

1 GENERAL

1.01 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.
- .3 Environmental Choice Program
 - .1 CCD-047-98(R2005), Architectural Surface Coatings.
 - .2 CCD-048-98(R2006), Surface Coatings - Recycled Water-borne.
- .4 Green Seal Environmental Standards (GS)
 - .1 GS-11-2008, 2nd Edition, Paints and Coatings.
- .5 Health Canada / Workplace Hazardous Materials Information System (WHMIS)
 - .1 Material Safety Data Sheets (MSDS).
- .6 The Master Painters Institute (MPI)
 - .1 Architectural Painting Specification Manual - current edition.

1.02 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, and 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 and 01 35 43 - Environmental Procedures.
 - .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 Prince Edward Island, Canada.
 - .2 Indicate materials, core thicknesses, finishes, connections, joints, method of anchorage, number of anchors, supports, reinforcement, details, and accessories.

1.03 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.

1.04 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, labelled with manufacturer's name and address.
- .3 Storage and Handling Requirements:
 - .1 Store materials in accordance with manufacturer's recommendations in clean, dry, well-ventilated area.
 - .2 Replace defective or damaged materials with new.
- .4 Develop Waste Reduction Workplan related to Work of this Section and in accordance with Section 01 74 21 - Construction/Demolition Waste Management and Disposal.
- .5 Packaging Waste Management: remove for reuse and return by manufacturer of pallets, crates, padding, and packaging materials as specified in Waste Reduction Workplan in accordance with Section 01 74 21 - Construction/Demolition Waste Management and Disposal.

2 PRODUCTS

2.01 MATERIALS

- .1 Steel sections and plates: to CSA G40.20/G40.21, Grade 300W.
- .2 Steel pipe: to ASTM A 53/A 53M standard weight, galvanized finish.
- .3 Welding materials: to CSA W59.
- .4 Welding electrodes: to CSA W48 Series.

- .5 Bolts and anchor bolts: to ASTM A 307.
- .6 Aluminum sheet: proprietary utility sheet pattern.
- .7 Stainless steel tubing: to ASTM A 269, Type 302 commercial grade.
- .8 Grout: non-shrink, non-metallic, flowable, 15 MPa at 24 hours.

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.

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.
- .3 Shop coat primer: in accordance with chemical component limits and restrictions requirements and VOC limits of CCD-047a.
- .4 Zinc primer: zinc rich, ready mix to MPI-INT 5.2C in accordance with chemical component limits and restrictions requirements and VOC limits of CCD-047a.

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 CCD-047a.
- .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.

2.07 PIPE RAILINGS

- .1 Steel pipe: formed to shapes and sizes as indicated.
- .2 Galvanize exterior and interior pipe railings after fabrication. Shop coat prime interior railings after fabrication.

2.08 CORNER GUARDS

- .1 Galvanized finish for exterior, prime paint for interior.
 - .1 Primer: maximum VOC limit 250 g/L to GS-11 when applied onsite.

2.09 TRENCH COVERS AND FRAMES

- .1 Steel fabricate from 6 mm thick raised pattern plate set in L 55 x 55 x 6 frame. Include anchors at 1200 mm on centre for embedding in concrete. Supply trench covers in 1200 mm removable lengths.
- .2 Finish: galvanized prime coat painted.
 - .1 Primer: maximum VOC limit 250 g/L to GS-11 when applied onsite.

2.10 CHANNEL FRAMES

- .1 Fabricate frames from steel, sizes of channel and opening as indicated.
- .2 Weld channels together to form continuous frame for jambs and head of openings, sizes as indicated.
- .3 Finish: galvanized.

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 or Weld field connection.
- .7 Deliver items over for casting into concrete and building into masonry together with setting templates to appropriate location and construction personnel.
- .8 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.
- .9 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 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 Waste Management: separate waste materials for reuse and recycling in accordance with Section 01 74 21 - Construction/Demolition Waste Management and Disposal
 - .1 Remove recycling containers and bins from site and dispose of materials at appropriate facility.

3.04 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