

Atlantic States Ductile Iron Pipe Process

Molten Iron Process

Our pipe making starts with 100% recycled metal. We load the scrap into a bucket and transfer it-along with coke, silicon and limestone-into the cupola. Heated air and oxygen is then blasted into the cupola causing the material to melt at a fast rate. Over 700,000 pounds of molten iron is typically needed per shift to meet production needs. Atlantic States is the first foundry in North America to demonstrate the use of advanced control technology to limit mercury emissions from the melting operation.

Casting Process

After leaving the cupola at 2800°F, the liquid iron is tested for its chemical composition. The iron is skimmed to remove impurities in the form of slag. The iron is then desulfurized and treated with magnesium to make ductile iron. The molten ductile is then poured into water cooled molds and centrifugally cast producing a pipe of a specified size and thickness. Each mold is specially made for the size. The pipe bell is formed using a sand core for each joint of pipe.

Finishing Process

Each pipe passes through a 130 foot long oven. Each pipe reaches a temperature above 1800°F to anneal the pipe to its proper ductility. Once the pipes leave the annealing oven a hydrostatic test is performed at 500 psi to ensure the pipe can withhold high pressures. The pipes are then lined with cement which prevents internal corrosion. The final stages include painting, labeling, and bundling the pipe for shipment. McWane is a global company that ships to destinations worldwide.

Our Safety Culture

Safety is a core value at Atlantic States, as we have reinforced many times, no amount of production or profit is worth the risk of an accident. Eliminating unsafe acts and conditions, which account for 95% of all accidents, is critical for achieving our ZERO accident culture. To achieve our zero risk culture, all of us must continue to fully embrace safety first, hold ourselves and our co-workers responsible and never take safety for granted. So much of our safety is just pure common sense – personal protection equipment (PPE) protects our eyes, hands, feet from injury, lock out tag out (LOTO) protects us from moving equipment, fall arrest from working at elevated levels, and a strong commitment to housekeeping to prevent slips, trips, and falls.

**Goal is always ZERO Risk
ZERO Accidents**

Tour Group Required PPE

Hard Hat
Ear Plugs

Safety Glasses
Steel Toe Boots

Atlantic States Cast Iron Pipe



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For Generations



Atlantic States Ductile Iron Pipe



For Generations

WE HONOR . WE INVEST . WE COMMIT . WE STRIVE

CORE FLOOR



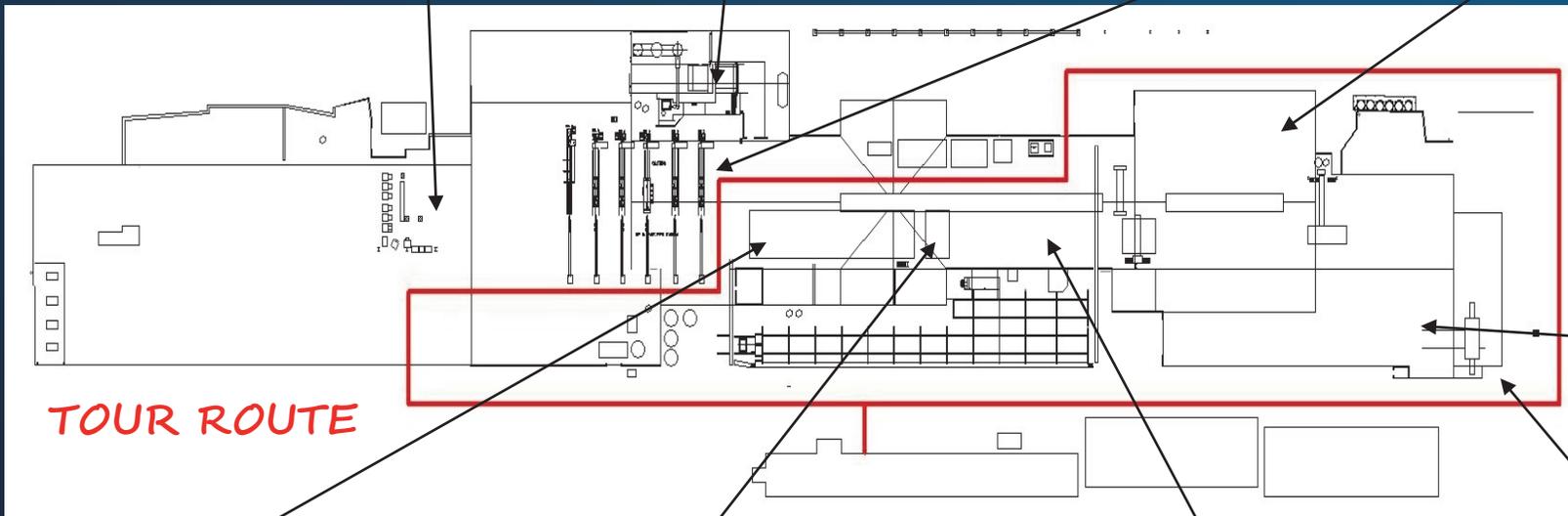
MELTING



PIPE CASTING MACHINE



CEMENT LINE



PAINT LINE



ANNEALING OVEN



QUENCHER



TEST PRESS



SHIPPING



9001:2008 Certified QMS
NO. 5337

