

Approved: 2010-06-30

Part 1 General

1.1 RELATED REQUIREMENTS

- .1 Section 13 34 19 – Metal Buildings Systems.

1.2 REFERENCES

- .1 ASTM International
 - .1 ASTM A53/A53M-12, Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless.
 - .2 ASTM A269-15a, Standard Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service.
 - .3 ASTM A307-14, Standard Specification for Carbon Steel Bolts and Studs, and Threaded Rod 60,000 PSI Tensile Strength.
 - .4 ASTM A325M-14, Standard Specification for Structural Bolts, Steel, Heat Treated 120/105 Ksi Minimum Tensile Strength.
- .2 CSA International
 - .1 CSA G40.20/G40.21-13, 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 S16-14, Design of Steel Structures.
 - .4 CSA W48-14, Filler Metals and Allied Materials for Metal Arc Welding (Developed in co-operation with the Canadian Welding Bureau).
 - .5 CSA W59-13, Welded Steel Construction (Metal Arc Welding).
- .3 Health Canada / Workplace Hazardous Materials Information System (WHMIS)
 - .1 Material Safety Data Sheets (MSDS).
- .4 The Master Painters Institute (MPI)
 - .1 Architectural Painting Specification Manual.

1.3 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.
- .3 Shop Drawings:
 - .1 Submit drawings stamped and signed by professional engineer registered or licensed in Manitoba, Canada.

- .2 Indicate materials, core thicknesses, finishes, connections, joints, method of anchorage, number of anchors, supports, reinforcement, details, and accessories.

1.4 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.

1.5 DELIVERY, STORAGE AND HANDLING

- .1 Deliver, store and handle materials in accordance 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 off ground and in accordance with manufacturer's recommendations in clean, dry, well-ventilated area.
 - .2 Replace defective or damaged materials with new.

Part 2 Products

2.1 MATERIALS

- .1 Steel sections: to CSA G40.20/G40.21, Grade 350W.
- .2 Steel plates: to CSA G40.20/G40.21, Grade 300W.
- .3 Steel pipe: to ASTM A53/A53M standard weight, galvanized finish.
- .4 Welding materials: to CSA W59.
- .5 Welding electrodes: to CSA W48 Series.
- .6 Structural Bolts: to ASTM A325.
- .7 Anchor Bolts: to ASTM A307.
- .8 Stainless steel tubing: to ASTM A269, Type 302.
- .9 Grout: non-shrink, non-metallic, flowable, 15 MPa at 24 hours.

2.2 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 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.

2.3 FINISHES

- .1 Galvanizing: hot dipped galvanizing with zinc coating 600 g/m² to CAN/CSA-G164.

2.4 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.

2.5 SHOP PAINTING

- .1 Apply one shop coat of primer to metal items, with exception of galvanized items, unless noted otherwise.
- .2 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.
- .3 Clean surfaces to be field welded; do not paint.

Part 3 Execution

3.1 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 Inform DFO Representative of unacceptable conditions immediately upon discovery.
 - .2 Proceed with installation only after unacceptable conditions have been remedied.

3.2 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.
- .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 Touch-up rivets, field welds, bolts and burnt or scratched surfaces with primer after completion.

3.3 CLEANING

- .1 Leave Work area clean at end of each day.
- .2 Final Cleaning: upon completion remove surplus materials, rubbish, tools and equipment.

3.4 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