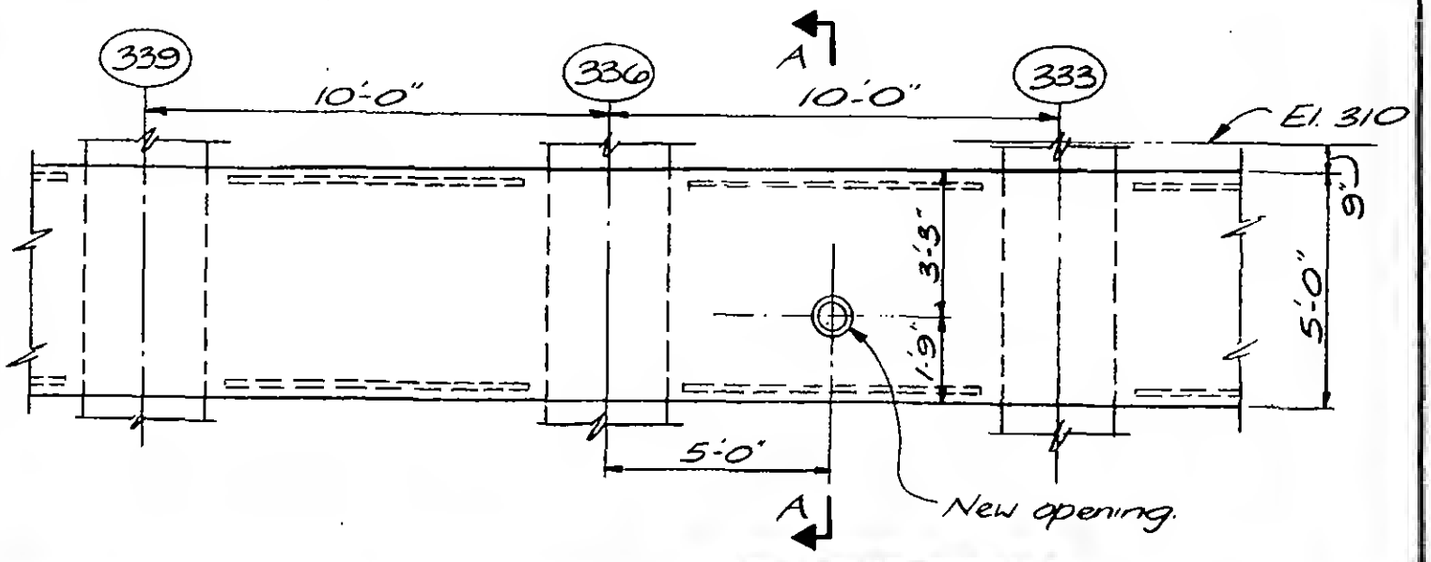
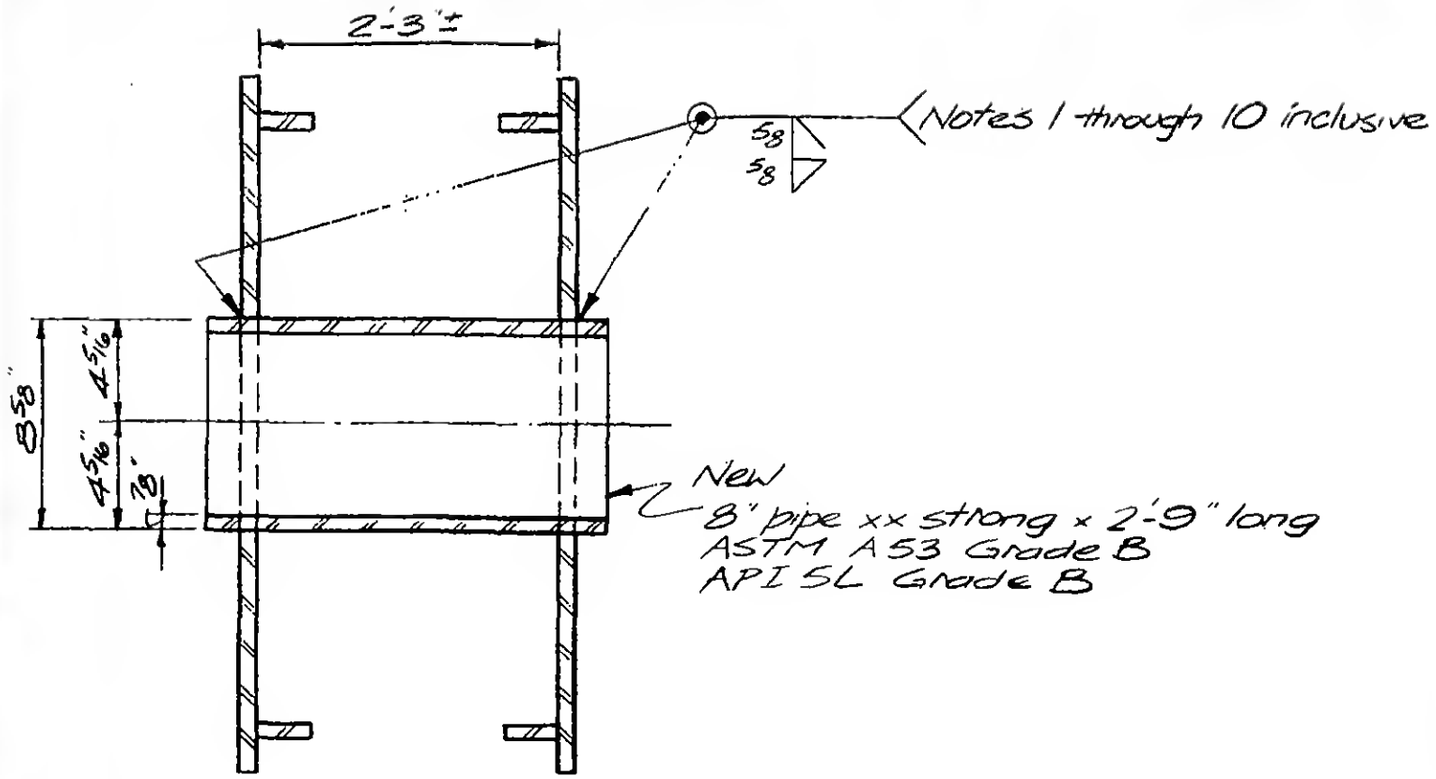
SKILLING, HELLE, CHRISTIANSEN, ROBERTSON — Structural & Civil Engineers

