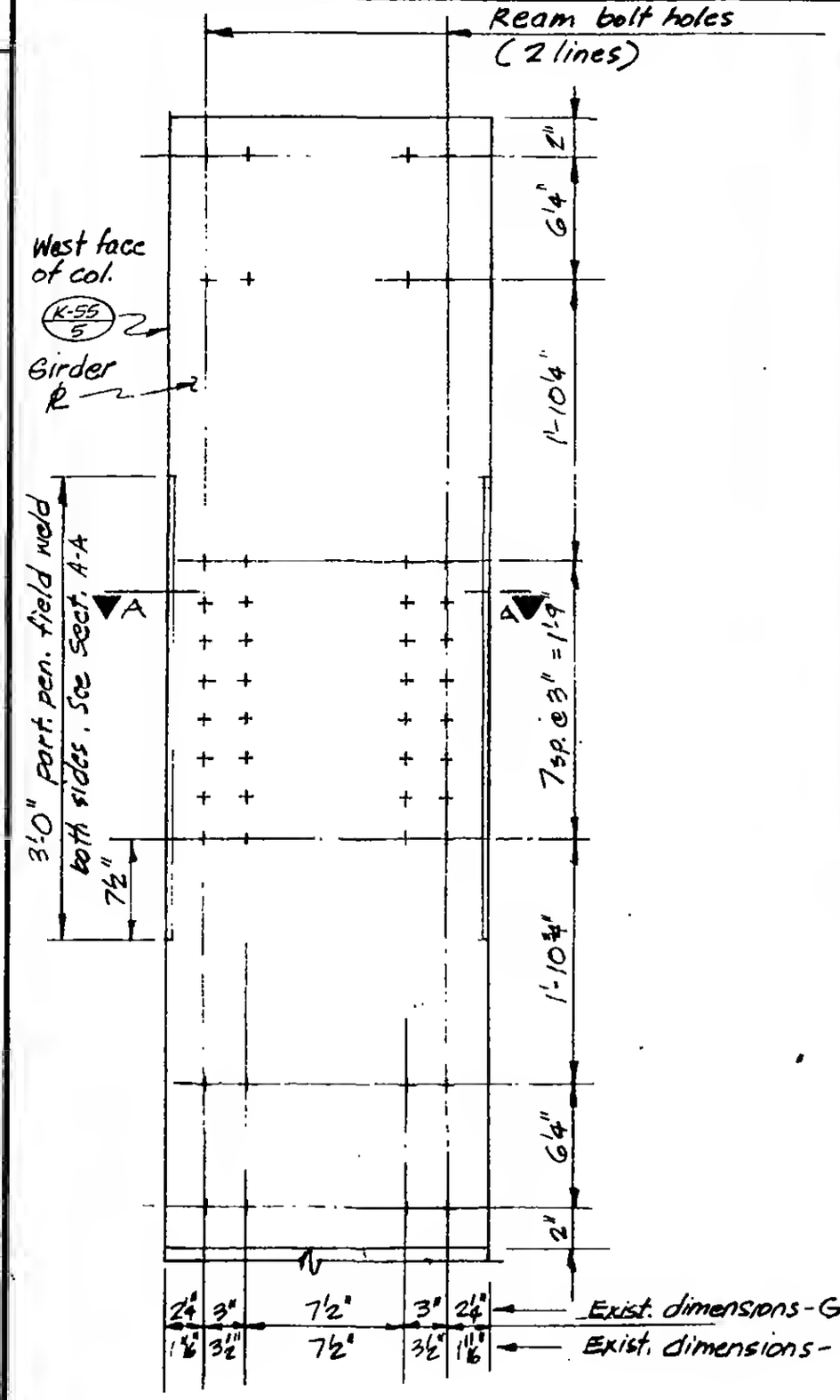
SKILLING, HELLE, CHRISTIANSEN, ROBERTSON — Structural & Civil Engineers

PROJECT: THE WORLD TRADE CENTER

TITLE: EL. 332, ZONE K-5, REPAIR AT WEST FACE OF COL. (K-55/5)

DATE: 1-9-74

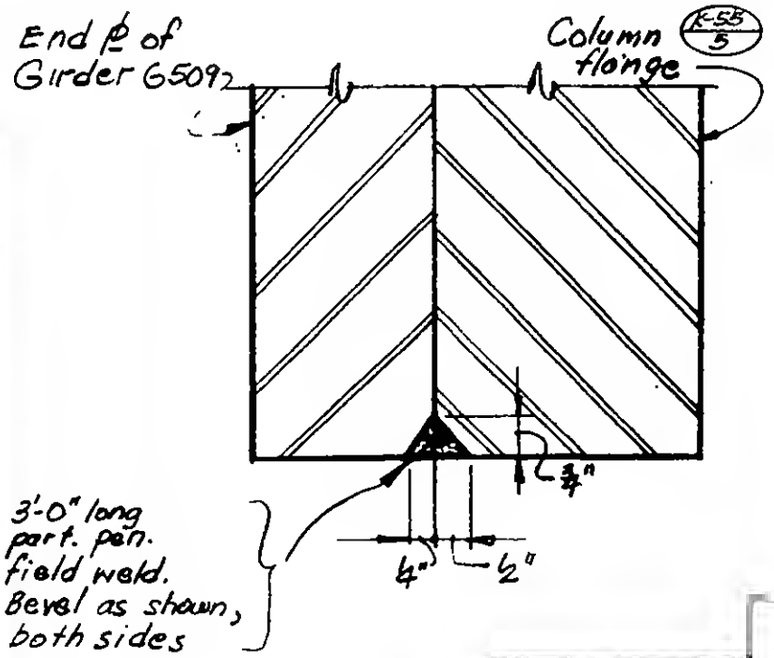
REVISIONS



Refer to 13-K2.4-14C for details not shown on this sheet.

Procedure for repair of non-matching gauge distances, East end of ℄ girder (G509) to west flange of column (K-55/5)

1. Install A-490-X bolts in all "fair" holes (i.e. install all bolts that will "make"). Tighten bolts.
2. Chase ream remaing holes to 1'8".
3. Install all remaining bolts (in reamed holes) using A490F in lieu of A490-X & one 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 field 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. 34960 — UNIVERSITY OF THE STATE OF NEW YORK

DESIGNED AK

DRAWN

REVIEWED JTM

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19-K-1083