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- requirements of CSA-W47.1, Division 1 or 2.1 or CSA-W47.2.
- .2 Provide written procedures to Departmental Representative for review and approval indicating methods to be used for all welding on this project.
- .3 Provide evidence to the Department Representative of current qualifications of welders.
- 1.6 Procedure and Welder Qualification for Underwater Welding
- .1 No underwater welding is to proceed until qualification of welding procedure and performance qualifications to Section 5, "Qualification" and verification of procedure and performance qualification to Section 6, "Inspection" as per AWS D3.6M, has taken place.
- .2 Contractor is responsible to provide satisfactory evidence to the Departmental Representative that the procedure and welders have been qualified and a verification of procedure and performance qualification has been carried out. No production welding is to be done prior to this submission being approved by the Departmental Representative.
- 1.7 Shop Drawings
- .1 Submit fabrication and erection documents and material lists in accordance with Section 01 33 00 Submittal Procedures.
- .2 It is the responsibility of this Contractor to field confirm the exact locations and construction of related work to which work under this section connects to, or is supported on.
- .3 Each drawing submission shall bear signature and stamp of qualified Professional Engineer registered or licensed to practice in the Province of New Brunswick, for all assemblies, components, details and connections not shown on the drawings.
- .4 Review of procedure and erection drawings will extend to general design concept only. This review does not relieve the Contractor of the responsibility for accuracy of the detail dimensions, general fit-up of parts to be assembled, adequacy of proposed methods and



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- .7 Welding Electrodes (above water): to CSA W48 Series.
  - .8 Structural Bolts, nuts and washers: to ASTM F3125, grade A325.
  - .9 Threaded anchor rods, nuts and washers: to ASTM A307.
  - .10 Galvanizing: Hot Dip to ASTM A123/A123M. (610g/m<sup>2</sup>).
  - .11 Galvanizing Touch-Up/Repair:
    - .1 Touch-up galvanizing for repair to damaged galvanized surfaces shall be with a purpose-made cold-applied film galvanizing system consisting of zinc powder, aromatic hydrocarbon and binder. Coating system to meet the following minimum requirements:
      - .1 Dry film content 96% by weight with zinc purity of 99.995% to ISO 3549.
      - .2 Recognized for use as repair coating for hot-dip galvanizing.
      - .3 Dry film non-toxic to AS/NSZ 4020.
      - .4 UV resistant.
- 2.2    Fabrication - General
- .1 Fabricate work square, true, straight and accurate to required size, with joints closely fitted and properly secured.
  - .2 Where possible, fit and shop assemble work, ready for erection.
  - .3 Ensure exposed welds are continuous for length of each joint. File or grind exposed welds smooth and flush.
  - .4 Provide adequate drainage at low points of all closed sections. Indicate drain hole locations on shop drawings.



will not augment or replace Contractor's quality control nor relieve him of his contractual responsibility.

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END OF SECTION

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