

Wharf Reconstruction – Phase 2**Structure 408****Val-Comeau, New Brunswick****Project No. R.097242.003**

Metal Fabrications

PART 1 – GENERAL1.1 Reference Standards

- .1 ASTM A123/A123M-17, Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products.
- .2 ASTM A307-14e1, Specification for Carbon Steel Bolts, Studs, and Threaded Rod 60,000 psi Tensile Strength.
- .3 CSA G40.20-13 / G40.21-13, 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 CSA S157-17, Strength Design in Aluminum.
- .7 CSA W59.2-18, Welded Aluminum Construction.
- .8 ASTM A722/A722M-18 – Standard Specification for High-Strength Steel Bars for Prestressed Concrete.

1.2 Related Work

- .1 Refer to other Specification Sections for related information.
- .2 Refer to Section 01 33 00 for Shop Drawings/ Submissions requirements.

1.3 Shop Drawings

- .1 Submit shop drawings in accordance with Section 01 33 00.
- .2 Shop Drawings:
 - .1 Clearly indicate the following items:
 - .1 General arrangements, dimensions, clearance locations and directions of assemblies as installed on structures.
 - .2 Locations, sizes and installation tolerances of anchor bolts, eye bolts and embedded parts.
 - .3 Types of materials used, finishes and core thickness.
 - .4 All other pertinent details and accessories.
- .3 Test Results:
 - .1 Provide test results for the galvanized items.

Wharf Reconstruction – Phase 2**Structure 408****Val-Comeau, New Brunswick****Project No. R.097242.003**

Metal Fabrications

- .4 Submissions
 - .1 Provide submissions in accordance with Section 01 33 00.

PART 2 – PRODUCTS2.1 Materials

- .1 Steel sections: to CSA G40.21, Grade 350W.
- .2 Steel rod, plate and angles: to CSA G40.21, Grade 300W.
- .3 Steel angles for panel support clips: to CSA G40.21, Grade 350W.
- .4 Welding materials: to CSA W59.
- .5 Bolts and anchor bolts: to ASTM A307.
- .6 Galvanizing: hot dipped galvanizing with zinc coating 610 g/m² to ASTM A123. All hardware to be galvanized unless otherwise noted on the drawings.
- .7 Zinc primer: Zinc rich, ready mix to ASTM 123.
- .8 Do not use items manufactured or fabricated from scrap steel of unknown chemical composition or physical properties.
- .9 For adhesive anchors see Cast-in-Place concrete, Section 03 30 00.
- .10 Steel Tie Rods:
 - .1 Substitute different size or strength of tie rods only if permitted in writing by Departmental Representative.
 - .2 Tie rod shall conform to ASTMA722/A722M, minimum yield strength of 827 MPa, unless indicated otherwise.
- .11 Aluminum to consist of 6061-T6 marine alloy.
- .12 Welding of aluminum to be mig welding with S356 filling alloy in accordance with CSA W47.2.

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.

Wharf Reconstruction – Phase 2**Structure 408****Val-Comeau, New Brunswick****Project No. R.097242.003**

Metal Fabrications

- .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 shape, size and details required.
 - .2 Galvanize all miscellaneous steel items.

PART 3 – EXECUTION3.1 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.

3.2 Steel Tie Rods

- .1 Tie rods to be installed as shown on structural drawings.
- .2 Do not place backfill behind concrete wall panel bulkhead until steel piles have been completely driven and secured in final position by the anchorage system, until concrete wall panels have been installed and adjusted, and until anchor wall has achieved the 28-day strength.
- .3 Fit and adjust the tie rod systems so that the connections at the steel H piles and anchor wall are tight before commencing backfilling.
- .4 Prior to backfilling, contractor to ensure the surroundings of the backfill area have been completely enclosed in accordance with the structural drawings and to obtain a written approval from the Departmental Representative.

Wharf Reconstruction – Phase 2

Structure 408

Val-Comeau, New Brunswick

Project No. R.097242.003

Metal Fabrications

.5 Contractor shall provide temporary supports for tie rods during backfilling and replacing any tie rod that is damaged during backfilling at no extra cost.

.6 Contractor shall protect tie rod threads from damage during handling and installation. Tie rods with damaged threads will be rejected.

3.3 Dissimilar Metals

.1 Isolation between black reinforcing steel and galvanized anchor bolts is required, and is the responsibility of the contractor to avoid potential galvanic reaction. Isolation to be achieved by 30 mm clear spacing between black and galvanized steel or denso tape on black steel at contact areas if 30 mm clear spacing cannot be achieved.

.2 Provide full isolation gaskets (4 mm neoprene) between aluminum electrical shrouds and galvanized anchor bolts as shown on drawings.

END OF SECTION