



METAL FABRICATION®



A National Leader in
Custom Industrial Metal Fabrication



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Ci Metal Fabrication has successfully fabricated high-quality custom components for the power generation industry for nearly half a century. When a customer recently awarded the company with a \$1.3 million contract for approximately 560,000 pounds of ductwork, trusses, support steel, splitter vanes and turning vanes, Ci Metal used its expertise to provide a solution that met every project requirement while exceeding the customer's expectations.

Details for the ductwork portion of the project were not provided before work began, so Ci Metal Fabrication's draftsmen and layout personnel calculated and detailed every duct panel one-by-one using only arrangement drawings. Shop details then had to be produced for every panel in order to move forward with the fabrication process.

The initial project consisted of an estimated 409,000 pounds to be fabricated in 24 weeks, but the project grew to approximately 560,000 pounds due to changes. This increase in scope presented a significant challenge for Ci Metal, because the original ship date remained the same despite the changes. In order to complete the order in the same time frame and meet customer expectations, Ci Metal had to revise the plan and produce a more efficient job schedule. In the end, Ci Metal met the difficult goal of fabricating 560,000 pounds in less than 24 weeks, even with multiple priority sequence changes made during the fabrication process.

An additional challenge was shipping the finished product. Large ductwork cannot be shipped fully assembled, so Ci Metal custom fit all duct panels to their mating panel, then match-marked and pre-drilled all fit up holes to ensure that field installation went as smoothly as possible. Ci Metal also calculated and laid out the locations of all splitter vanes, turning vanes and trusses on the duct panels in order to shop-attach turning vane clips before shipping. The installers could then simply slide the turning vanes into place during installation.

Although this project presented challenges in both technicality and scope, Ci Metal Fabrication succeeded in delivering quality fabricated components that met the exact specifications of the customer's request while facilitating hassle-free installation and use.

