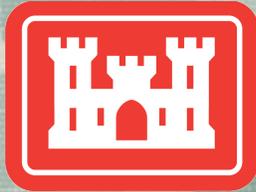


# LD 14 Roller Gate Repair

11 February 2015

Aaron D. Dunlop, P.E.

Chief, Maintenance Section



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US Army Corps of Engineers  
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# 13 July 2014 #1 Roller Gate



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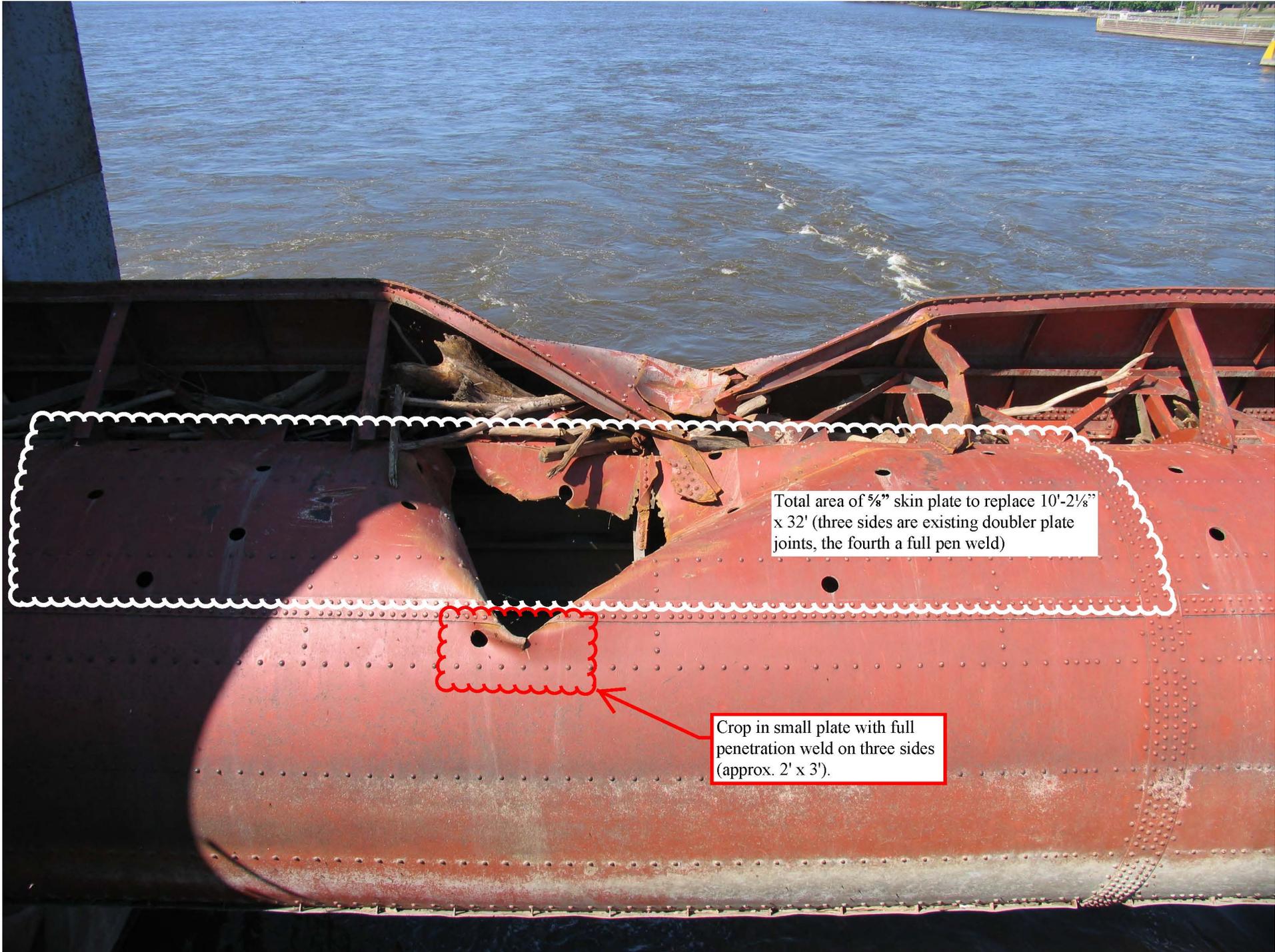






