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By Del Williams

Power Plants Forge Ahead: Speedy Delivery of High Quality, Open Die Forgings, Seamless and Contoured Rolled Rings and Complex Forged Parts

Specialty forgers can manufacture custom, high-quality, seamless rolled rings in a variety of materials and finishes in as little as eight weeks.

Open die forgings and seamless rolled rings are essential components in power plant engineering, contributing to the overall reliability and efficiency of turbines, generator systems, and transmission and distribution equipment.

Forgings for component parts and seamless rolled rings have a greater lifespan than other products due to their strength and durability, and are less prone to cracking or warping, making the option ideal for critical components requiring high tensile strength. Depending on the metal and alloy, the rings are also resistant to thermal and chemical damage, which further extends longevity while reducing the need for maintenance, repair, and replacement.

For the power generation industry, obtaining large seamless rolled rings and turbine parts in a timely manner remains a significant challenge, however. Currently, it may take many months to receive the forged components after placing an order. This delay can have a severe impact on the production and maintenance

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schedules of firms that depend on replacement parts.

Rings are typically provided with a rough surface finish, which necessitates the use of CNC machining to achieve the required level of smoothness. This poses a challenge for machine shops with a high workload, as allocating machine time for finishing inevitably leads to a decrease in production speed and an increase in costs, ultimately impacting the end-use cost or profitability.

Fortunately, power generation product manufacturers can rely on industry-leading forging specialists capable of producing a wide array of shapes and sizes of custom forged parts, seamless rolled rings, and contoured seamless rolled rings with the required surface finish in under two months. One example, All Metals & Forge Group, an ISO 9001:2015 and AS9100D manufacturer of custom and standard open die forged parts and seamless rolled rings can cost-effectively deliver these components with the required finish within 8-10 weeks.

The range of forged products includes rings, discs, hubs, blocks, shafts (including step shafts or with flanges), sleeves, gear blanks, cylinders, flats, hexes, rounds, plates, and custom shapes. Carbon steel, alloy steel, stainless steel, nickel, titanium, and aluminum are among the materials used for forging. These forgings meet rigorous industry specifications such as ASTM, AMS, AISI, ASME, Boeing, SAE, GE, DIN, ASME B 16.5, ASME B16.47, and API 6A.

When speed and quality are essential, the power industry can reap the advantages of an accelerated process for obtaining flawless rolled rings.

The Benefits of Open Die Forging
One of the chief advantages of open die forging is the customization it offers in the seamless rolled ring manufacturing process.

According to Lewis Weiss, President of All Metals & Forge Group, open die forging is ideal for providing large, custom parts. "We can produce seamless rolled rings or contoured rolled rings up to 200 inches in outside diameter, and custom forgings up to 40 feet long or 80,000 lbs.," says Weiss. All Metals & Forge Group has been manufacturing and selling open die forgings and seamless rolled rings for more than 50 years.

While open die forging is typically associated with larger, sim-



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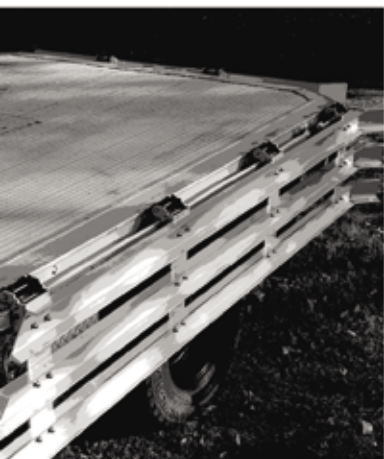


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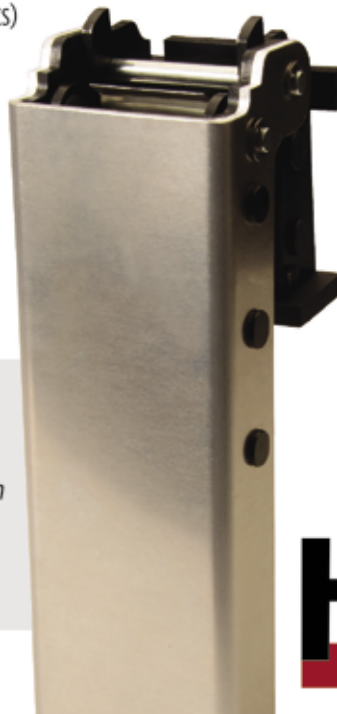
"Previously I had wooden side gates on my work truck. To remove them, you had to pick them up, set them to one side, and put them back, usually requiring two people — they're heavy! With HingePost, I just fold them down."

