

A QUARTERLY MAGAZINE FROM MCWANE DUCTILE

IRON STRONG INSIGHTS™

SPRING 2022



**MCWANE
DUCTILE**

BUILDING IRON STRONG UTILITIES FOR GENERATIONS

**Multiple Events Collide
to Affect Ductile Iron
Pipe Supply** PG 4

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**McWANE
DUCTILE**

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IRON STRONG INSIGHTS™

McWane Ductile has been an industry leader in the manufacture of water distribution and infrastructure products since 1921. With three U.S. foundries, McWane Ductile offers superior service while supplying Ductile iron pipe across North America and beyond, all while maintaining an unwavering commitment to safety and quality. Through continued innovation, it is our goal to meet the customer needs and industry demands of the future in order to Build Iron Strong Utilities for Generations.

PG 4

Multiple Events Collide To Affect Ductile Iron Pipe Supply

CONNECT WITH US ON



Welcome to Iron Strong Insights™

Dear Readers,

Welcome to the spring edition of Iron Strong Insights. It has been a busy 2022 so far. Our staff has engaged in numerous trade shows and conferences as exhibitors and presenters in various technical sessions. We have also continued providing our on-site installation training, primarily led by our Product Engineers, to many utilities and contractors across the U.S. These organized training and educational activities are not only vital to the success of McWane Ductile and our customers, but to the broader waterworks industry.

As we have moved through the year, COVID-19 appears to be waning. However, we are still dealing with the disruptions it caused to our lives, especially its effect on the supply chain. The unexpected and ongoing war in Ukraine has undoubtedly impacted the supply chain as well. In this issue, we have an in-depth feature on the supply chain and what McWane Ductile

is doing to manage these current issues and prepare for the future. As always, the primary goals are to produce a quality product for our customers in a safe and environmentally friendly manner.

We have our regional Project Profiles section for our readers to enjoy that highlights various construction projects across the nation. Of particular note in this issue is an "Installation Tips" sheet that focuses on some best practices for the assembly and installing push-on joint pipe. This sheet is designed to cut out for the readers' future reference. We will also make this sheet available on our website, under our Learning Center tab, as we continue to add to the informational and instructional content our users can access. As a note, stay tuned for additional content to be provided on our Pocket Engineer as well. We're nearing the completion of a new "Truckload Builder" Calculator that will assist the user with partial fill content

and the total number of truckloads on a specific order. That should be ready by early summer of this year.

Finally, as I started discussing our staff's various conferences, McWane Ductile is excited that we are returning to an in-person event for ACE22 in San Antonio, Texas. The waterworks group for the family of McWane companies will be there in Booth #25097, ready to assist visitors with any questions related to the various products and services McWane can offer. We always welcome the opportunity to discuss with true waterworks professionals how we can work together Building Iron Strong Utilities for Generations.



Stuart Liddell
Sales Operations Manager
Sales Operations Department



MULTIPLE EVENTS COLLIDE TO AFFECT DUCTILE IRON PIPE SUPPLY

Raise your hand if you can say that you've recently made a trip to your local grocery store with a craving for bagels and cream cheese, but after searching, you can't seem to find your favorite flavor of cream cheese, and the bread shelves are barren. Like many other industries, no one could have predicted the multitude of unrelated events that conspired to cause supply chain issues worldwide. But one thing is for certain in the water and wastewater pipe sector, we have experienced one challenge after another.

The availability and cost of Ductile iron pipe (DI pipe) have been very trying over the last year, and we will continue to face headwinds based on demand and rising input costs. So how do we weather the storm that does not seem to be subsiding anytime soon? This Iron Strong article will discuss why we are experiencing supply chain issues, rising costs and what McWane Ductile is doing to combat these obstacles.

ORIGINS OF SUPPLY CHAIN ISSUES

The beginning of the issues with DI pipe availability can be traced back to the housing bust and resulting economic crisis from 2006 to 2009. Demand for DI pipe was significantly reduced. The resulting consolidation and closures

of operating foundries brought the industry from 12 manufacturing plants to just seven today, thus greatly diminishing the available production capacity for pipe. But that was just a precursor for what lay ahead:

- ▶ In early 2020, the onset of the COVID-19 pandemic caused widespread staffing shortages in all aspects of manufacturing and shipment of DI pipe.
- ▶ *"It's been extremely challenging during the COVID-19 pandemic to hire and retain employees. Over the last 12 months, it has gradually become more challenging. In Ohio, our employees have stepped up to meet the demands of supplying our customers. They have done this*

safely and effectively, even while being short-staffed and enduring extended hours," said Tom Crawford, VP/GM McWane Ductile Ohio.

