

Wharf Reconstruction**Chebogue****Yarmouth County, Nova Scotia****Project No. R.100885.001**

Metal Fabrication

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PART 1 - GENERAL

- 1.1 Reference Standards
- .1 ASTM A123/A123M-17, Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products.
 - .2 ASTM A307-14e1, Standard Specification for Carbon Steel Bolts, Studs, and Threaded Rod 60,000 psi Tensile Strength.
 - .3 CSA G40.20/G40.21-13 (R2018), General Requirements for Rolled or Welded Structural Quality Steel/Structural Quality Steel.
 - .4 CSA S16-14, Design of Steel Structures.
 - .5 CSA W59-18, Welded Steel Construction.
 - .6 CAN/CGSB-1.181-99, Ready-Mixed Organic Zinc-Rich Coating.
- 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 plate, angles, threaded rods and rods: to CSA G40.20/G40.21, Grade 300W.
 - .2 Welding materials: to CSA W59.
 - .3 Bolts and anchor bolts: to ASTM A307.
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- .4 Galvanizing: hot dipped galvanizing with zinc coating 600 g/m² to ASTM A123/A123M.
- .5 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 CSA S16, or weld.
- .3 Touch-up bolts and scratched surfaces after completion of erection with zinc primer.
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