*— Mathew Hughes, Uncle Shuck's Corn Maze
Dawsonville, Georgia*

Introducing a new chapter in stake-post evolution, rights-holder HingePost has made a dramatic break with traditional designs. The main focus of this newly patented device for flatbeds is its automated locking mechanism and its speed of operation in folding downward 180°. Even its ease of installation and removal from flatbed pockets is notable.

Necessity: the Mother of Invention

HingePost is based in Dahlonega, Georgia and established in early 2023 by Bobby Anderson. The concept was motivated by the desire to accelerate loading times and, also, to contain the payload safely. HingePost uses aluminum, mild steel, and high carbon steel—all 3/16in thick. **The first of its kind**, this new stake post defines a new direction in combining side gates with flatbed platforms.



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pler-shaped parts like bars or blanks, the process enables the creation of “custom-designed” metal components.

According to Weiss, open-die forging facilitates the production of seamless rolled rings to exact specifications with optimized mechanical properties and structural integrity. He notes that the rings can be produced in a variety of alloys, sizes, and shapes specific to the requirements.

The forging of the rings is also cost-effective since the process reduces material waste and manufacturing costs. Since the rings are constructed from a single metal piece using a specialized ring rolling machine, there is no need for welding or assembly, saving time and labor. The seamless rolled rings are also more structurally sound because they create a circular grain flow in the material, following the shape of the ring, which increases strength and integrity, creating a refined grain structure. This can enhance the material's fatigue resistance and overall performance, resulting in a stronger, more durable final product compared to other methods of ring making, such as cutting from plate.

Near Net Shape Parts with Finer Surface Finish
Typically, when seamless rolled rings are forged, they are often left in an unprocessed state with a rough surface measured at approximately 500 RMS. As a result, significant CNC machining time is required to achieve a smoother surface for the finished machined part. This poses a challenge for machine shops as the allocation of machine time for finishing these rough parts directly affects production efficiency and delivery time to the client.

To optimize efficiency and reduce costs, All Metals & Forge Group frequently provides near-net-shaped forged parts with more refined surface finishes.

“Typically, we provide a 250 RMS surface finish. We can even provide 125 RMS. We can also drill holes and do contour forgings as needed,” says Weiss.

“Some forge shops only offer a raw unmachined part. We produce a rough machine part, saving machine shop time and equipment wear and tear since we have already taken off the first rough cuts off the ring or forged parts,” he adds.

In addition, the company conducts ultrasonic testing at zero expense to the customer to guarantee the absence of internal cracks, pits, or voids. This instills the utmost confidence in the quality of the parts, according to Tim Grady, Management Consultant for All Metals & Forge Group.

“In many cases, All Metals & Forge Group can offer ultrasonically tested parts that are more affordable than raw forged rings,” says Grady.

Streamlining Delivery

In today's market, the procurement of forged seamless rolled rings usually takes a considerable amount of time, from 20 weeks to as much as a year, as there are long lead times in receiving the necessary steel from mills.

“When replacement parts are required, a delay of a year or more is not acceptable,” says Grady. “Even 20+ weeks is a serious issue.”

To expedite the process for customers, All Metals & Forge Group has established strategic partnerships within the industry, enabling the company to deliver many custom forgings in a timeframe of eight to 10 weeks. Furthermore, to minimize any potential production downtime for machine shops, the company strives to provide accurate quotes within 48 hours.

