

				PARTS LIST	
PART NO.	SUB PART NO.	NO. REQ'D	DESCRIPTION	MATERIAL	
3101	A	2	DISC WELDMENT		
"	A	1752	WELD ROD	CARBON 37-L	
3101	AA	2	2 3/4" Φ x 2 1/2" DISK HUB 285° CON R	ASTM A-221-37-L RHS824, GR. B	
"	AB	2	2 3/4" Φ x 2 1/2" DISK HUB	"	
"	AC	4	2 3/4" Φ x 4 1/8" x 7'-6" CUTTING SHEET N°2	"	
"	AD	4	2 3/4" Φ x 3 3/4" x 3'-3 3/4" "	"	
"	AE	2	2 3/4" Φ x 52 1/2" x 3'-6 1/4" "	"	
"	AF	8	2 3/4" Φ x 26" x 3'-10" "	"	
"	AG	8	2 3/4" Φ x 37 1/2" x 5'-5" "	"	
"	AH	4	2 3/4" Φ x 41" x 5'-10" CUTTING SHEET N°2	"	
"	AJ	4	1/2" x 1 1/4" x 23'-6 1/8" FLAT BAR	AISI 10-100S-60	
"	AK	8	1/2" x 1" x 5'-0" FLAT BAR	"	
"	AL	8	1/2" x 1" x 7'-6" FLAT BAR	"	
"	AM	8	1/2" x 1" x 6'-0" FLAT BAR	"	
"	AN	16	1/2" x 1" x 5'-0" FLAT BAR	"	
"	AP	16	1/2" x 1" x 3'-3" FLAT BAR	"	
"	AQ	12	1/2" x 1" x 2'-7" FLAT BAR	"	
"	AR	4	1/2" x 1" x 13" FLAT BAR	"	
3201	4		DISC HUB "CASTING"	5233-5200	
3102	4		1" COUNTERSUNK Pipe Plug	BRASS	

* SPLICING PERMITTED TO OBTAIN LENGTH.

GENERAL NOTES

- 1) ALL DISC WELDS SHALL BE MAGNAFLUXED FOR FULL PENETRATION WELDS, MAGNAFLUX ROOT PASS AND EACH 3/8" THICKNESS OF DEPOSITED METAL INCLUDING FINISH PASS, FOR FILLET WELDS, MAGNAFLUX FINISH PASS ONLY.
- 2) CLEAN WELDS WITH SLAGGING GUN AND GRINDING AS REQ'D TO REMOVE ALL SLAG AND SPATTER.
- 3) PRE HEAT TO 150°F WHEN PLUG WELDING DISC PLATES TO RIBS
- 4) PRE HEAT CASTINGS TO 150°F WHEN WELDING ATTACHMENTS

INSPECTION: BY CORPS OF ENGINEERS & WISCO
CLEANING: NONE EXCEPT PER NOTE 2
PAINTING: PER DWG. 5233-1000 & 5233-1100

WELD PROCEDURE: WISCO WELD PROC. NOS. A-3385
STRESS RELIEVE: PER ASME VIII, PAR. UW-40
TESTING: AT ASS'Y PER DWG. 5232-1000