- ▶ The inability to obtain needed parts for maintenance affected the upkeep and operation of plant equipment for many industries. Some businesses, including McWane Ductile, had to find alternatives to established supply to maintain our facilities and produce at a consistent level.
- ▶ At the very early stages of the





coronavirus pandemic, production of many construction materials, including PVC pipe, was slowed as the shutdowns chilled the economy and put construction projects on hold.

- ▶ With an overall decrease in demand for fuel, significant cutbacks in oil production were implemented.

The pandemic increased the focus on the water sector and the importance of clean, accessible drinking water. Much of the available COVID relief money was earmarked by states for infrastructure improvements, and projects once again began to bid. In early 2021, the economy and construction projects began to rebound as markets and COVID restrictions were loosening. Then the following events occurred:

- ▶ In February 2021, ice storms in the U.S. Gulf region severely disrupted plastic resin production and the movement of resin goods already in short supply.
 - PVC pipe is made from resin, a byproduct of refining oil into petroleum. Most of this resin is produced by companies along the Gulf Coast of Texas.
- ▶ Then came a severe winter storm in Texas that forced resin producers to shut down for several weeks.
- ▶ Later that year, Hurricane Ida slammed into Louisiana in August, forcing refineries in the region to shut down again.
- ▶ To overcome this shortage in plastics, many buyers upgraded to Ductile iron pipe.

- ▶ Ductile iron pipe manufacturers did not have sufficient winter inventories to meet this unexpected surge.

Since the late summer of 2021, McWane Ductile has been selling pipe as quickly as we can make it, and, as Crawford stated, *“We expect the demand for Ductile iron pipe to remain strong over the next three years as a result of the infrastructure Bill that includes several billion dollars in water and wastewater infrastructure rehabilitation and electrical infrastructure hardening.”*

HOW IS INFLATION AFFECTING THE COST OF DUCTILE IRON PIPE?

In addition to supply chain issues, we've seen the U.S. inflation rate gradually

climb over the past few months to a 40-year high. Think about it — there is hardly anything one could purchase at this time that does not cost significantly more than it did a year ago. Demand, however, has not subsided and, in fact, continues to increase, which suggests the upward rise in consumer prices is unlikely to relent soon. Inflation has affected the pricing for consumer goods and the input prices that manufacturers must pay for the raw material, such as scrap, as well as natural gas and coke; the fuel sources needed to melt and anneal Ductile iron products.

WHAT ARE WE DOING ABOUT IT NOW?

So, what are some steps McWane Ductile is taking to improve manufacturing efficiencies and increase production capabilities? It starts with a commitment to making significant capital investments, including:

- ▶ More than \$18 million of downstream equipment will be operational at the Ohio facility by Spring 2022.
- ▶ A new line featuring zinc coating will weld TR Flex® restrained joint pipe in line with the same speed as casting and annealing rates.

- ▶ The Utah facility added new welders and zinc guns to increase the production of specialty items.
- ▶ A new small-diameter, high-speed casting machine will be installed at the New Jersey facility and is expected to come online in the fall of 2022.
- ▶ The Utah facility will add material handling equipment to increase casting capacity by 20%.

More than \$60 million will be committed to McWane Ductile facilities during the calendar year 2022 to facilitate meeting your needs.

WHAT ARE WE DOING ABOUT IT IN THE FUTURE?

Along with the investment noted above for 2022, the following capital projects are also being undertaken:

- ▶ The Ohio plant has hired an additional 80 employees to begin a second shift, starting May 1, 2022.
- ▶ Spring 2022: the Ohio facility will break ground on a second annealing oven, increasing the production of pipe and poles by more than 20%.
- ▶ Until the Ohio oven is fully operational by the end of 2023 or early 2024, hours and staffing levels will increase to improve output to meet demand.

"The significant capital investments coupled with adding an additional shift in Ohio show that we are proactively doing all we can to increase supply and meet demand," said Crawford.

WHY IS A SCRAP SURCHARGE BEING APPLIED?

At McWane Ductile, each pipe is made from up to 95% recycled materials.



Things like shredded automobiles and structural steel are the primary ingredients. The Russian-Ukraine conflict, which many did not expect to continue for as long as it has, has caused a severe shortage of pig iron in the international market, as both Russia and Ukraine are two of the world's top producers.