Positioning for the Future

The need to acquire seamless rolled rings will only increase in industries like power generation that require high-quality custom-forged components that can safely withstand extreme forces with minimal repair or replacement. In these cases, working with an expert forger who can expedite the process will convey a significant advantage.

For more information, contact All Metals & Forge, LLC at 75 Lane Road, NJ 07004; (973) 276-5000; Canada 416-363-2244, toll-free (800) 600-9290; fax (973) 276-5050 or visit www.steelforge.com •

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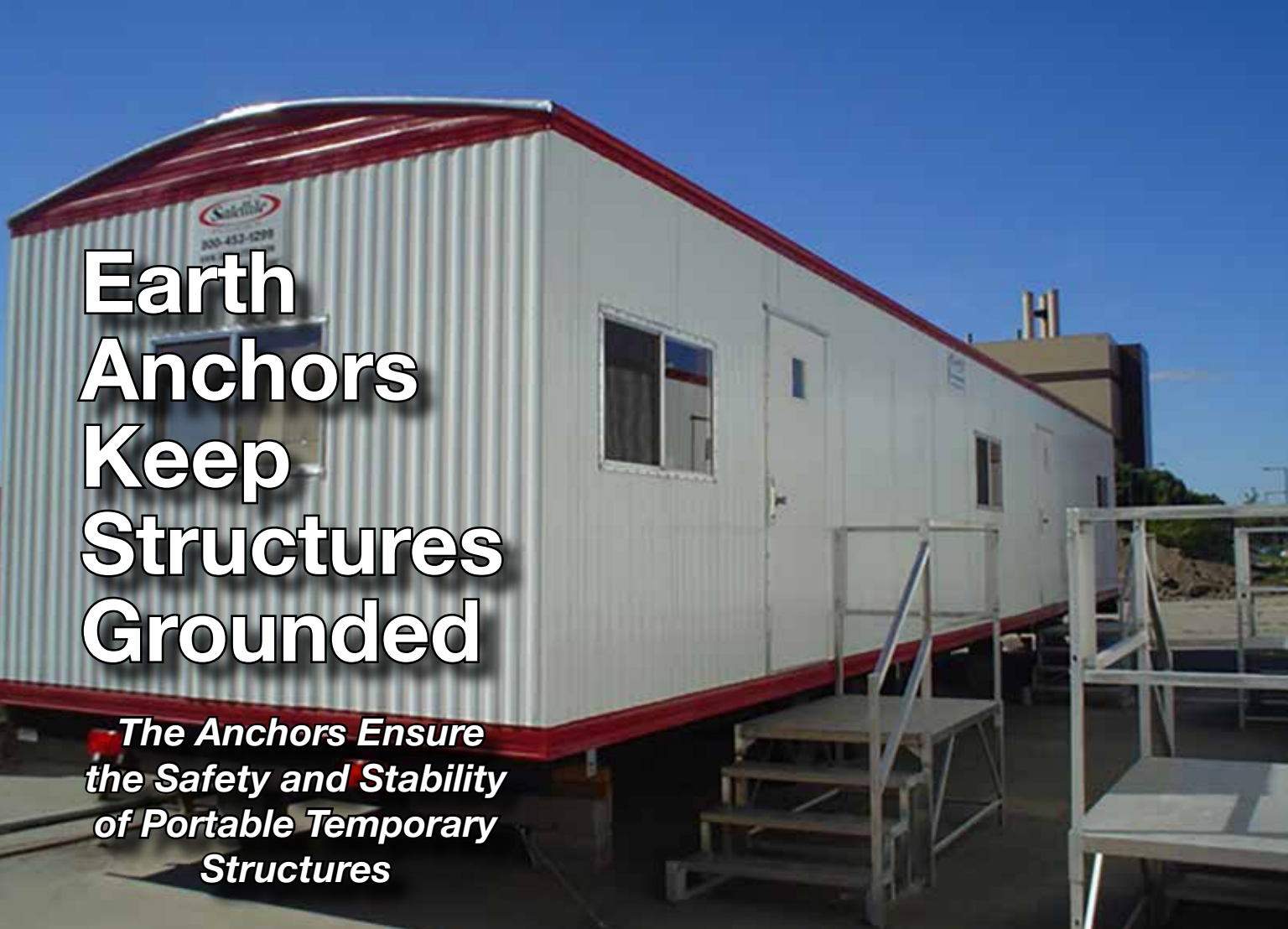
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Earth Anchors Keep Structures Grounded

