

PART 1 - GENERAL

1.1 DESCRIPTION

- .1 This section specifies requirements for metal fabrications.

1.2 RELATED WORK SPECIFIED ELSEWHERE

- .1 SS Beam Installation Section 05 53 00.

1.3 REFERENCE STANDARDS

- .1 Do welding to AWS (American Welding Society) D1.6 - Structural Welding code - Stainless Steel unless specified otherwise.
- .2 316 stainless steel for structural and other shapes shall conform to ASTM A276 - Standard Specification for Stainless Steel Bars and Shapes.

1.4 SHOP DRAWINGS

- .1 Submit shop drawings in accordance with Section 01 33 00.
- .2 Clearly indicate materials, core thickness, finishes, connections, joints, method of anchorage, number of anchors, supports, reinforcements, details and accessories.

1.5 MEASUREMENT FOR PAYMENT

- .1 Stainless Steel Pump Collars: as specified including all plant, material, labour and equipment will constitute lump sum price for measurement purposes and shall be included in the lump sum portion on the Bid and Acceptance form.
 - .1 Include incidental to this work all costs associated with the supply and installation of collars, pumps and Canada supplied hoses in their final shaft locations.

PART 2 - PRODUCTS

2.1 MATERIALS

- .1 316 Stainless Steel Sections and Plates: to ASTM A276.

- .2 Welding Materials: to AWS D1.6.
- .3 Bolting: stud bolts to ASTM A193, Gr. B8 and nuts to ASTM A194, Gr. B8.

2.2 FABRICATION

- .1 Field check all dimensions, elevations, etc., prior to fabrication of pump collars, existing pumps are located at NAFC facility, 80 East White Hills road.
- .2 Fabricate items from 316 stainless steel as specified.

PART 3 - EXECUTION

3.1 INSTALLATION

- .1 Prior to shop drawing submittal and collar fabrication contractor shall inspect the existing ss Flygt pumps to ensure that the new collars are fitted and constructed to suit and any modifications to the proposed design shall be submitted to the DR for approval prior to fabrication.
- 2. Install metal fabrications as detailed and in locations indicated on the drawings.
- 3. Remove existing four (4) Flygt pumps and install new ss Flygt pumps in the same general location within the shaft as directed by DR.
- 4. Contractor shall remove existing 75 mm hard wall hoses and reinstall these from the upper pumps to the pipe line connection points and install new flexible hoses from the bottom pumps to the upper pumps.
Note; All hoses and clamps are Canada supplied.
- 5. Contractor shall supply and install 316 SS cable grips along the pump power cables and anchored to existing rock bolts in the shaft wall as follows;
Two grips required for each bottom pump, one at the shaft exit point and one at the 4 meter elevation point.
One grip required for each top pump at the shaft exit point.