LUBRICATION: NONE
TOLERANCES: SHOP STANDARD UNLESS OTHERWISE NOTED

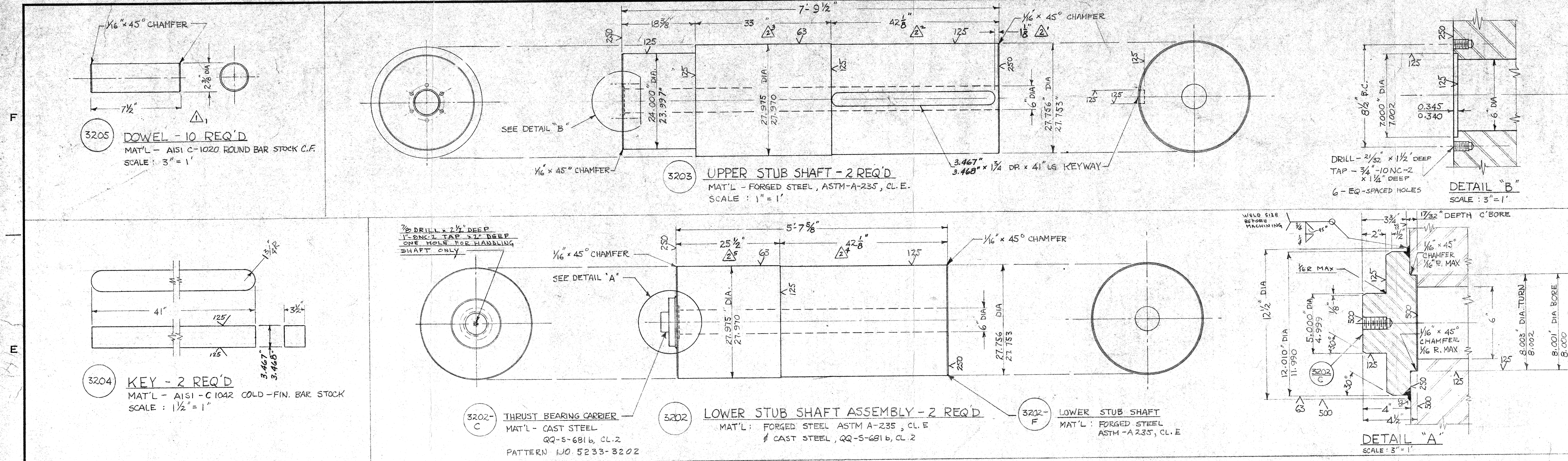
CUSTOMER'S APPROVAL _____

FINAL RECORD

JAN 14 1960

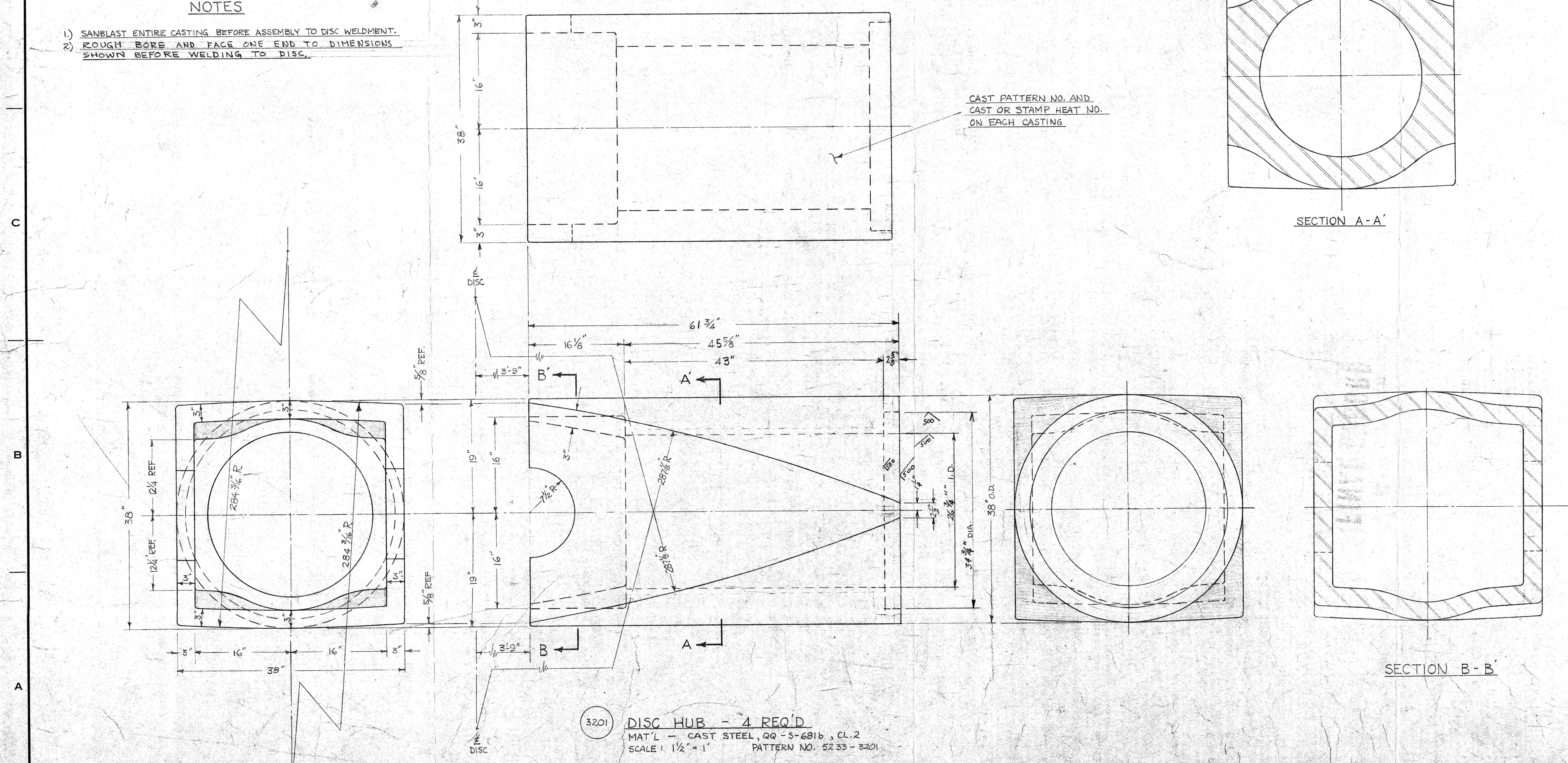
REFERENCE DRAWINGS
5233 - 3000

△5	REPL	REPLACEMENT LENGTH BETWEEN	FEW	7/7/59
△6	E.G.	HUB TO FACILITATOR MACHINING		
△7	REPL	1,205-1200 WAS 1,255 700 000		7/7/59
△8	E.G.	Replaced Drain Holes & Fails Drain	FEW	7/7/59
△9	REPL	REPLACED 5/16" DIA. 5/16" DIA. 7/16"		
△10	REPL	REMOVED 1/2" W. LETTER 5/10/59	FEW	7/7/59
△11	E.G.	REMOVED 1/2" DIA. HOLE		
△12	REPL	REMOVED 1/2" W. LETTER 1/10/59	FEW	7/7/59
△13	REPL	1/2" BBR WAS 1/2"		
△14		MAJOR WELDING REVISION	R.D.	7/20/59 FEW
MARK	ZONE	REVISIONS	BY	DATE REF.
FOR CONTRACT				
DA-32-015 C1ENG-59-113				
TITLE				
FORTY BECK DAM				
18" 0" BUTTERFLY VALVE				
DISC WELDMENT DETAILS				
WILLAMETTE IRON AND STEEL COMPANY				
2800 N. W. FRONT AVENUE				
PORTLAND 10, OREGON				
DR	FEW	SCALE AS NOTED 1"=1'	DATE ISSUED	JAN 5 1960
TR		DATE 7-4 1958	FILE NO.	40753
CH	KN	APP'D FEW		
SALES ORDER	NO.	COMPONENT	WEIGHT	OF REV.
50-5233		3100		06



NOTES

- 1) SANBLAST ENTIRE CASTING BEFORE ASSEMBLY TO DISC WELDMENT.
- 2) ROUGH BORE AND FACE ONE END TO DIMENSIONS SHOWN BEFORE WELDING TO DISC.