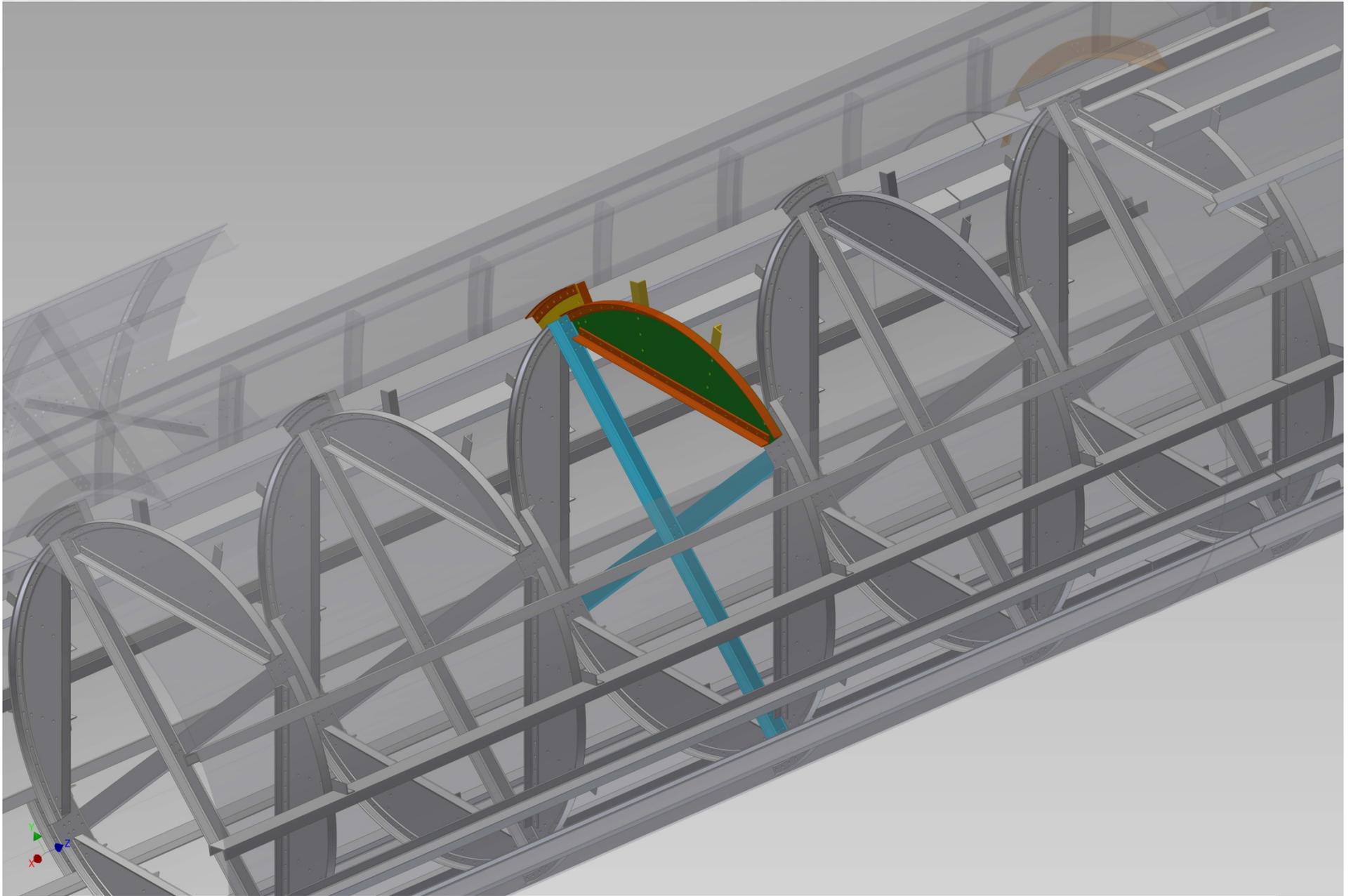
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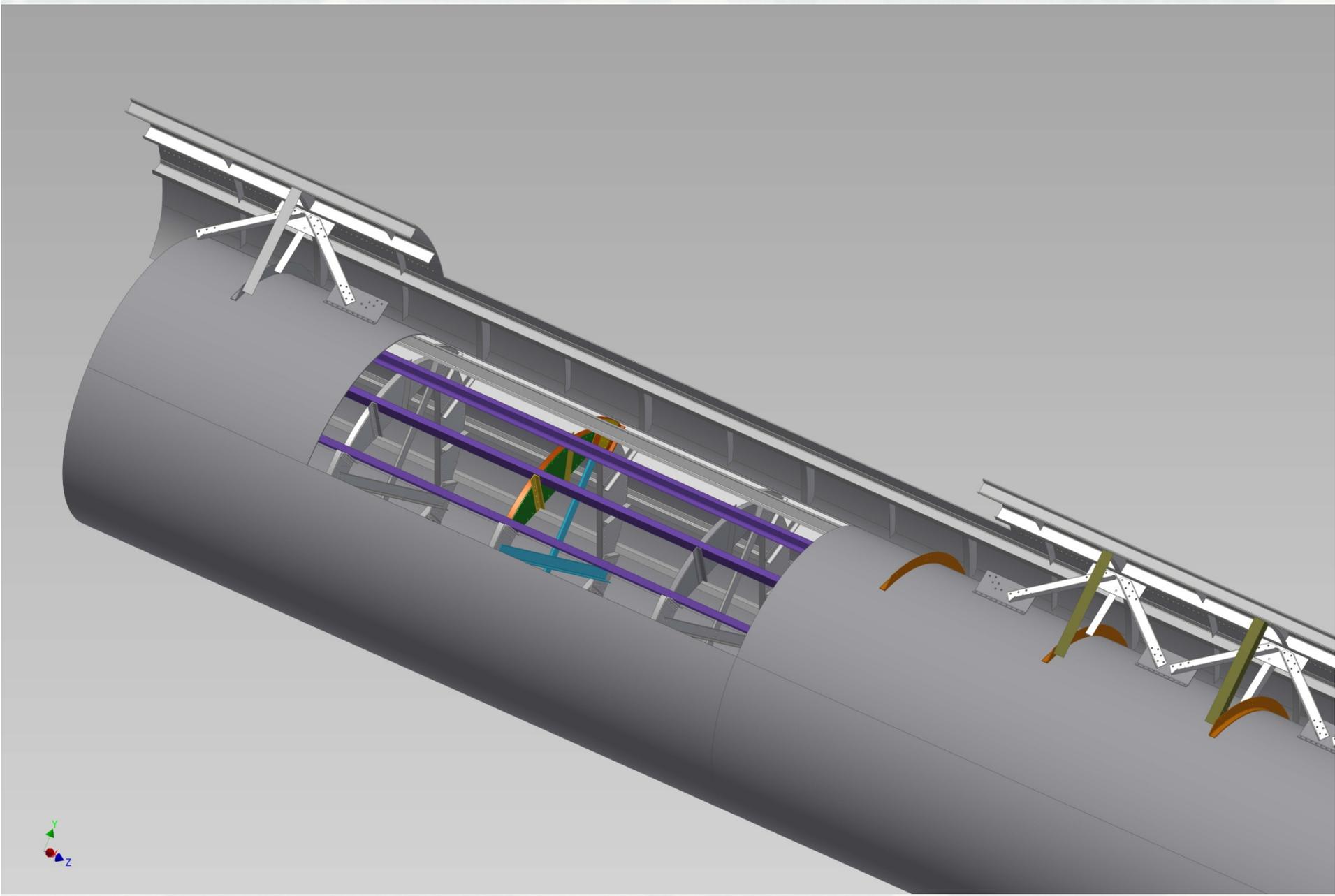


Total area of  $\frac{5}{8}$ " skin plate to replace  $10' - 2\frac{1}{8}"$  x 32' (three sides are existing doubler plate joints, the fourth a full pen weld)

