
METAL FABRICATIONS

Floating Dock Construction
SAR Station, Twillingate, NL
Project No. R.089926.008

Section 05 50 00
Page 1 of 6
March 2021

PART 1 - GENERAL

1.1 RELATED SECTIONS

- .1 Section 01 33 00 - Submittal Procedures.
- .2 Section 31 53 16 - Structural Timber.

1.2 REFERENCES

- .1 American Society for Testing and Materials International, (ASTM)
 - .1 ASTM A 53/A53M-latest edition, Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless.
 - .2 ASTM A 269-latest edition, Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service.
 - .3 ASTM A307-latest edition, Standard Specification for Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength.
- .2 Canadian Standards Association (CSA International)
 - .1 CAN/CSA-G40.20/G40.21-latest edition, General Requirements for Rolled or Welded Structural Quality Steel.
 - .2 CAN/CSA-G164-latest edition, Hot Dip Galvanizing of Irregularly Shaped Articles.
 - .3 CAN/CSA-S16-latest edition, Limit States Design of Steel Structures.
 - .4 CSA W48-latest edition, Filler Metals and Allied Materials for Metal Arc Welding (Developed in co-operation with the Canadian Welding Bureau).
 - .5 CSA W59-latest edition, Welded Steel Construction (Metal Arc Welding).

METAL FABRICATIONS

Floating Dock Construction
SAR Station, Twillingate, NL
Project No. R.089926.008

Section 05 50 00
Page 2 of 6
March 2021

1.3 SUBMITTALS

- .1 Product Data:
 - .1 Submit manufacturer's printed product literature, specifications and data sheet in accordance with Section 01 33 00 - Submittal Procedures.
 - .2 Submit two copies of WHMIS MSDS - Material Safety Data Sheets in accordance with Section 01 33 00 - Submittal Procedures. Indicate VOC's:
 - .1 For finishes, coatings, primers and paints.
- .2 Shop Drawings
 - .1 Submit shop drawings in accordance with Section 01 33 00 - Submittal Procedures.
 - .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: Certified test reports showing compliance with specified performance characteristics and physical properties.
- .2 Certificates: Product certificates signed by manufacturer certifying materials comply with specified performance characteristics and criteria and physical requirements.

METAL FABRICATIONS

Floating Dock Construction
SAR Station, Twillingate, NL
Project No. R.089926.008

Section 05 50 00
Page 3 of 6
March 2021

1.5 DELIVERY, STORAGE, .1
AND HANDLING

Packing, Shipping, Handling and
Unloading:

.1 Deliver, store, handle and
protect materials in accordance with
Section 01 61 00 - Common Product
Requirements.

.2 Storage and Protection:

.1 Cover exposed stainless steel
surfaces with pressure sensitive
heavy protection paper or apply
strippable plastic coating, before
shipping to job site.

.2 Leave protective covering in
place until final cleaning of
building. Provide instructions for
removal of protective covering.

PART 2 - PRODUCTS

2.1 MATERIALS

- .1 Steel sections and plates: to
CAN/CSA-G40.20/G40.21, Grade 300W or
better, galvanized finish.
- .2 Welding materials: to CSA W59.
- .3 Welding electrodes: to CSA W48
Series.
- .4 Bolts and anchor bolts: to ASTM A307.

2.2 FABRICATION

- .1 Fabricate work square, true, straight
and accurate to required size, with
joints closely fitted and properly
secured.
- .2 Use flat headed screws on items
requiring assembly by screws or as
indicated.
- .3 Where possible, fit and shop assemble

METAL FABRICATIONS

Floating Dock Construction
SAR Station, Twillingate, NL
Project No. R.089926.008

Section 05 50 00
Page 4 of 6
March 2021

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 600g/m² to CSA G164. All steel used shall be hot dipped galvanized.

2.4 SHOP PAINTING

- .1 Not required.

2.5 STEEL H-PILE GUIDES

- .1 Steel H-Pile Guides and Floating Dock Attachment to H-Pile Guide: sizes and shapes as indicated.
- .2 Galvanize all steel in H-Pile guide and floating dock attachment to H-Pile guide after fabrication.
- .3 All hardware shall be galvanized.

2.6 DOCK TO DOCK FLIP PLATE

- .1 Dock to Dock Flip Plate: sizes and shapes as indicated.
- .2 All connection plates shall be galvanized.
- .3 All hardware shall be galvanized.

PART 3 - EXECUTION

3.1 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.

METAL FABRICATIONS

Floating Dock Construction
SAR Station, Twillingate, NL
Project No. R.089926.008

Section 05 50 00
Page 5 of 6
March 2021

- .3 Exposed fastening devices to match finish and be compatible with material through which they pass.
- .4 Make field connections with bolts to CAN/CSA-S16.1, or weld.
- .5 Hand items over for casting into concrete or building into masonry to appropriate trades together with setting templates.
- .6 Touch-up rivets, field welds, bolts and burnt or scratched surfaces after completion of erection with primer.
- .7 Touch-up galvanized surfaces with zinc rich primer where burned by field welding.

3.2 STEEL H-PILE
GUIDES

- .1 Install new galvanized steel H-Pile guide and attachment of floating dock to H-Pile guide as indicated.

3.3 DOCK TO DOCK FLIP
PLATE

- .1 Install new galvanized flip plate between floating docks as indicated.

3.4 CLEANING

- .1 Perform cleaning after installation to remove construction and accumulated environmental dirt.
- .2 Upon completion of installation, remove surplus materials, rubbish, tools and equipment barriers.

METAL FABRICATIONS

Floating Dock Construction
SAR Station, Twillingate, NL
Project No. R.089926.008

Section 05 50 00
Page 6 of 6
March 2021

END OF SECTION