The Anchors Ensure the Safety and Stability of Portable Temporary Structures

Many industries utilize portable, modular, or temporary structures or buildings due to the speed, flexibility, and cost-effectiveness advantages offered by this approach over permanent facilities. The construction industry, educational institutions, the events and entertainment industry, logistics/warehousing, military/defense, and emergency/disaster relief all utilize modular buildings as portable offices, classrooms, housing, storage, and shelters.

There are many reasons why these structures need to be secured to the ground and stabilized including:

- Protecting occupants, workers, and visitors from accidents due to unstable structures
- Preventing liability, tipping, shifting, or structural collapse during strong winds or storms
- Securing buildings to the ground to enhance structural stability, especially in areas prone to seismic activity or soil erosion
- Meeting building code, public safety, or insurance requirements.

The technology or methodology utilized to secure a structure can take many forms. It can be as basic as using concrete blocks or ballasts placed on the corners or along the perimeter of a building to provide weight and stability. More sophisticated solutions may use foundation systems that include footings, piers, or concrete slabs to provide a stable base for the building.

An increasingly popular and economic solution to this issue is earth anchors. These heavy-duty aluminum

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-James "Jim" Bonner

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anchors are driven or screwed into the ground and attached to structures using cables, straps, or brackets. The anchors can be easily installed into sand, soil, hardpan, asphalt, and even underwater.

Securing Metal Buildings

Koehn Building Systems, a member of the Metal Building Contractors & Erectors Association (MBCEA), works with building owners, facility managers, and qualified architects to design and erect pre-engineered metal buildings throughout Missouri and surrounding states. According to Jerel Koehn, Co-Founder of Koehn Building Systems, the company recently began using earth anchors, specifically Penetrators from Rhode Island-based American Earth Anchors (AEA), as temporary bracing guide anchors for pre-engineered metal buildings during construction.

AEA's Penetrators are screw anchors made of heat-treated 356 aluminum that can be installed with a portable impact wrench, machine PTO drive fitted with a suitable tool, or the company's manual ratcheting T-Handle. The screw anchors are available in lengths from 9" to 46" and can provide 2,500 to 14,000 lbs. of holding power in asphalt or hard pan soil.

According to Koehn, pre-engineered metal buildings can be utilized as warehouses, distribution centers, industrial facilities, auto dealerships, airplane hangars, offices, gyms, churches, and living quarters.

The benefits of pre-engineered metal buildings include the speed of acquisition (being mostly off-the-shelf standard parts) and the rapidity of erection. These attributes save construction time (and cost) and speed occupancy. Due to the inherent strength of metal buildings and their built-in support structure, their clear span can far exceed wood framed buildings. In addition, pre-engineered metal buildings tend to have longer life spans than traditional wooden structures since they do not age as quickly from damaging elements such as weather and termite damage.

Koehn Building Systems serves as both designer and erector of these structures. Customizable in almost any size or configuration, the pre-engineered metal buildings arrive with all the component parts, including permanent bracing that is used in the walls and roof for support, and to plumb the structures.

Koehn was concerned about strong winds that might possibly rise to 35 mph or higher during a storm, given that the structure's permanent bracing is not designed to withstand high wind conditions when unsheathed. Koehn Building Systems holds an AC478 accreditation, administered by the International Accreditation Service, that includes standards and guidelines for maintaining safe work practices.

With these concerns at top of mind, Koehn began searching for a solution to secure the structure temporarily, prior to sheeting. Koehn initially learned about Earth Anchors in a publication of the Metal Buildings Institute that addressed temporary bracing of metal buildings. He also attended an industry conference where earth anchors, and specifically the Penetrator screw anchors, were discussed.

