

Acme Coke
11236 S. Torrence Ave.
Chicago IL 60617



acmecoke.com

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United Refractory Repair Proposal
Dated: 2000

Recovered from site on March 6 2021



EDWARD ESPOSITO
Chairman of the Board

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PAUL ESPOSITO
President

March 31, 2000

Mr. Jack Garzella
Manager Coke Plant
Acme Steel Company
11236 South Torrence Avenue
Chicago, Illinois 60617-6440

Dear Mr. Garzella:

At the request of Mr. Al Irvine, I would like to up-date our proposal to seal three oven chambers.

PROPOSAL:

The leakage is best stopped when sealed at the initial leak point. Ovens should be left empty for a period of time (24 hours minimum) to allow de-carbonization. The joint between the roof block and the wall should be ceramic welded. Pressurizing the flue chambers and visually locating the flames leaking into the oven chamber should identify all open joints across the oven. These joints should then be welded. Charging holes should be inspected and welded with fireclay weld powder. After all open joints and cracks are welded; the oven should then be grouted. This is accomplished by drilling through the top course (paving) mortar joints of the walls to a depth of approximately 18". Pipefittings are placed into the holes and grout is pumped under high pressure into the holes and back fills from the roof block-wall joint to the top course. Our product Super Grout 85 is used to perform the grouting procedure.

Ovens should then be patched on the end flues with trowel patching material and jamb spray, then pressure dusted to seal the remaining leaks that were too small for welding.

This proposal can be achieved only on a time and material basis due to the unknown extent of leakage per oven.

United Refractories, Inc.

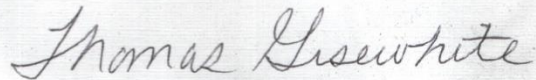
Any rental equipment is billed at our cost plus 10 percent.

There is a \$100.00 per day for out of town Superintendent.

Trailer delivery and pick up is billed at cost.
These prices are effective until May 31, 2000.

If you have any questions regarding this proposal please call Mr. Al Irvine or myself at your earliest convenience.

Sincerely yours,



Thomas Gisewhite,
Ceramic Welding and
Coke Oven Refractory Sales

Cc: Al Irvine

TG/pb

United Refractories, Inc.

Our hourly rates are as follows:

	Regular	Overtime	Double-time
Foreman	\$59.71	\$85.93	\$111.84
Bricklayer	\$57.87	\$83.04	\$108.22
Laborer	\$48.19	\$69.15	\$90.12
Superintendent	\$65.00	\$97.50	\$130.00
Shower Trailer (OSHA Required)			\$120.00 Per Day
Ceramic Weld Powder (Silica or Fireclay)	F.O.B. Warren, Ohio		\$3.10 Per Pound
Super Grout 85	F.O.B. Warren, Ohio		\$9.40 Per Gallon
United CO Dust	F.O.B. Warren, Ohio		\$465.00 Per Ton
Jamb Coat P	F.O.B. Warren, Ohio		\$500.00 Per Ton
Jamb Patch P	F.O.B. Warren, Ohio		\$520.00 Per Ton

Acme is asked to supply the following:

- Oxygen – 150 PSI Minimum
- Compress Air – 85 PSI Minimum
- Ceramic Blanket and Adhesive
- Scaffold or Manlift
- All necessary connections for trailers