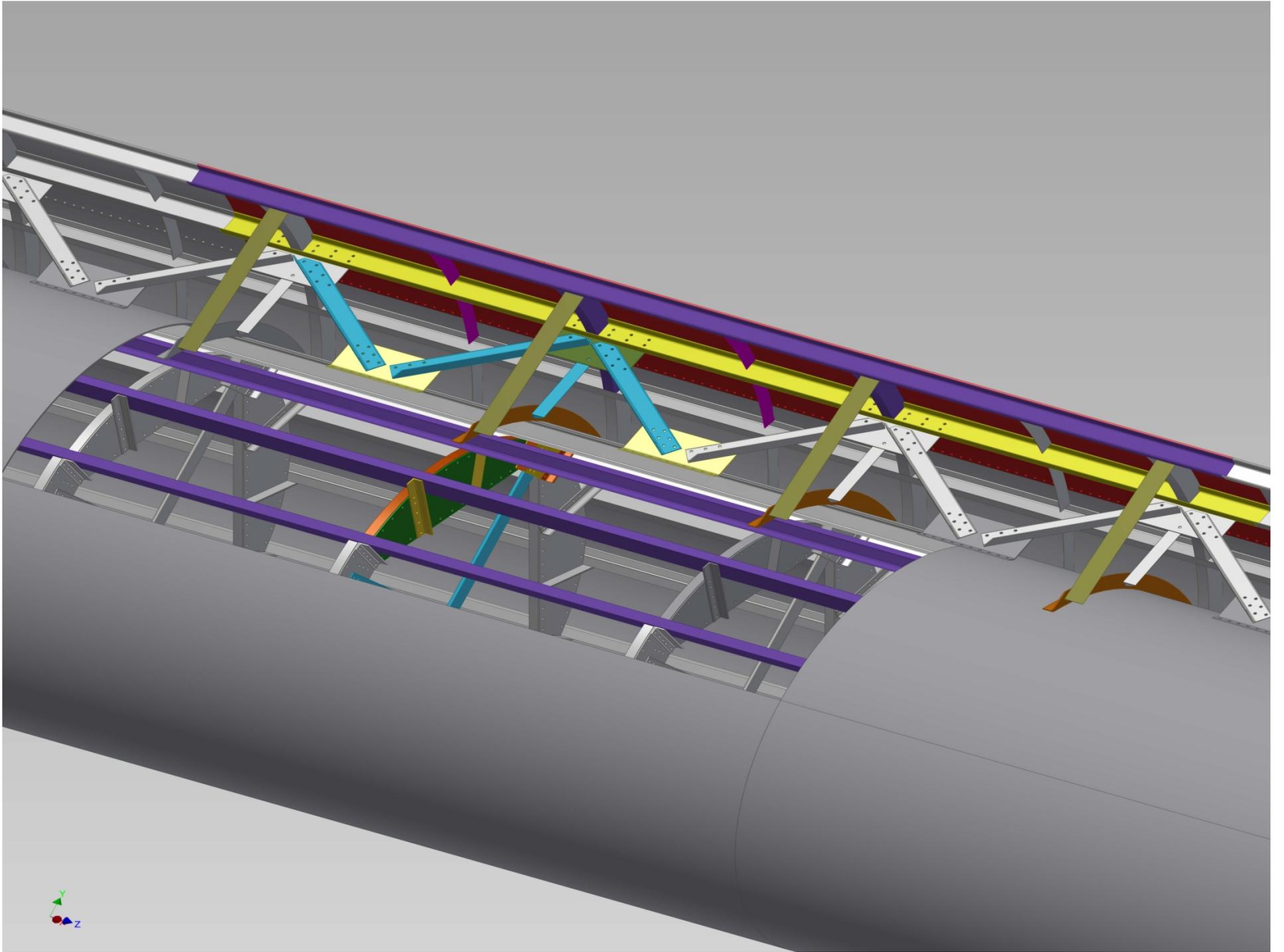
Crop in small plate with full penetration weld on three sides (approx. 2' x 3').