Although earth anchors are not mandated by building codes or regulations for pre-engineered metal buildings, after his personal research Koehn was convinced that AEA's anchors offered a superior solution. The company now utilizes 46-inch Penetrators as temporary bracing for metal buildings. The number of anchors required varies, and each is installed strategically to support end walls with vertical columns using guy-wires.

"The earth anchors definitely give me peace of mind. When I install the 46-inch long Penetrators, we can



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Koehn considers the affordable earth anchors a “cheap insurance” against strong wind.

An Earth Anchor for Every Structural Grounding Need
Although Koehn Building Systems uses the Penetrators, there are other types of earth anchors. Selecting an optimal anchor for a temporary structure requires matching the anchor to the nature of the project and configuration of the structure, the type and characteristics of the ground, and the anticipated loads (principally wind in most cases). Key considerations include the class of soil and the project’s

load capacity requirements (e.g. Factor Safety to be applied to the maximum anticipated load). Calculating the required load capacity involves many factors.

“When considering load capacity, you need to consider the soil’s real-time moisture content and compaction. In addition, you need to review the earth anchor’s root penetration, installation method, pullout load angle, and any other factors that may be unique to the installation’s particular time and place,” says Cy Henry, President of AEA.

According to Henry, besides screw anchors, other earth anchor options include bullet anchors and arrowhead anchors, which are installed using a drive rod.

Bullet anchors, named for their bullet shape, are ideal for holding in tough soil such as hard clay, gravel, or soil intermixed with roots. An anchor is connected to a galvanized steel aircraft cable (typically available in 36, 60 and 120” lengths, but customizable) that attaches to the structure.

Similarly, arrowhead anchors offer superior holding in hard, compact, and rocky soil. Once in the earth, the anchor twists like a toggle bolt and will not release from the ground without cutting the cable or digging it out. The arrowheads come in 4, 6, 8, and 10-inch sizes with 48, 60, 72, and 120-inch galva-

drive them into the ground and attach them with a cable. I can walk away from the project and feel totally safe and secure that we have done everything we can to prepare for any type of weather,” says Koehn.

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"Arrowhead anchors are a great solution for softer and sandier soils. These anchors have more surface area in the ground when they flip around," says Henry.

Grounded in Safety

Whether the environment is commercial, residential, or military, the need to ensure that the structure is completely secured to the ground is paramount to the safety of everyone who uses it.

"Building codes and regulations often mandate anchoring for temporary and modular structures. If you fail to secure a structure properly, it can result in code violations, occupant safety risks, and valuable equipment and inventory losses, as well as property owner-operator legal liabilities," says Henry.

The popularity of portable structures continues to grow across virtually all sectors. Although the need for a structure in a particular location may be temporary, there can be no compromising on how well it

is secured to the ground.

While portability, ease of installation, and cost effectiveness may be the foundation of temporary storage structures' popularity, earth anchors matched to the specific conditions of use will help to ensure that the structures remain securely and safely grounded.