While McWane Ductile does not use pig iron, consumers of pig iron have downcycled to raw materials such as busheling and auto shred, resulting in immediate and intense demand for all grades of U.S. scrap, which in turn has dramatically driven up scrap prices over the past few months.

We expect this cost escalation to continue until the conflict resolves. Considering the detrimental impacts of these unexpected events, it was necessary to implement a scrap surcharge for all shipments.

ADDITIONAL POINTS

- ▶ This surcharge is temporary, and we will rescind it when scrap prices return to February 2022 levels.
- ▶ We will adjust the surcharge monthly based on changes in the Busheling Index published monthly in Fastmarkets.com.
- ▶ Fastmarkets publishes the settled scrap price on the 10th of each month.
- ▶ You may choose not to pay the surcharge and delay your scheduled shipments until scrap prices have returned to lower levels. However, because of unprecedented demand for our products along with supply



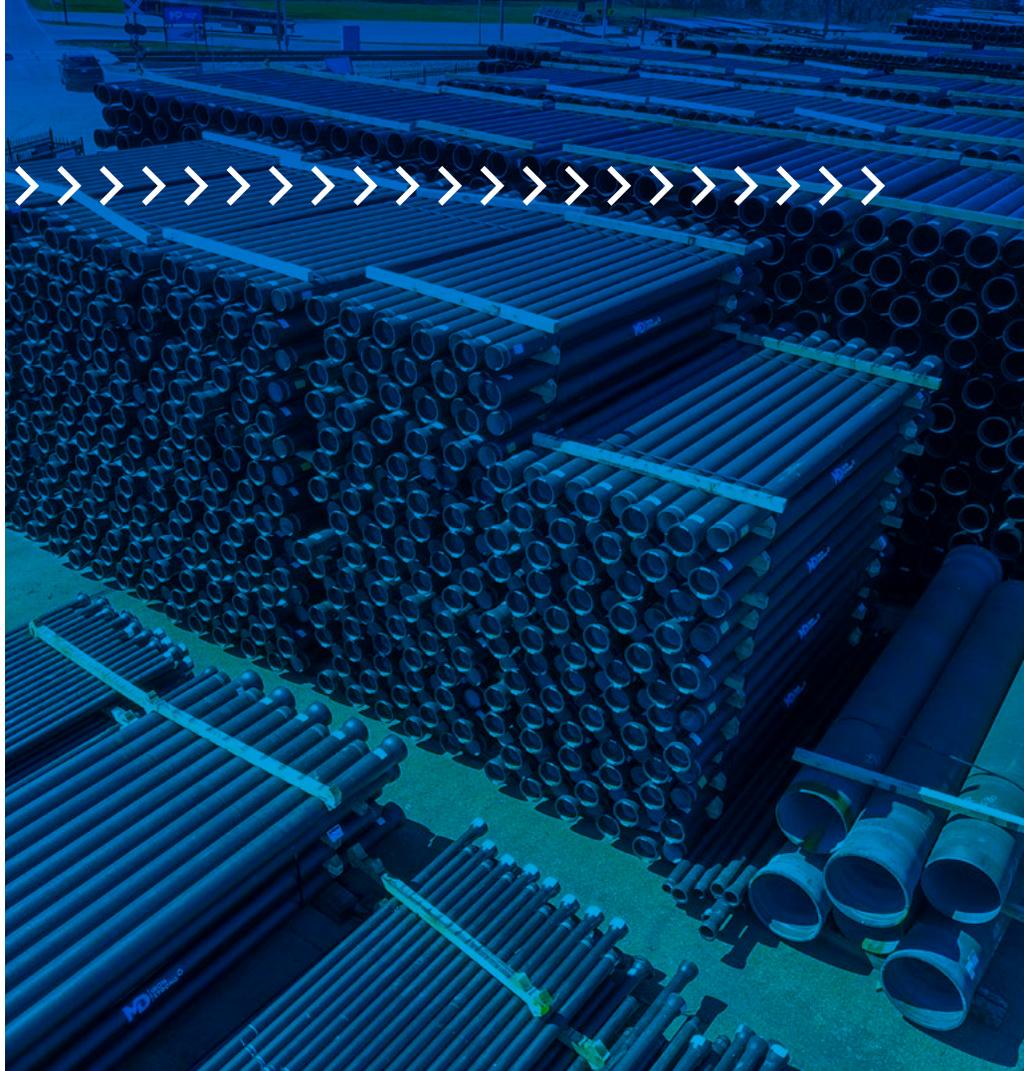


chain constraints, any previously communicated lead times, delivery schedules, and availability are not guaranteed.