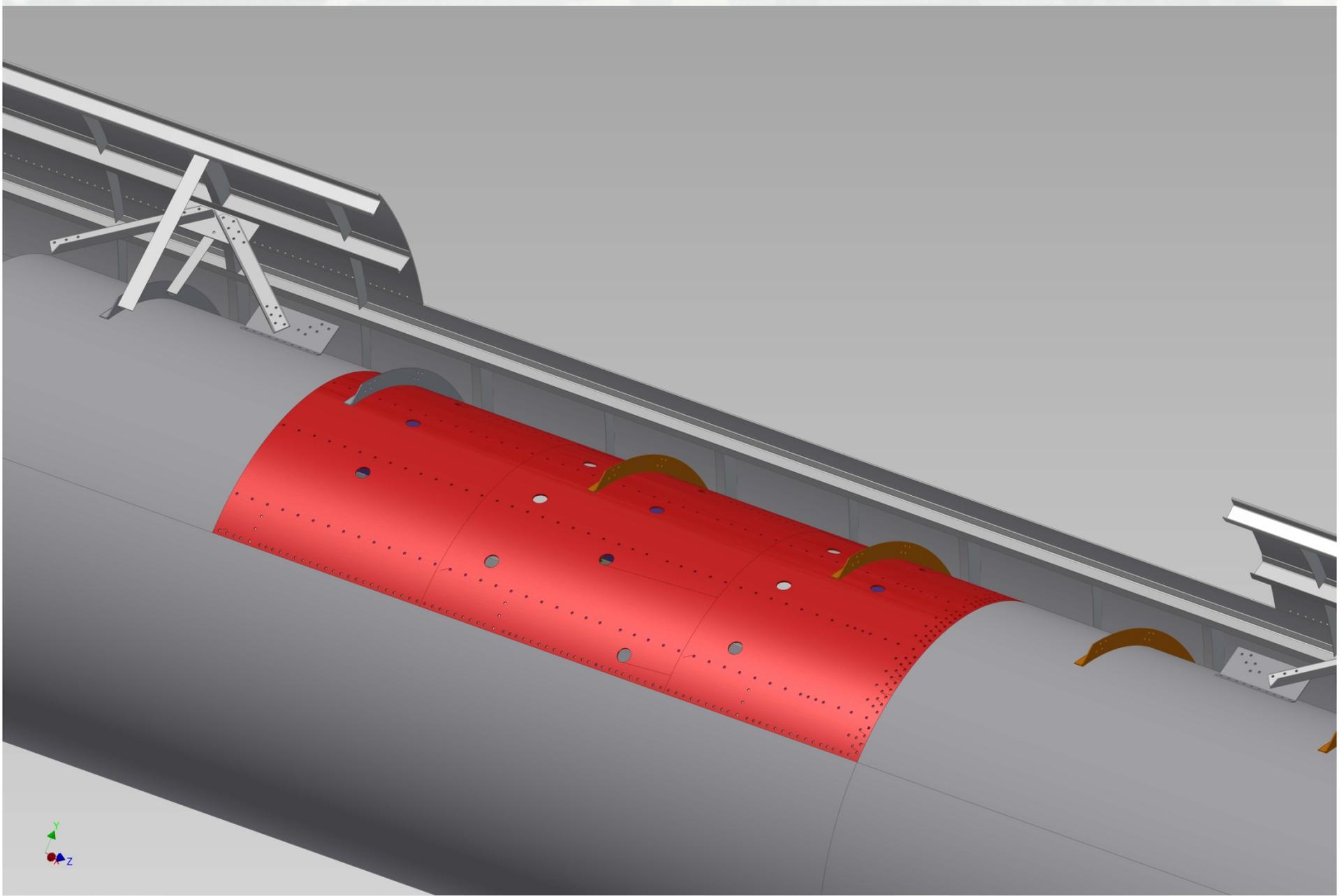


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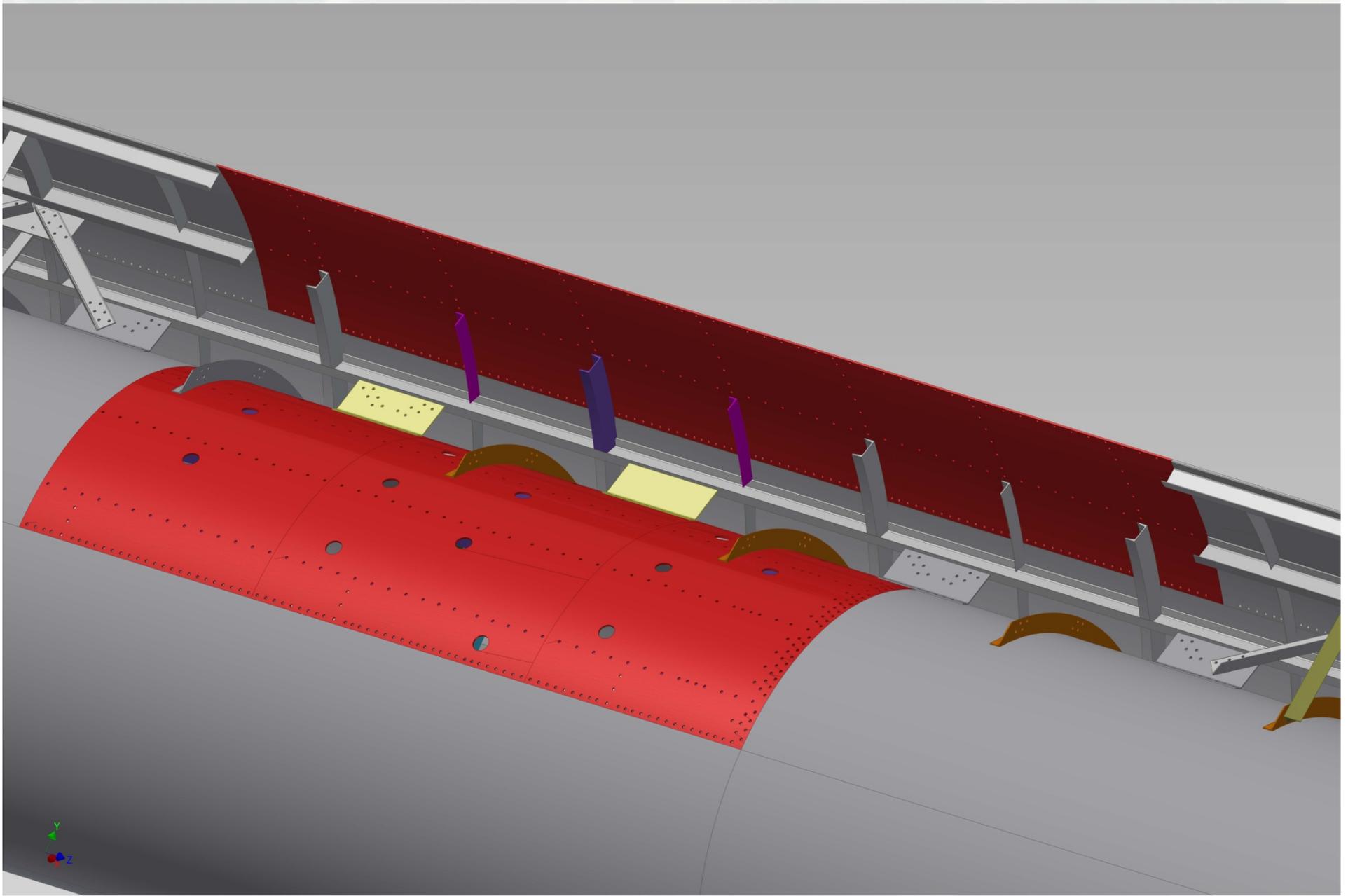
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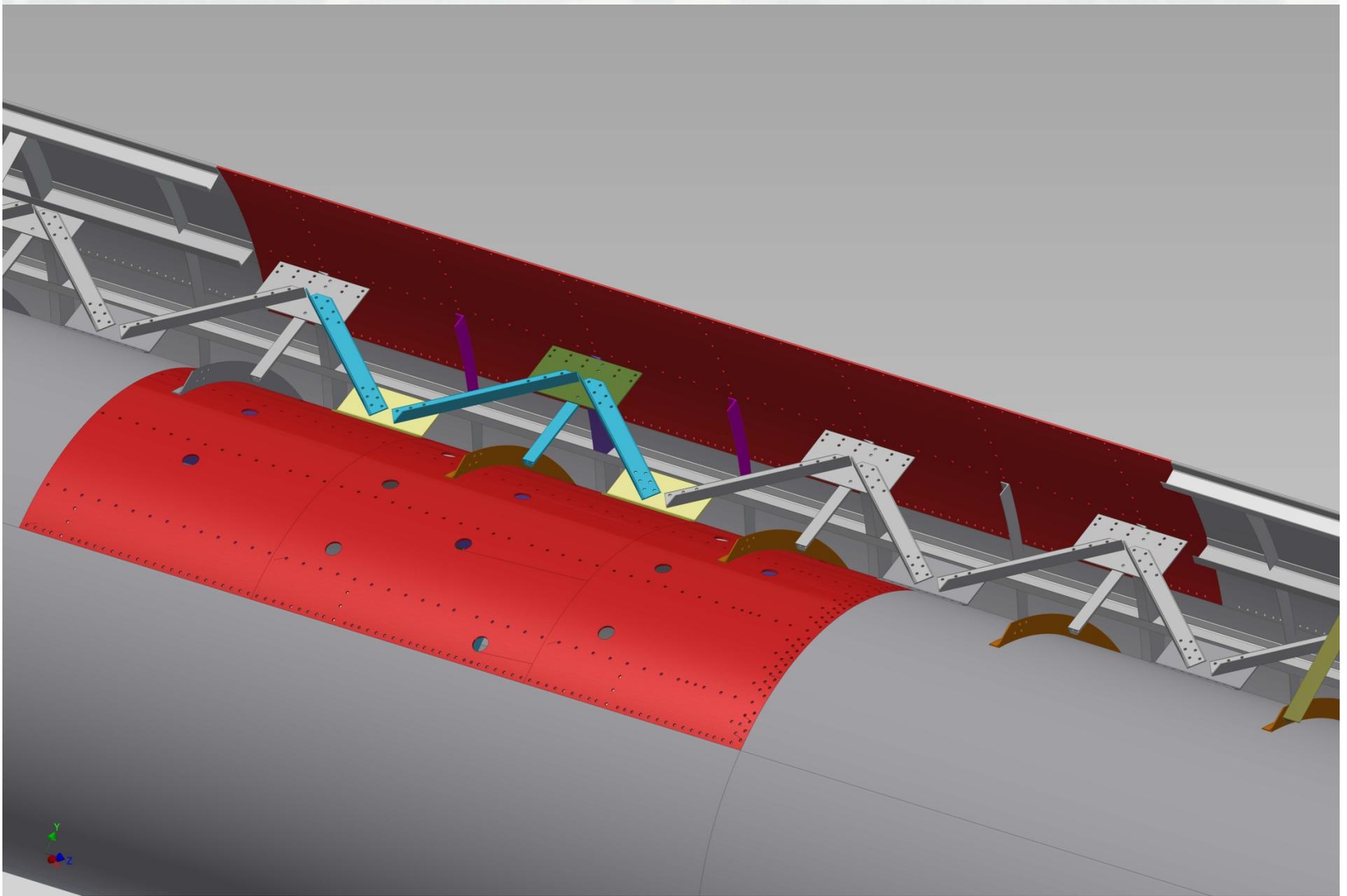


