

Fabrication Procedure at Lichtenwald-Johnston Iron Works Co.

1. Design drawings are obtained from the customer.
2. Shop details are prepared according to AISC standards and sent to the architect for his approval.
3. While the details are being approved, steel is purchased as per detailers advanced cutting list.
4. Once the approval process is complete, the details would be put into the shop for fabrication, at the same time the steel that was purchased would be arriving at our shop, where it would be checked in against its purchase order.
5. The steel that is to be used for the job would have test reports certifying that it meets or exceeds A36 or whatever specifications may be required for the job.
6. Shop details are first given to the shop superintendent from whom cutting lists are prepared in order to indicate which steel is to be used for each particular member. Templates at the same time are prepared to help facilitate the fabrication process, primarily with the pieces that have to be either drilled or punched.
7. Steel after being received and cut to size is then laid out using the details. At the same time that the main steel members are being laid out, there are smaller pieces being cut up and prepared that eventually will be attached to those members. This detail material is what is used to fit the main members up with.
8. After the fit up is complete, the steel is welded by certified welders as per AWS welding procedures and as per AWS symbols as shown on the approved shop details.
9. Completed steel is checked by a quality control supervisor before entering the paint area. This is to ensure that mistakes are minimal. In the paint bay the steel is thoroughly cleaned and painted as per job requirements.
10. After all of the above is completed the steel is loaded in proper sequence for delivery and installation by the field erector.