PARTS LIST				
PART NO.	SUB PART NO.	NO. REQ'D	DESCRIPTION	MATERIAL
5231	4		DISC HUB "CASTING"	QQ-S-681b
"	P 1		PATTERN N° 5233-3201	WOOD
5202	2		LOWER STUB SHAFT ASSEMBLY	
"	A 2*		WELD ROD	CARBON STL
"	C 2		THRUST BEARING CARRIER "CASTING"	QQ-S-681b CL.2
"	F 2		PIERCED TO FIN. 28" O.D. x 7'-9 1/2"	FORGED STL
"	P 1		PATTERN N° 5233-3202	WOOD
5208	2		PIERCED TO FIN. 28" O.D. x 5'-7 1/2"	FORGED STL
5204	2		3/4" KEY STOCK x 42" LG	C.F. STEEL
5205	10		2 1/2" BAR x 9' LG	C.F. STEEL

INSPECTION: BY CORPS OF ENGINEERS & WISCO
CLEANING: NONE EXCEPT AS NOTED
PAINTING: PER DWG. 5233-1000 & 5233-1100

WELD PROCEDURE: WISCO WELD PROC. #
STRESS RELIEVE: CASTING H.T. BY FOUNDRY
TESTING: AT ASBY. PER DWG. 5233-1000

LUBRICATION: NONE
TOLERANCES: SHOP STANDARD UNLESS OTHERWISE NOTED

CUSTOMER'S APPROVAL

FINAL RECORD

JAN 14 1960

REFERENCE DRAWINGS
5233-3000 & 5233-3100

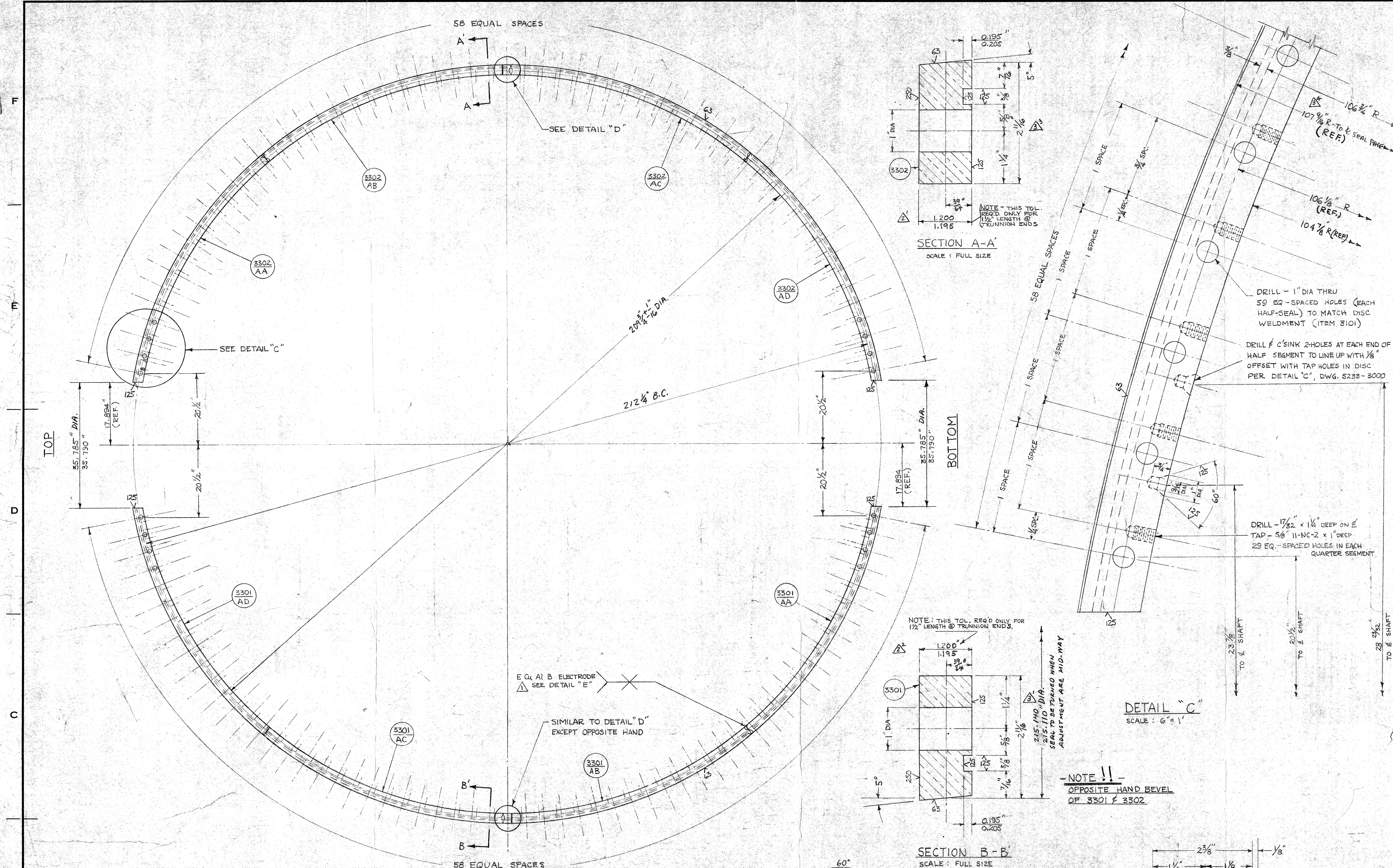
25	F3 R-4	REVISED TO SUIT DISC	FEW	7/17/59
23	E3 E-4	REVISED PER 1/2 LETTER DATED 12/4/58	RLB	12/19/58
1	CH	REVISED PER 1/2 LETTER DATED 12/4/58	FEW	
MARK	ZONE	REVISIONS	BY	DATE