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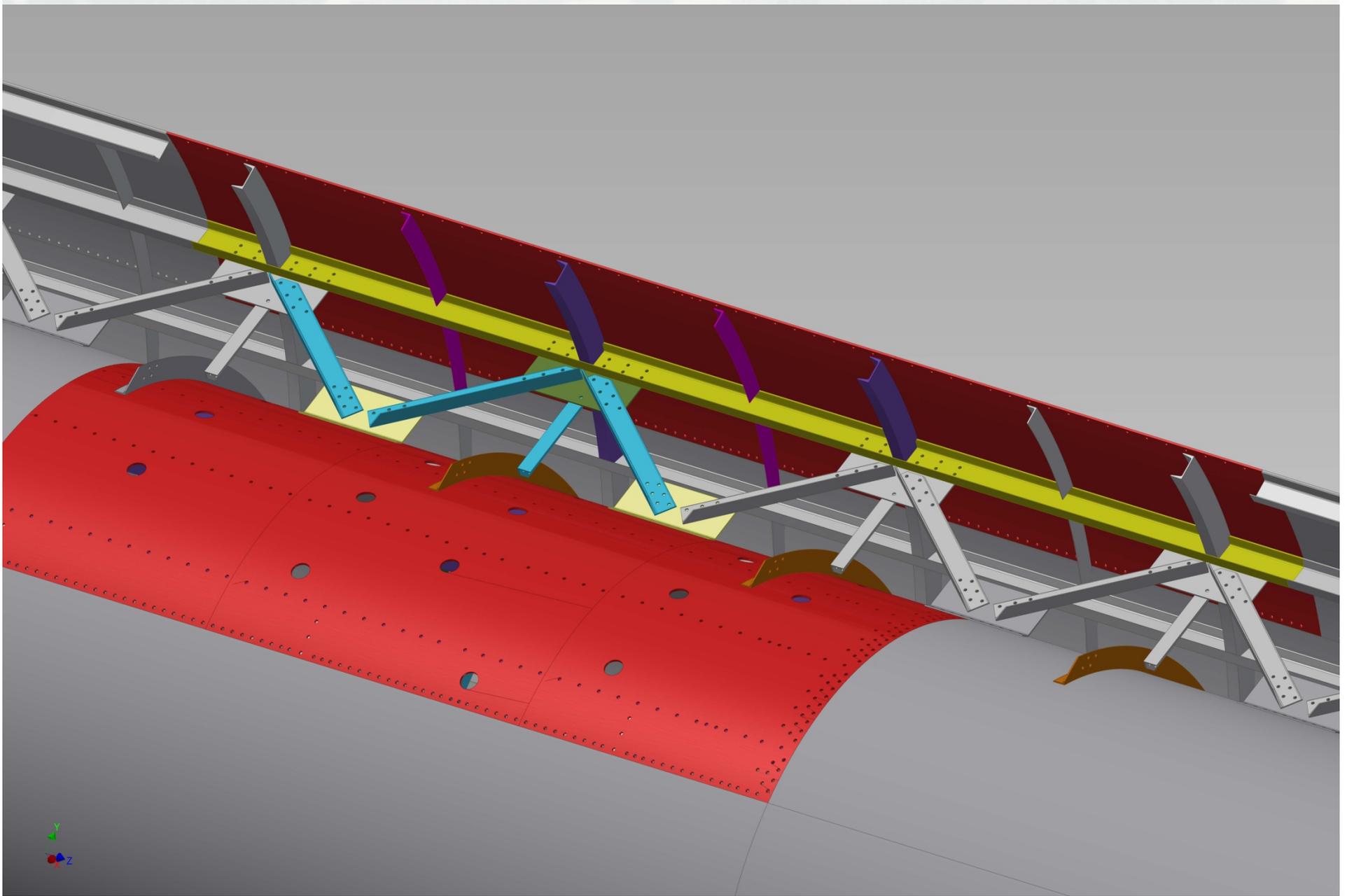
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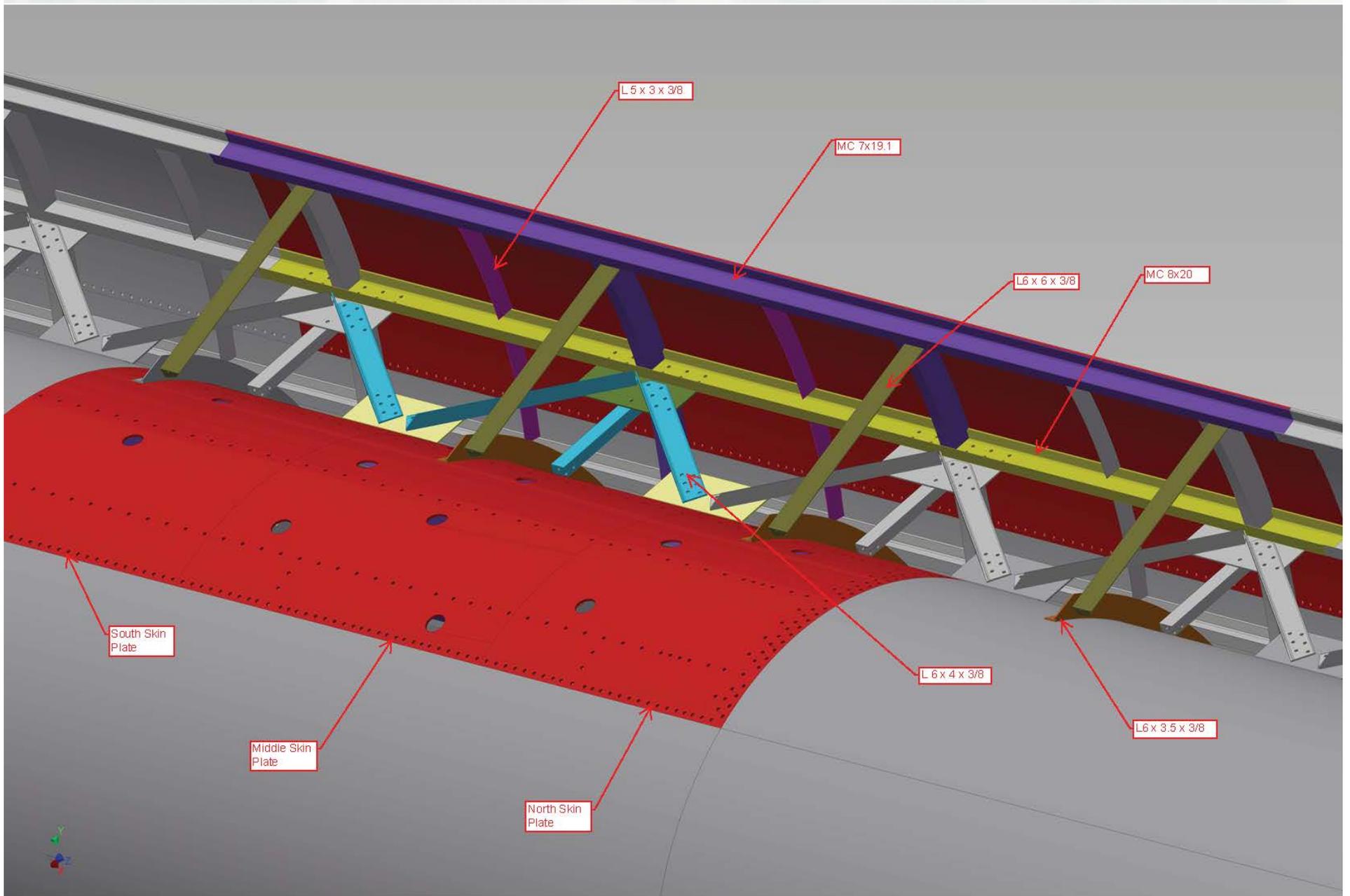
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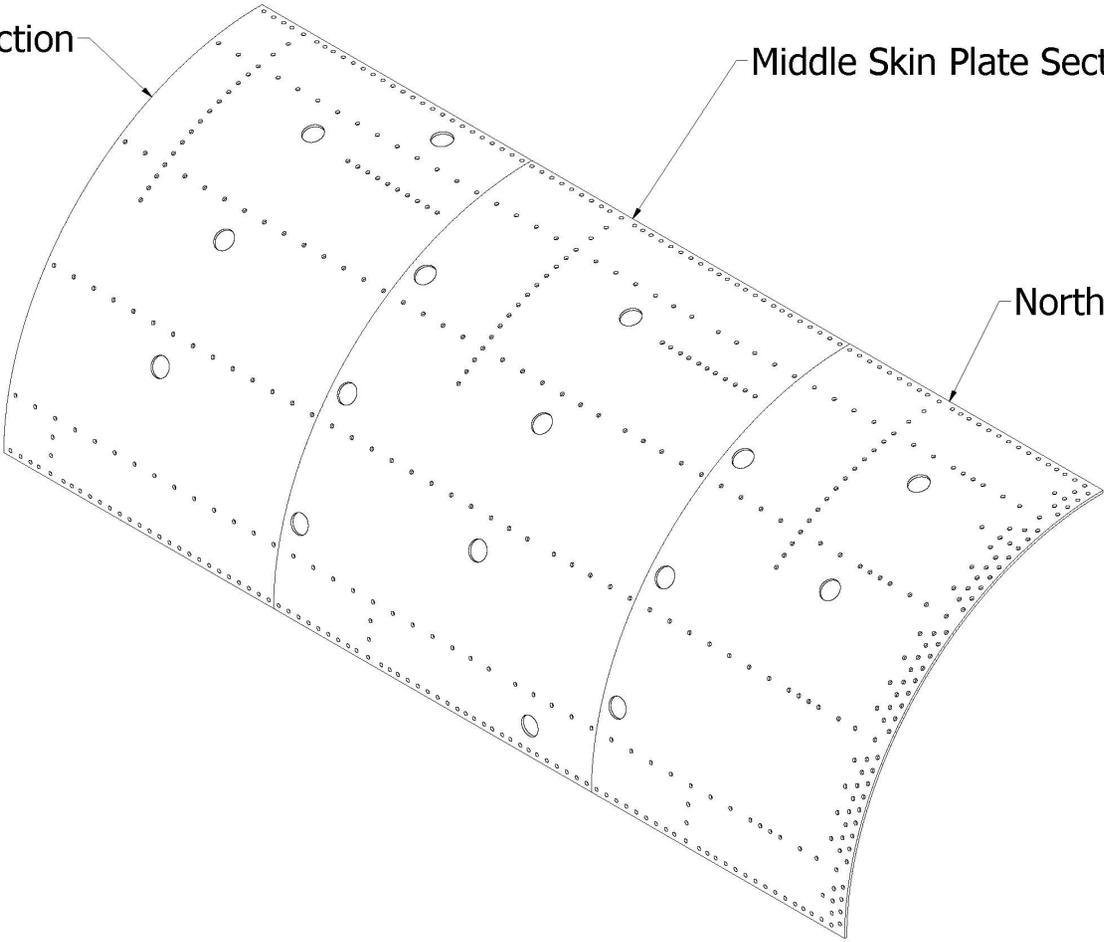