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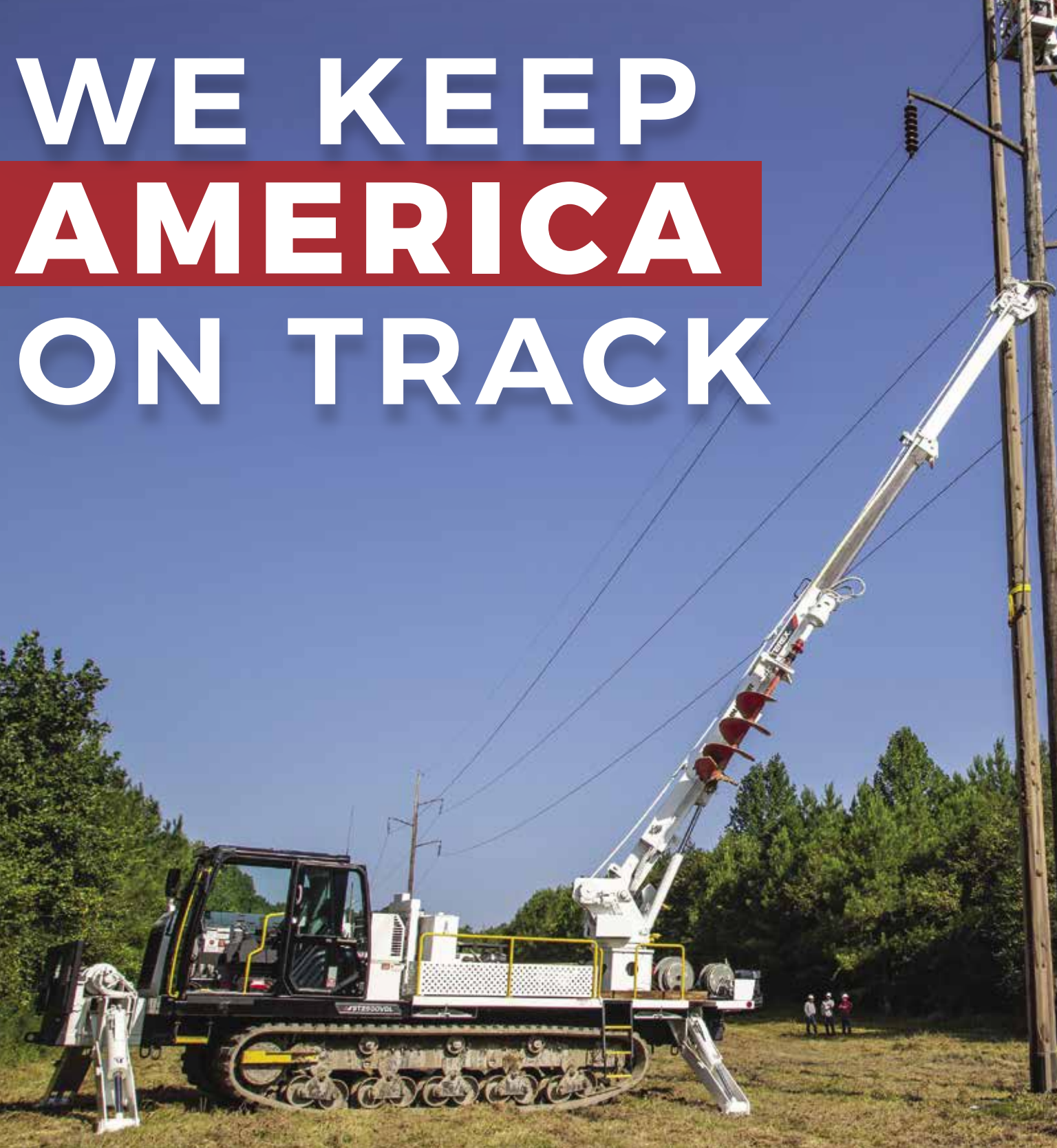
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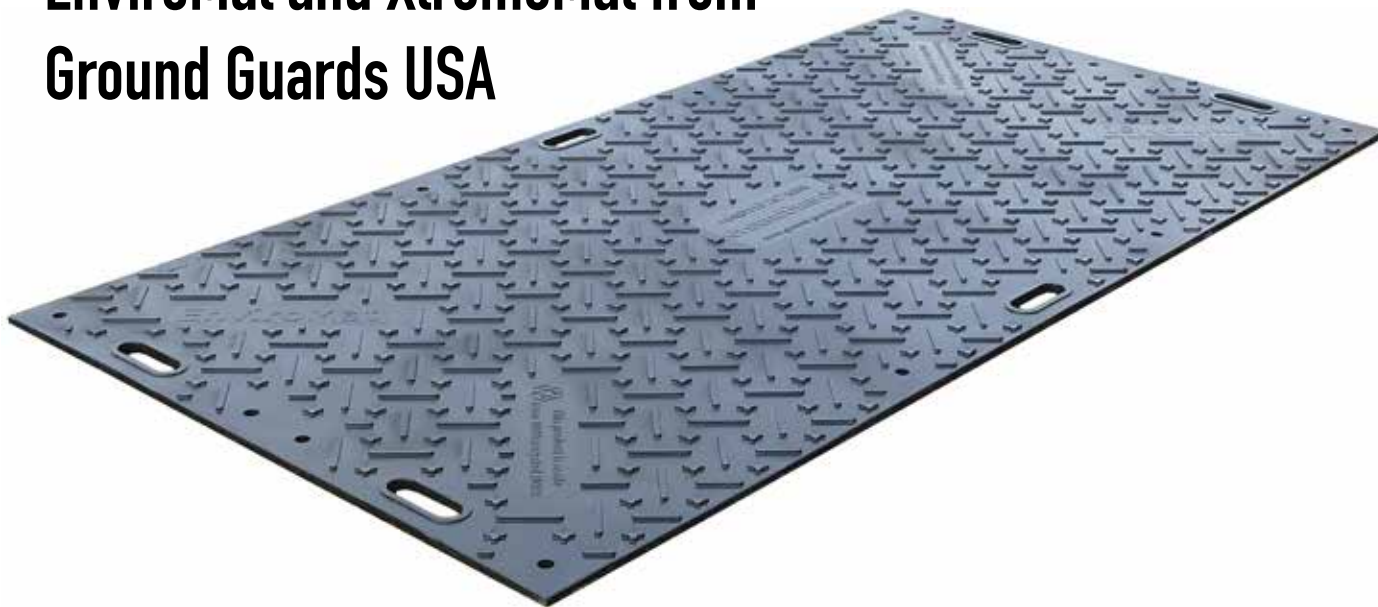
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DICA Expands Ground Protection Portfolio with EnviroMat and XtremeMat from Ground Guards USA



