

Interoffice

12 METER MILLIMETER WAVE TELESCOPE

MEMO No. 126

**National Radio Astronomy Observatory**

January 19, 1982

To: J. Marymor

From: W. Horne

Subject: Subcontract AUI-200  
Letters from CenFab dated Jan 7, 1982

I have reviewed the letter from CenFab with respect to the welding electrode to be used and AUI can approve CenFabs proposed electrodes. I would have preferred the E7018 rod over the E7024 rod because of slightly better penetration and improved low temperature ductility. The two wire welding electrodes they propose are acceptable although the E71T-1 will produce the better welds. The ER70S-3 wire will hopefully be only used on the thinner sections (tubes and gauge sheets).

The proposed payment schedule is satisfactory and reasonable but instead of the word "fabrication" used in sequences 2, 4 and 6 I would suggest "assembly" since they are going to do shop assembly.

In their schedule of work I assume production includes the shop assembly of that portion of the work. I note that they do not order materials for the outer ring and guy assemblies until late February and early March. I would suggest that they order these items as early as possible as some of the tube sizes and the guy fittings might be difficult to locate.

I note that this schedule produces a 16 week delivery and that the schedule does not show when shipment is made. I suggest that the schedule should include "disassembly and shipment" and reference should be made to a "target" shipment date of 13 weeks which I understand CenFab had agreed to strive for.

c.c. H. Hvatum