# Skin Plate Replacement Sections

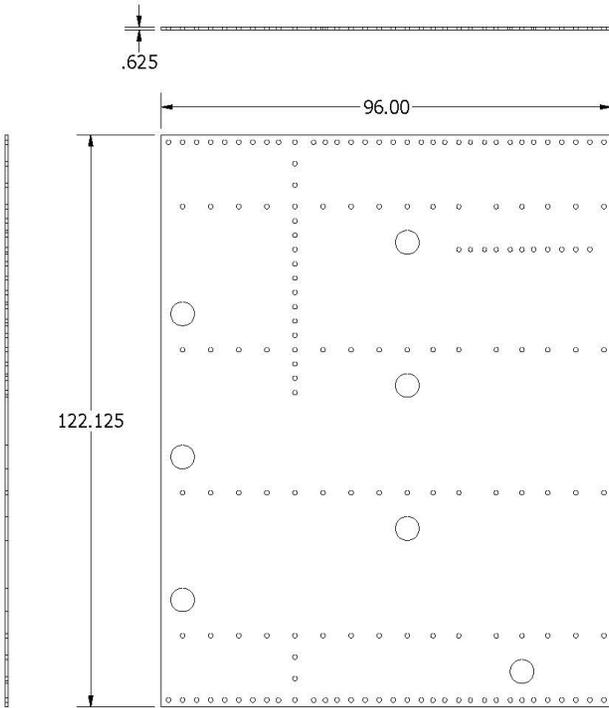
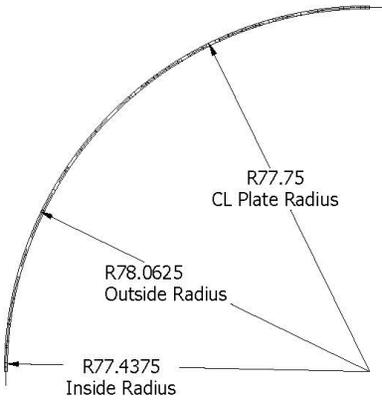
South Skin Plate Section

