

CONSTRUCTION SPECIFICATION 481

METAL FABRICATION AND INSTALLATION

1. SCOPE

The work shall consist of furnishing, fabricating and erecting metalwork, including the metal parts of composite structures.

2. MATERIALS

A. STRUCTURAL STEEL

Structural steel shall conform to the requirements of ASTM Specification A 36.

High-strength low-alloy structural steel shall conform to ASTM Specification A 242 or A 588.

Carbon steel plates of structural quality to be bent or formed cold shall conform to ASTM Specification A 283, Grade C.

Carbon steel sheets of structural quality shall conform to ASTM Specification A 570, Grade D or A 611, Grade D.

Carbon steel strip of structural quality shall conform to ASTM Specification A 570, Grade C.

B. COMMERCIAL OR MERCHANT QUALITY STEEL

Commercial or merchant quality steel shall conform to the requirements of the applicable ASTM specifications listed below:

<u>Product</u>	<u>ASTM Specification</u>
Carbon steel bars	A 575, Grade M 1015 to Grade M 1031
Carbon steel sheets	A 569
Carbon steel strip	A 569
Zinc-coated carbon steel sheets	A 526

C. ALUMINUM ALLOY

Aluminum alloy products shall conform to the requirements of the applicable ASTM specifications listed below. Unless otherwise specified, alloy 6061-T6 shall be used.

<u>Product</u>	<u>ASTM Specification</u>
Standard structural shape	B 308
Extruded structural pipe and tube	B 429
Extruded bars, rods, shapes and tube	B 221
Drawn seamless tubes	B 210
Rolled or cold-finished bars, rods and wire	B 211
Sheet and plate	B 209

D. BOLTS

Steel bolts shall conform to the requirements of ASTM Standard A 307. If high-strength bolts are specified, they shall conform to the requirements of ASTM A 325.

When galvanized or zinc-coated bolts are specified, the zinc coating shall conform to the requirements of ASTM Standard A 153 except that bolts 0.5 inch or less in diameter may be coated with electro-deposited zinc or cadmium coating conforming to the requirements of ASTM Standard B 633, Service Condition SC 3, or ASTM B 766, unless otherwise specified.

E. RIVETS

Unless otherwise specified, steel rivets shall conform to the requirements of ASTM Specification A 31, Grade B. Unless otherwise specified, aluminum alloy rivets shall be Alloy 6061 conforming to the requirements of ASTM Standard B 316.

F. WELDING ELECTRODES

Steel welding electrodes shall conform to the requirements of American Welding Society Specification AWS A5.1, "Specification for Mild Steel Covered Arc-Welding Electrodes," except that they shall be uniformly and heavily coated (not washed) and shall be of such a nature that the coating does not chip or peel while being used with the maximum amperage specified by the manufacturer.

Aluminum welding electrodes shall conform to the requirements of American Welding Society Specification AWS A5.10, "Specification for Aluminum and Aluminum-Alloy Welding Rods and Bare Electrodes."

3 FABRICATION

Fabrication of structural steel shall conform to the requirements of Section 1.23 of the "Specification for the Design, Fabrication and Erection of Structural Steel for Buildings (Riveted, Bolted and Arc-welded Construction)," American Institute of Steel Construction.

Fabrication of structural aluminum shall conform to the requirements in the Aluminum Construction Manual, "Specifications for Aluminum Structures," Section 6 and section 7, The Aluminum Association, November 1976.

4 ERECTION

The frame of metal structures shall be carried up true and plumb. Temporary bracing shall be placed wherever necessary to resist all loads to which the structure may be subjected, including those applied by the installation and operation of equipment. Such bracing shall be left in place as long as may be necessary for safety.

As erection progresses the work shall be securely bolted up, or welded, to resist all dead load, wind and erection stresses. The Contractor shall furnish such fitting up bolts, nuts and washers as may be required. Structural members shall be lifted and handled in such a way as to minimize bending, twisting and other damage in the member.

No riveting or welding shall be done until as much of the structure as will be stiffened thereby has been properly aligned.

Rivets driven in the field shall be heated and driven with the same care as those driven in the shop.

All field welding shall be done in conformance to the requirements for shop fabrication, except those that expressly apply to shop conditions only.

Galvanized items shall not be cut, welded or drilled after the zinc coating is applied.

5 PROTECTIVE COATINGS

Items specified to be galvanized shall be completely fabricated for field assembly before the application of the zinc coatings. Areas to be painted or coated will be indicated on the plans.

6 SPECIFIC DETAILS