

1 GENERAL

1.01 RELATED REQUIREMENTS

1.02 REFERENCES

- .1 ASTM International
 - .1 ASTM A 53/A 53M-07, Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless.
 - .2 ASTM A 269-08, Standard Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service.
 - .3 ASTM A 307-07b, Standard Specification for Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength.
- .2 CSA International
 - .1 CSA G40.20/G40.21-04(R2009), General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steel.
 - .2 CAN/CSA G164-M92(R2003), Hot Dip Galvanizing of Irregularly Shaped Articles.
 - .3 CSA S16-09, Design of Steel Structures.
 - .4 CSA W48-06, Filler Metals and Allied Materials for Metal Arc Welding (Developed in co-operation with the Canadian Welding Bureau).
 - .5 CSA W59-M03(R2008), Welded Steel Construction (Metal Arc Welding) Metric.
- .4 Environmental Choice Program
 - .1 CCD-047-98(R2005), Architectural Surface Coatings.
 - .2 CCD-048-98(R2006), Surface Coatings - Recycled Water-borne.
- .5 Green Seal Environmental Standards (GS)
 - .1 GS-11-2008, 2nd Edition, Paints and Coatings.
- .6 Health Canada / Workplace Hazardous Materials Information System (WHMIS)
 - .1 Material Safety Data Sheets (MSDS).
- .7 The Master Painters Institute (MPI)
 - .1 Architectural Painting Specification Manual - current edition.

1.03 ACTION AND INFORMATIONAL SUBMITTALS

- .1 Submit in accordance with Section 01 33 00 - Submittal Procedures.
- .2 Product Data:
 - .1 Submit manufacturer's instructions, printed product literature and data sheets for sections, plates, pipe, tubing, bolts, and include product characteristics, performance criteria, physical size, finish and limitations.
 - .2 Submit two copies of WHMIS MSDS in accordance with Section 01 35 29.06 - Health and Safety Requirements, 01 35 44 - Environmental Procedures for Marine Work.

- .1 For finishes, coatings, primers, and paints applied on site: indicate VOC concentration in g/L.
- .3 Shop Drawings:
 - .1 Submit drawings stamped and signed by professional engineer registered or licensed in Province of New Brunswick, Canada.
 - .2 Indicate materials, core thicknesses, finishes, connections, joints, method of anchorage, number of anchors, supports, reinforcement, details, and accessories.

1.04 QUALITY ASSURANCE

- .1 Test Reports: submit certified test reports showing compliance with specified performance characteristics and physical properties.
- .2 Certifications: submit product certificates signed by manufacturer certifying materials comply with specified performance characteristics and criteria and physical requirements.

1.05 DELIVERY, STORAGE AND HANDLING

- .1 Deliver, store and handle materials in accordance with Section 01 61 00 - Common Product Requirements and with manufacturer's written instructions.
- .2 Delivery and Acceptance Requirements: deliver materials to site in original factory packaging, labeled with manufacturer's name and address.
- .3 Storage and Handling Requirements:
 - .1 Store materials off ground, in dry location and in accordance with manufacturer's recommendations in clean, dry, well-ventilated area.
 - .2 Replace defective or damaged materials with new.
- .4 Packaging Waste Management: in accordance with Section 01 74 21 - Construction/Demolition Waste Management and Disposal.

2 PRODUCTS

2.01 MATERIALS UNLESS SPECIFIED DIFFERENTLY IN THE STATEMENT OF WORK.

- .1 Steel sections and plates: to CSA G40.20/G40.21, Grade 300W.
- .2 Steel pipe: to ASTM A 53/A 53M.
- .3 Welding materials: to CSA W59.
- .4 Welding electrodes: to CSA W48 Series.
- .5 Bolts and anchor bolts: to ASTM A 307.
- .7 Machine bolts, holdfasts, ladder rungs, anchor bolts, nuts, washers: to ASTM A307-83a.
- .8 Tie Rods: Hot rolled threaded bar, 517 MPa minimum yield as manufactured by Williams Form Engineering corp or approved equal complete with the connectors and nuts

by same manufacturer.

- .9 Cast Iron: to ASTM-74.
- .10 Steel Pipe: to ASTM-A53.
- .12 Machine Bolts:
 - .1 Machine Bolts will have standard heads, nuts, and threads and when in position will be of sufficient length to permit a full nut and two washers. Threads shall be the Coarse Thread Series as specified in the latest issue of ANSI B1-1 having a Class 2A tolerance.
 - .2 Standard plate washers to be three times bolt diameter and a minimum thickness of 8mm unless notes otherwise.