IN SUMMARY

Price increases have spread throughout the economy, and the businesses are still suffering from widespread shortages of labor and supplies, not to mention shipping delays and higher transportation costs.

The recent unanticipated circumstances have brought unprecedented times. Like the grocery store's bread shelves, keeping the pipe yard full of fresh-made stacks of pipe has been a challenge. But rest assured, McWane Ductile is constantly evaluating current and future scenarios to provide quality products in a timely manner and enable our customers to build Iron Strong utilities for generations. If you have any questions regarding the



Ductile iron supply chain or your water or wastewater infrastructure project, reach out to your local McWane Ductile representative.

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GO BIG IN RIVER CITY.



"Everything's Bigger in Texas," so the saying goes. We welcome you to stop by **booth #25097** at the annual ACE conference in San Antonio and have some **BIG** conversations with McWane Ductile and the McWane family of companies and see why McWane Ductile is **Building Iron Strong Utilities for Generations.**

[McWaneDuctile.com](https://www.McWaneDuctile.com)

For a chance to **WIN one of two sets of AirPods Pro®** from McWane, visit us at **booth #25097** at 3 p.m. on Monday and Tuesday!



**McWANE
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ACE²²

June 12-15, 2022, San Antonio



IRON STRONG

DUCTILE IRON PIPE INSTALLATION TIPS FOR PUSH- ON JOINTS

Training is priceless. Crews often receive training on safety, but what about installation? The following are some basic tips to help ensure your Ductile iron pipe project installs efficiently and problem-free.

INSPECT THE PIPE AT DELIVERY:

Ensure you have received all material by checking it against the Bill of Lading to verify that all items are accounted for.

TRENCH CONDITIONS AND EXCAVATION:

- ▶ What **Trench Type** is specified — will there be special backfill required?
- ▶ Be aware of trench conditions throughout construction to ensure it is safe.
- ▶ Ensure the trench is wide enough to allow for the proper installation and assembly of the pipe joints.
- ▶ During excavation, remember to dig bell holes to facilitate assembly, especially if pipe other than push-on pipe is being installed. Bell holes will also help facilitate the installation of polyethylene encasement if required.

BEFORE INSTALLATION OF THE PIPE:

- ▶ Clean bell socket and spigot ends to remove any dirt or debris.
- ▶ In winter conditions, make sure to check for ice in the bells.
- ▶ The spigot should be cleaned just beyond the home line.
- ▶ If using TR Flex® pipe, position the bells so that the slots are easily accessible and follow the assembly instructions provided by diameter.

GASKET CARE AND INSTALLATION:

- ▶ Remember to properly store the gaskets in a clean and dry location.
- ▶ In the winter, heated storage may also be needed. This will allow the rubber to flex more easily for installation in cold weather.
- ▶ **Gasket Loops:** Looping the gasket will assist in assembly. The rule of thumb to follow is the 1st digit = number of loops recommended:
 - 3" - 18" = one loop
 - 20" & 24" = two loops
 - 30" & 36" = three loops
- ▶ For push-on pipe, the "heel" of the gasket should be located behind and flush or below the bell entering the throat. It should also sit ahead of the retainer bead — this holds the gasket in place during spigot insertion.
- ▶ The "bulb," or softer rubber, should sit fully in the gasket seat area of the bell.
- ▶ For large diameter, it may be necessary to remove tension at the loop areas, working it around the bell. A flat hammer may be used to tap the gasket in place.

Note: Restraining gaskets, such as a Sure Stop 350®, are not as pliable as standard gaskets, and extra attention to detail is required.



PIPE INSTALLATION:

- ▶ After inserting the gasket, thoroughly lube the inside surface of the gasket and spigot OD of the pipe to be installed.
 - **Note:** Use only lube as supplied and/or approved by the manufacturer.
- ▶ While positioning the pipe into the trench, it is important to use proper handling techniques, including approved tongs or slings to lift the pipe.
- ▶ Once lowered into position, it is essential to align it straight with the adjoining pipe.
- ▶ When in position, place wood dunnage across bell face and use the backhoe to push the pipe “home.”
- ▶ It is not recommended to use a sling to pull the pipe home as pipe may move from side to side during assembly.
- ▶ If there is an upward rise in the grade, insert the spigot STRAIGHT, deflect up, and back fill under the pipe.
- ▶ If installing on a downward slope, dig the grade down, support the pipe and insert the spigot STRAIGHT, then lower the pipe to proper deflection.

