

Wharf Extension**Eastern Passage****Halifax County, Nova Scotia****Project No. R.082417.001**

Metal Fabrication

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PART 1 - GENERAL1.1 Reference
Standards

- .1 CAN/CSA-G40.21-M92 (or latest edition), Structural Quality Steels.
- .2 CSA W59-M1989 (or latest edition), Welded Steel Construction (Metal Arc Welding).
- .3 ASTM A307-94 (or latest edition), Specification for Carbon Steel Bolts and Studs, 60,000 psi Tensile.
- .4 CAN/CSA-G164-M92 (or latest edition) - Hot Dip Galvanizing of Irregularly Shaped Articles.
- .5 CAN/CGSB-1.181-92 (or latest edition), Ready-Mixed Organic Zinc-Rich Coating.
- .5 CAN/CSA-S16.1-94 (or latest edition), Limit States Design of Steel Structures.

1.2 Shop Drawings

- .1 Submit shop drawings in accordance with **Section 01 33 00**.
- .2 Indicate materials, core thicknesses, finishes, connections, joint, method of anchorage, number of anchors, supports, reinforcement, details and accessories.

1.3 Measurement
for Payment

- .1 Measurement for payment will be in accordance with **Section 01 29 00**.

PART 2 - PRODUCTS2.1 Materials

- .1 Steel Sections: to CAN3-G40.21, Grade 350W.
- .2 Steel plate and angles: to CAN3-G40.21, Grade 350W.
- .3 Welding materials: to CSA W59.
- .4 Bolts and anchor bolts: to ASTM A307.
- .5 Galvanizing: hot dipped galvanizing with zinc coating 600 g/m² to CSA G164.

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| | .6 | Zinc primer: Zinc rich, ready mix to CGSB 1-GP-181. |
| 2.2 <u>Fabrication</u> | .1 | Build work square, true, straight and accurate to required size, with joints closely fitted and properly secured. |
| | .2 | Fabricate items from steel unless otherwise noted. |
| | .3 | Where possible, fit and shop assemble work, ready for installation. |
| | .4 | Ensure exposed welds are continuous for length. |
| 2.3 <u>Miscellaneous Metal Work Items</u> | .1 | Miscellaneous anchors, bolts and inserts: |
| | .1 | Where size, spacing and the like are not indicated, provide as necessary for the purpose. |
| | .2 | Galvanize all miscellaneous anchors, bolts and inserts. |
| | .2 | Miscellaneous Steel: |
| | .1 | Provide miscellaneous steel as required for guide units and the like to the shape, size and details required. |
| | .2 | Galvanize all miscellaneous steel items. |

PART 3 - EXECUTION

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| 3.1 <u>Erection</u> | .1 | Install metalwork square, plumb, straight and true, accurately fitted, with tight joints and intersections. |
| | .2 | Make field connections with bolts to CAN/CSA-S16.1, or weld. |
| | .3 | Touch-up bolts and scratched surfaces after completion of erection with zinc primer. |
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