2.02 FABRICATION

- .1 Fabricate work square, true, straight and accurate to required size, with joints closely fitted and properly secured.
- .2 Use self-tapping shake-proof flat headed screws on items requiring assembly by screws or as indicated.
- .3 Where possible, fit and shop assemble work, ready for erection.
- .4 Ensure exposed welds are continuous for length of each joint. File or grind exposed welds smooth and flush.
- .5 The fabrication of all structural steel shall conform to the requirements of CSA CAN3-S16.1-M78.

2.03 FINISHES

- .1 Galvanizing: hot dipped galvanizing with zinc coating 600 g/m² to CAN/CSA-G164.
- .2 Chromium plating: chrome on steel with plating sequence of 0.009 mm thickness of copper 0.010 mm thickness of nickel and 0.0025 mm thickness of chromium.

2.04 ISOLATION COATING

- .1 Isolate aluminum from following components, by means of bituminous paint:
 - .1 Dissimilar metals except stainless steel, zinc, or white bronze of small area.
 - .2 Concrete, mortar and masonry.
 - .3 Wood.

2.05 SHOP PAINTING

- .1 Primer: VOC limit 250 g/L maximum to GS-11.
- .2 Apply one shop coat of primer to metal items, with exception of galvanized or concrete encased items.

- .3 Use primer unadulterated, as prepared by manufacturer. Paint on dry surfaces, free from rust, scale, grease. Do not paint when temperature is lower than 7 degrees C.
- .4 Clean surfaces to be field welded; do not paint.

2.06 ANGLE LINTELS

- .1 Steel angles: galvanized, sizes indicated for openings. Provide 150 mm minimum bearing at ends.
- .2 Weld or bolt back-to-back angles to profiles as indicated.
- .3 Finish: shop painted.
 - .1 Primer: VOC limit 250 g/L maximum to GS-11 when applied onsite.

3 EXECUTION

3.01 EXAMINATION

- .1 Verification of Conditions: verify conditions of substrates previously installed under other Sections or Contracts are acceptable for metal fabrications installation in accordance with manufacturer's written instructions.
 - .1 Visually inspect substrate in presence of Departmental Representative.
 - .2 Inform Departmental Representative of unacceptable conditions immediately upon discovery.
 - .3 Proceed with installation only after unacceptable conditions have been remedied and after receipt of written approval to proceed from Departmental Representative.

3.02 ERECTION

- .1 Do welding work in accordance with CSA W59 unless specified otherwise.
- .2 Erect metalwork square, plumb, straight, and true, accurately fitted, with tight joints and intersections.
- .3 Provide suitable means of anchorage acceptable to Departmental Representative such as dowels, anchor clips, bar anchors, expansion bolts and shields, and toggles.
- .4 Exposed fastening devices to match finish and be compatible with material through which they pass.
- .5 Supply components for work by other trades in accordance with shop drawings and schedule.
- .6 Make field connections with bolts to CSA S16.
- .7 Touch-up rivets, field welds, bolts and burnt or scratched surfaces with primer after completion of:
 - .1 Primer: maximum VOC limit 250 g/L to GS-11.
- .8 Touch-up galvanized surfaces with zinc rich primer where burned by field welding.

- .1 Primer: maximum VOC limit 250 g/L to GS-11.

3.03 INSTALLATION OF MACHINE BOLTS, SPIKES, WASHERS, NUTS

- .1 Machine Bolts will have standard heads, nuts and threads, and when in position will be of sufficient length to permit full nut and two washers. Holes for machine bolts will be bored to the same diameter as that of the bolts.
- .2 Machine Bolts will be placed in the work with their heads on the outside. The heads of machine bolts that interfere with succeeding parts of the work being placed, or where directed by the Departmental Representative or shown on the drawings will be countersunk.
- .3 Standard steel washers of the sizes indicated will be placed under the heads and nuts of all machine bolts bearing on timber surfaces, except where specified otherwise.
- .4 Where indicated, use steel washers of size shown.
- .5 Holes for anchor dowels will be bored 1.5mm smaller diameter than anchor dowel.

3.04 CLEANING

- .1 Progress Cleaning: clean in accordance with Section 01 74 11 - Cleaning.
.1 Leave Work area clean at end of each day.
- .2 Final Cleaning: upon completion remove surplus materials, rubbish, tools and equipment in accordance with Section 01 74 11 - Cleaning.

3.05 PROTECTION

- .1 Protect installed products and components from damage during construction.
- .2 Repair damage to adjacent materials caused by metal fabrications installation.

END OF SECTION