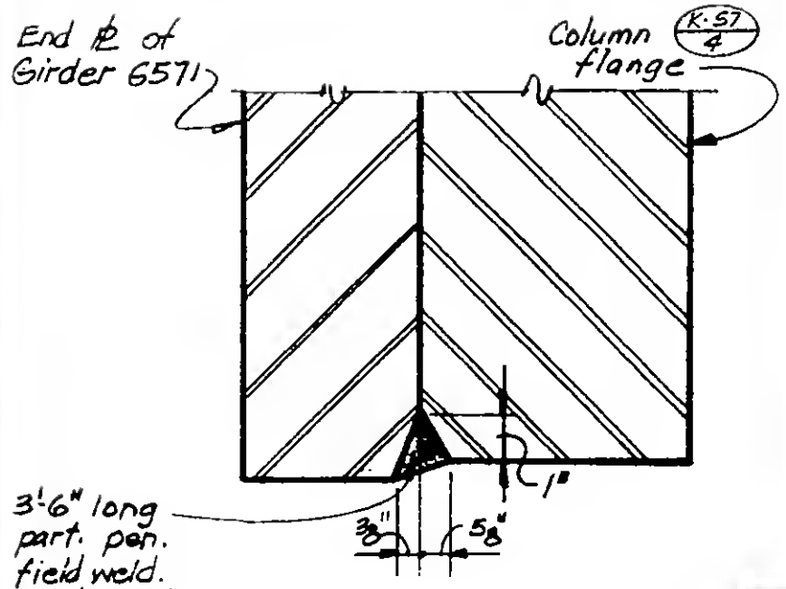
3" 7½" 3" ← Hole spacing as detailed Col. K-57/4

3" 7" 3" ← Hole spacing as fabricated Col. K-57/4

3" 7½" 3" ← Hole spacing as detailed and fabricated - Girder G571

Procedure for repair of non-matching gauge distances, West end of ℄ girder (G571) to east flange of column (K-57/4)

1. Install ⅞" drift pins to position center-line of girder to align with center-line of column
2. Chase ream holes to 1⅛".
3. Install all bolts (use A490F in lieu of A490-X) using one only XH9 washer under bolt head and nut and tighten.
4. Preheat to 300° minimum temperature areas shown on this drawing (i.e. areas to be welded with partial penetration weld.)
5. Using arc-air gouge, remove metal to depth and configuration as shown on this drawing. IMPORTANT NOTE - CARE MUST BE TAKEN TO ASSURE THAT BEVEL IS TO DEPTH SHOWN AND NO GREATER.
6. Maintain preheat and interpass temperature at 225° minimum and weld using E70 XX low hydrogen electrodes.
7. Weld on each side of the joint should be made prior to completion of days work.
8. Care must be taken to allow for slow cooling of weld metal (i.e. cover with asbestos blanket, etc.)



LICENSED PROFESSIONAL ENGINEER — LESLIE E. ROBERTSON — No. 34360 — UNIVERSITY OF THE STATE OF NEW YORK

DESIGNED AR

DRAWN

REVIEWED JTM

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19-K-1082