FIELD CUTTING:

- ▶ Select proper pipe for field cutting:
 - Markings: Gauged Full Length (GFL) — green marking on the bell for 16” and up.
 - 12” and down are not specifically marked and are considered Gauged Full Length.
- ▶ Do not cut within 2’ of the bell face.
- ▶ Always check the OD of the pipe before cutting.
- ▶ Bevel spigot ends for “push-on” type joints.
- ▶ Chamfer spigots ends for Mechanical Joint (MJ) joints.

ADDITIONAL PRECAUTIONS WHEN USING RESTRAINING GASKETS:

- ▶ Do not lay the spigot on the entrance throat as the spigot may catch a tooth as it rides to the center of the gasket (typically at the 6 o’clock position).
- ▶ Depending on size, it is not uncommon to need an additional pushing force for restraining gaskets vs. standard push-on gaskets.
- ▶ After assembly, insert a feeler gauge between the bell and spigot to ensure the gasket was not pushed/dislocated.

ADDITIONAL ASSEMBLY AND INSTALLATION NOTES:

- ▶ When installing **TR Flex® restrained joint pipe**, it is essential to maintain pressure on the bell until all the locking segments have been installed.
- ▶ For large diameter pipe, insert the bottom locking segments first, then the top.
- ▶ Pull out the slack in the joint to “lock” the restraint.
- ▶ After the pipe has been fully assembled, **deflection at the joint(s)** may be achieved as needed, staying within the manufacturer’s recommended maximum allowed per joint type and size.
- ▶ A full 5 degrees of deflection equals 19.1 inches for an 18’ pipe. However, a convenient rule of thumb is not to exceed 1” of deflection per foot of pipe lay length.
- ▶ For assistance, refer to the McWane Pocket Engineer (pe.mcwane.com) for deflection per joint and size.

The preceding tip sheet has been provided for your convenience. If you’d like to receive more in-depth, on-site, or virtual training, contact your local McWane Ductile professional at McWaneDuctile.com/Contact-Us/ or call 800-800-6013.

PROJECT PROFILES

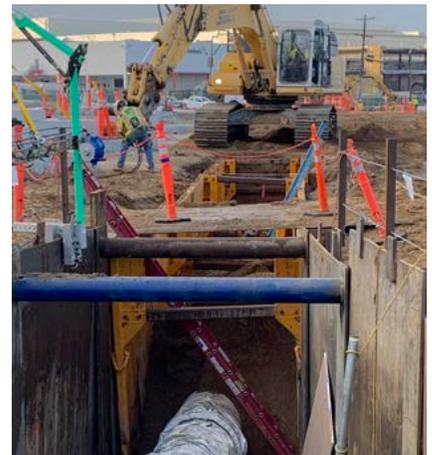


West PROJECT PROFILE

The Continental City Taxiway P Project utilizes the Storm Water Pollution Prevention Plan (SWPPP) to protect the environment while implementing improvements at the airport for the City of Los Angeles Department of Airports,

known as Los Angeles World Airports (LAWA). This project reconfigures traffic movement to accommodate the modernization programs and provide airfield improvements. The project aims to enhance security, efficiency and

effectiveness to keep the airport safe and secure. This is one of many LAWA projects for which McWane Ductile has supplied pipe.



Sales Region: West
Sales Representative: Carolyn Lopez
Project Location: Los Angeles, CA
Project Contractor: Griffith Co.
Project Distributor: R&D Mechanical

Types of Ductile iron pipe used on the project:

DIAMETER	JOINT	CLASS	FOOTAGE
8"	Tyton®	52	90
10"	Tyton®	52	109
16"	Tyton®	52	18
30"	Tyton®	52	772
30"	TR Flex®	52	1,184



Midwest

PROJECT PROFILE

As part of flood control updates, the City of Cedar Rapids is constructing a new bridge on Shaver Road as it crosses Cold Creek. The new bridge will provide an additional 8 feet of clearance over the waterway. The project will prevent the roadway’s closure during flood events and ensure access to numerous businesses in the adjacent low-lying area.