Middle Skin Plate Section

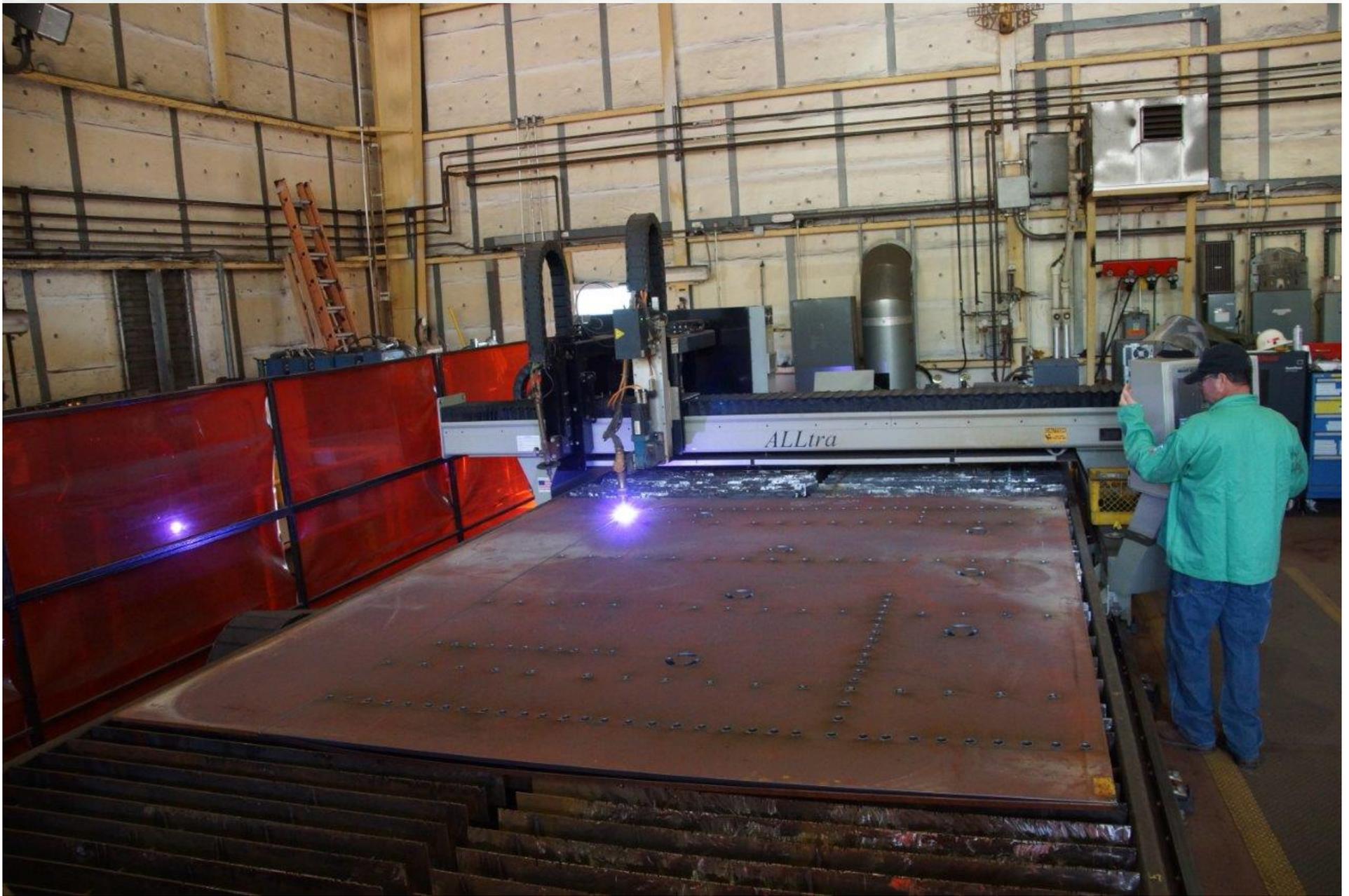
North Skin Plate Section



# Middle Skin Plate Section

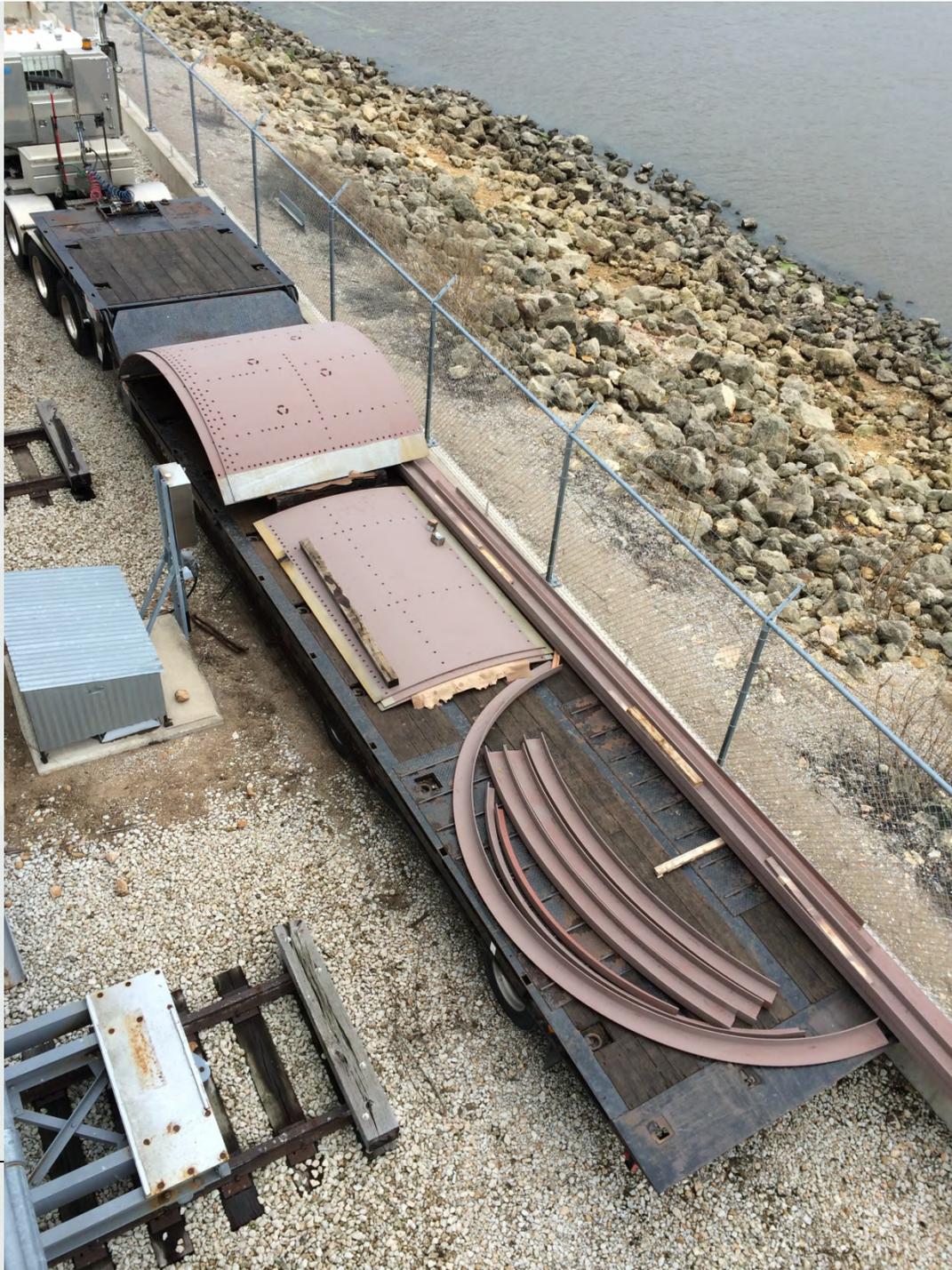


roll down



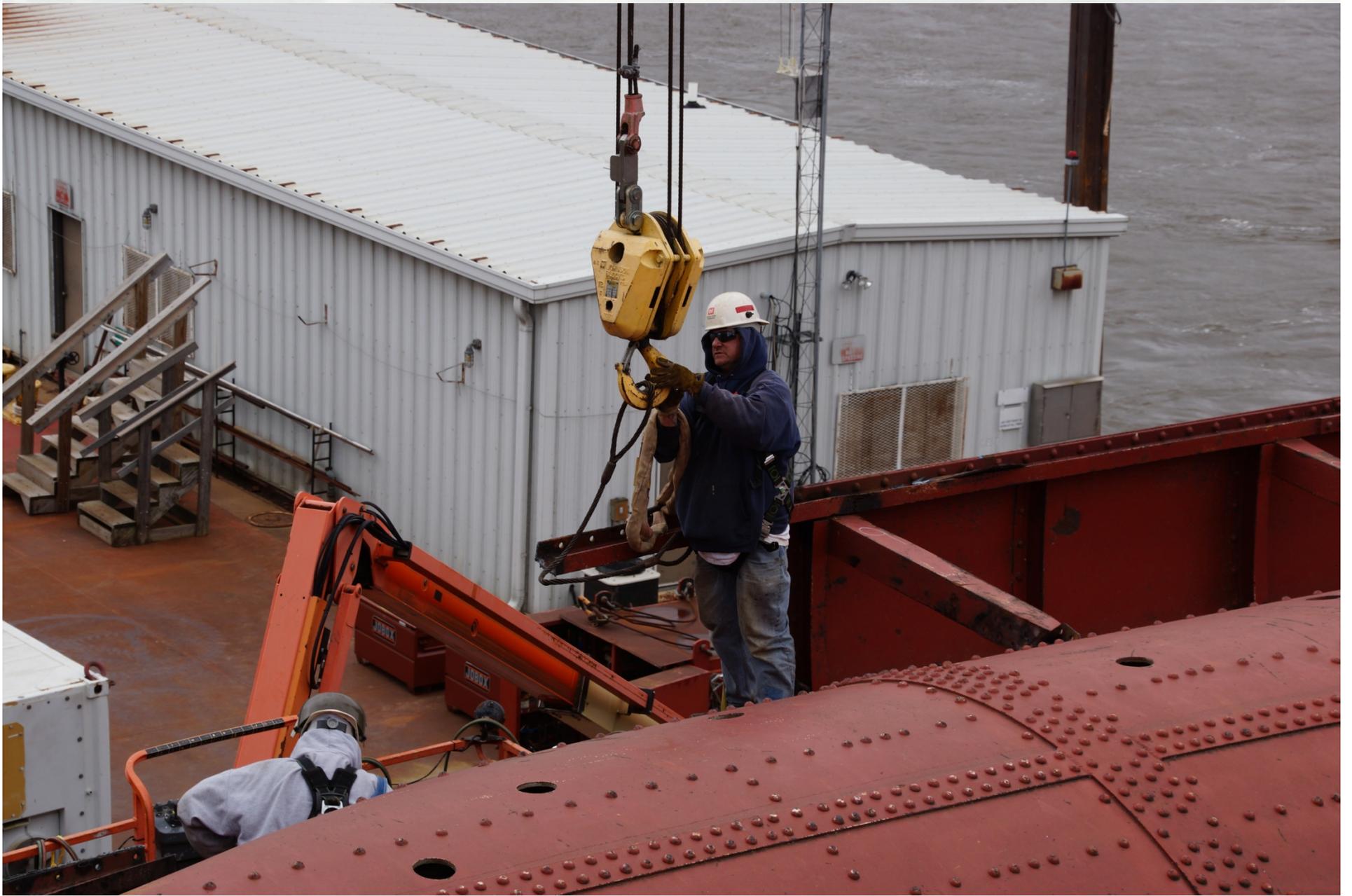
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## Project Summary

- Accident to Completed Repair: 3.5 Months
- Actual Repair Time: 1 Month
- Approx. Engineering Costs: \$21K
- Approx. Material Cost: \$30K
- Approx. Plant Cost: \$72K
- Approx. Labor Cost: \$164K
- Approx. Project Cost: \$287K
- Average Onsite Personnel: 8 persons



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