DICA will now distribute EnviroMat and XtremeMat ground protection products, in addition to MaxiTrack, from Ground Guards USA.

EnviroMat is a reliable and lightweight choice for quickly creating temporary access and vehicle roadways. No tools are needed to connect EnviroMat sections together by hand. The modular mats increase flexibility for solving a variety of site setup needs. A unique micro-traction design reduces slick surfaces, enhances safety, and provides superior turf protection to preserve the ground's integrity under heavy loads.

On the other end of the ground protection spectrum, XtremeMat is a heavy-duty solution perfect for haul and access roads, drill pads, crane access, and to create parking lots and site compounds. These large mats (14'2" x 7'5") feature overlapping flange joints bolted together with special Mega-Threads allowing installations to work together as a rigid and strong one-piece assembly. This feature allows users to combine XtremeMat together in any direction for modular site layouts.

"XtremeMat excels at creating temporary access roads and platforms in conditions such as swamps, where conventional methods would fail," said Kevin Koberg, Strategic Sales Manager at DICA. An HDPE outer shell and hard foam inner core creates a unique combination of durability and buoyancy. "With this in your arsenal, equipment owners don't have to worry about how to keep projects moving, even

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in the most extreme conditions,” said Koberg.

Earlier this year, DICA announced its first Ground Guards USA product, MaxiTrax. MaxiTrack is an access mat solution that can be deployed by hand for companies that need to provide temporary access for wheeled or tracked equipment weighing up to 150 tons. In addition to roadways, MaxiTrack can be configured for tight areas and in asymmetrical shapes. For projects that cover

large areas, four mats can be pre-assembled and mechanically lifted into place from lifting points to accelerate deployment.

“Partnering with Ground Guards USA has enabled us to provide comprehensive ground protection solutions for multiple industries. EnviroMat is a lightweight everyday option, MaxiTrax is a customizable medium-duty solution, and Xtreme-Mat is ideal for use when ground conditions are severe and traffic is high,” said Kris Koberg.

About DICA

DICA, Urbandale, Iowa, has been specializing in building a better outrigger pad since 1988. By creating engineered solutions for improving equipment stability and ergonomic safety, DICA is leading the way in product innovation for outrigger pads, crane pads and cribbing.

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