

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

Metal Fabrication

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PART 1 - GENERAL

- 1.1 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 - PRODUCTS

- 2.1 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 Fabrication
- .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 Miscellaneous Metal Work Items
- .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

- 3.1 Erection
- .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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