

## CASE STUDY

# US Philadelphia Mint

### CLIENT SITUATION

The United States Philadelphia Mint furnace piping developed oxidation inside due to condensate formation in the interior of the pipe. The piping needed to be replaced to restore proper operation of the annealing furnaces. The Mint required that all installation be performed during designated weekend work shutdowns to prevent interrupting operations at the facility and for annealing furnaces to remain in operation during normal production hours. Ultimately, the US Mint sought a turn-key solution that would restore the proper operation of the annealing furnaces.



### RHOADS SOLUTION

Rhoads immediately got to work, producing shop drawings for the fabrication of the pipe sections based on field verifications of existing Exogas Gas piping. The drawings indicated the breakdown of the piping system sections and acted as weld maps for our quality assurance documentation. We handled the material procurement and fabrication of spool pieces to pre-fabricate as much of the replacement piping offsite at a Rhoads facility to limit onsite installation and welding time. In addition, our management team worked directly with the Mint's project engineers and managers to schedule the installation without effecting production.

### RESULT

Upon completion of the installation, our entire work package was reviewed, verified and accepted by the Mint and the contracting officer in Washington, DC. The project was completed under budget and to schedule with zero loss in production, as well as zero incidents and safety violation. All deliverables were met to include final design drawings, weld mapping and inspection reports.

**Contact us today to  
learn how Rhoads  
Industries can help  
with your next project.**

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