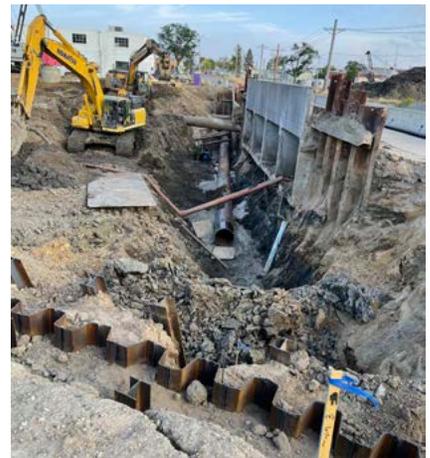
The first phase of the project includes rerouting water and sanitary sewer lines under Cold Creek and constructing a temporary bridge and box culvert. Using steel casing pipe, water and sewer lines penetrate a newly constructed flood wall. The sanitary sewer was designed to prevent buoyancy issues by utilizing double casing pipe, including concrete fill.

Boomerang Corporation, headquartered in Anamosa, Iowa was selected to

perform this work. Nearly 1,800 feet of sanitary sewer and 1,700 feet of waterline will be relocated as part of the project scope.

Justin Holland, Boomerang Project Manager, stated, “The main challenges

have been working with the constant water in the creek during construction. Occasional rains caused water levels to increase, providing additional obstacles.”



Sales Region: Midwest
Sales Representative: Chris Williams
Project Location: Cedar Rapids, IA
Project Owner/Utility: City of Cedar Rapids
Project Engineer: HDR – Cedar Rapids, IA
Project Contractor: Boomerang Corporation
Project Distributor: Schimberg Co.

Types of Ductile iron pipe used on the project:

DIAMETER	JOINT	CLASS	FOOTAGE
12"	Tyton®	52	670
24"	Tyton®	55	1,000
24"	TR Flex®	55	1,800

Sales Region: South

Sales Representative: Dustin Henderson

Project Location: Athens, AL

Project Owner/Utility: Limestone County Water & Sewer Authority

Project Engineer: CDG Engineering - Huntsville, AL

Project Contractor: Legacy Water Group

Types of Ductile iron pipe used on the project:

DIAMETER	JOINT	CLASS	FOOTAGE
8"	Tyton*	350	1,980
16"	Tyton*	350	9,400
24"	Tyton*	250	11,000



This project consisted of the installation of approximately 11,000 linear feet of 24-inch, 9,400 linear feet of 16-inch, and 1,800 LF of 8-inch Ductile iron water main; two open-cut creek crossings; six road crossings with casings ranging from 12-inch to 36-inch installed by both open-cut and jack-and-bore methods; relocation and connections of existing services; abandonment of existing mains; and all related items for a complete job. The project had a substantial completion of 240 days from notice to proceed and be done 30 days after the substantial completion date. The work was performed for a major road-widening project and

future development planned in the area. The widening project is designed to accommodate traffic heading to and from the new Mazda Toyota Manufacturing USA facility in southern Limestone County.

Legacy Water Group was able to take on the challenging schedule and complex installation in various project areas with ease. Two creek crossings on the part of the project required diverting the creek, encasing the pipe in concrete, and then restoring the original creek location. McWane Ductile and Legacy's longstanding relationship allowed us to work closely together to

keep schedules on track for a successful project outcome, even during the current supply chain strain.



PROJECT PROFILE

South





Northeast

PROJECT PROFILE

McWane Ductile teamed with Consolidated Pipe Supply and Cherokee Construction to tackle some 15,000 feet of 4-inch through 12-inch Tyton® 350 with Sure Stop 350™ gaskets on the Washington County Service

Authority Project, Galvanized Water Line Replacement Project Ph 3 Division 2B. This is the third phase of the 250,000-plus-foot replacement of a 50-plus-year-old galvanized water line.

Washington County decided to go with Ductile iron after much research as to the best value to serve the county for years to come.



Types of Ductile iron pipe used on the project:

DIAMETER	JOINT	CLASS	FOOTAGE
4"	Tyton®	350	5,000
6"	Tyton®	350	5,000
8"	Tyton®	350	5,000
12"	Tyton®	350	6,500
12"	TR Flex®	350	6,500

Sales Region: Northeast
Sales Representative: Todd Soady
Project Location: Virginia
Project Owner/Utility: Washington County, Virginia Service Authority
Project Contractor: Cherokee Construction Co.
Project Distributor: Consolidated Pipe Supply



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