PROJECT: THE WORLD TRADE CENTER | TITLE: FIELD REPAIR EL. 310 SPANDREL TOWER A | DATE: 9-4-75

REVISIONS



ELEVATION



1. Scribe circular cut guide line on face of each spandrel using compass, circular guide line to have a diameter of 8-7/8 inches.
2. Carefully gas burn with oxy-acetelyne torch each hole making sure to provide a smooth, notch-free cut as close as possible to (but always *inside*) the cut line.
3. Repair with E7018 weld metal all notches or excessive serrations, then grind smooth.
4. Insert 8"XXS pipe, center in holes, and tack weld in place.
5. Arcair gouge 5/8 inch deep by 40 to 50 degree bevel into spandrel base metal top 1/2 (180°) of pipe, one spandrel. Take care not to gouge pipe.
6. Preheat and fill weld groove with E7018 weld metal with sufficient weave or stringer bead passes to bring weld metal flush with spandrel face.
7. Repeat 5 and 6 for second spandrel.
8. Perform 5 and 6 for bottom half of pipe, each spandrel. Make sure "bottom half" weld ends are thoroughly fused without void, slag pocker, cracking or cold lap to "top half" weld ends.
9. Perform fillet weld all around each spandrel.
10. UT

LICENSED PROFESSIONAL ENGINEER — LESLIE E. ROBERTSON — NO. 34960 — UNIVERSITY OF THE STATE OF NEW YORK

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