

PART 1 - GENERAL

- 1.1 RELATED SECTIONS
- .1 Section 01 33 00 - Submittal Procedures.
  - .2 Section 03 30 00 - Cast-in-Place Concrete.
- 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, Specification for Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength.
  - .2 Canadian General Standards Board (CGSB)
    - .1 CAN/CGSB-1.40-latest edition, Anti-corrosive Structural Steel Alkyd Primer.
    - .2 CAN/CGSB-1.181-latest edition, Ready-Mixed, Organic Zinc-Rich Coating.
  - .3 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-S16.1-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).

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.

- 1.5 DELIVERY, STORAGE, AND HANDLING .1 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 A 307.  
.5 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 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.

### 2.3 FINISHES

- .1 Galvanizing: hot dipped galvanizing with zinc coating 600g/m<sup>2</sup> to CAN/CSA-G164. All steel used shall be hot dipped galvanized.
- .2 Shop coat primer: to CAN/CGSB-1.40.
- .3 Zinc primer: zinc rich, ready mix to CAN/CGSB-1.181.

### 2.4 SHOP PAINTING

- .1 Apply one shop coat of primer to metal items, with exception of galvanized or concrete encased items.
- .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.

### 2.5 STEEL EDGE ANGLE

- .1 Steel Edge Angle: sizes and shapes as indicated.
- .2 Galvanize steel edge angle after fabrication.

### 2.6 GANGWAY PINTLE HOOK/DOCK CONNECTION PLATE/FLIP PLATE

- .1 Gangway pintle hook/dock connection plate/flip plate: sizes and shapes as indicated.

- .2 Galvanize gangway pintle hook/dock connection plate/flip plate after fabrication.

2.7 STEEL  
EYEBOLTS/CHAIN ANCHOR

- .1 Steel eyebolts/chain anchors and associated hardware: sizes as indicated.
- .2 All steel eyebolts/chain anchors and associated hardware shall be galvanized.

2.8 STEEL GAP PLATES

- .1 Steel gap plates: sizes and shapes as indicated.
- .2 Steel gap plates shall be galvanized.

2.9 STEEL CHAIN

- .1 Steel chain: sizes as indicated.
- .2 All steel chain and associated 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.
- .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 EDGE ANGLE

- .1 Install new galvanized steel edge angle in reinforced concrete deck as indicated.

3.3 GANGWAY PINTLE HOOK/DOCK CONNECTION PLATE/FLIP PLATE

- .1 Install new galvanized steel gangway pintle hook/dock connection plate/flip plate at the top of the gangway as indicated.

3.4 STEEL EYEBOLTS/CHAIN ANCHORS

- .1 Install new galvanized steel eyebolts/chain anchors in locations as indicated.

3.5 STEEL GAP PLATES

- .1 Install new galvanized steel gap plates between docks as indicated.

3.6 STEEL CHAIN

- .1 Install new galvanized steel chain as indicated.

3.7 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.