FOR CONTRACT
DA-32-015-CNENG-59-113

TITLE
FORT PECK DAM
18'-0" BUTTERFLY VALVE
DISC MISC. DETAILS

WILLAMETTE IRON AND STEEL COMPANY
2800 N. W. FRONT AVENUE
PORTLAND 10, OREGON

DR. RLD	SCALES NOTED - 1" = 1"	DATE ISSUED	JAN 5 1960
TR.	DATE SEP 5 1958	FILE NO.	H- 4076
CH. RLB	APPROV. FEW		
SALES ORDER	NO.	COMPONENT	QUANTITY
SO- 5233	3200		02



PARTS LIST				
PART NO.	SUP. PART NO.	NO. REQ'D	DESCRIPTION	MATERIAL
3301	AA	2	DISC SEAL - 1/2 x 3/2 BAR x 8'-0"	BRONZE
3302	AB	2	" " " " " " " "	"
3302	AC	2	" " " " " " " "	"
3302	AD	2	" " " " " " " "	"
3302	AA	2	" " " " " " " "	"
3302	AB	2	" " " " " " " "	"
3302	AC	2	" " " " " " " "	"
3302	AD	2	" " " " " " " "	"
3303	12	END SEAL		NEOPRENE 40/50 DUKOMETER
3304	6	JOINT SEAL		RUBBER
3305	16	1" HEX BAR x 3' LONG		S. S. L.

* INCLUDES ONE SPARE SET

INSPECTION: BY CORP. OF ENGINEERS & WISCO
 CLEANING: NONE
 PAINTING: PER DWG. 5233-1000 & 5233-1100
 WELD PROCEDURE: NONE
 STRESS RELIEF: NONE
 TESTING: AT ASBY PER DWG. 5233-1000
 LUBRICATION: NONE
 TOLERANCES: SHOP STANDARD, UNLESS OTHERWISE NOTED
 CUSTOMER'S APPROVAL

FINAL RECORD
 JAN 14 1960

REFERENCE DRAWINGS 5233-3000

DA-32-015-CIVENG-59-113

TITLE
 FORT PECK DAM
 18'-0" BUTTERFLY VALVE
 DISC SEAL DETAILS

WILLAMETTE IRON AND STEEL COMPANY
 2800 N. W. FRONT AVENUE
 PORTLAND 10, OREGON

DATE ISSUED JAN 6 1960
 FILE NO. H-4077
 DATE SEPT 10 1959
 APPR. FEW
 SALES ORDER NO. COMPONENT SHEET OF REV
 SO-5233 3300 03

