

PART 1 - GENERAL

1.1 REFERENCE STANDARDS

- .1 Do welding Work in accordance with C.S.A. W-59-1989 (R2001) unless specified otherwise.
- .2 Do structural steel Work in accordance with CSA S16.1 - 94 (R2000) except where specified otherwise.
- .3 Refer to Structural drawings for additional specification notes.

PART 2 - PRODUCTS

2.1 MATERIALS

- .1 Steel sections and plates: to C.S.A. G40.21- 98, type 300W.
- .2 Steel pipe to C.S.A. B63-1966 (R1971).
- .3 Welding materials: to C.S.A. W59-1989.
- .4 Bolts and anchor bolts: To ASTM A325M-79.
- .5 Galvanizing: Hot dipped galvanizing with minimum zinc coating of 600 g/m to C.S.A. G164-M92.
- .6 Galvanized primer: zinc rich, ready mix to C.G.S.B. 1-GP-181m+Amdt-Mar-78.

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 Use self-tapping shake-proof countersunk flat headed screws on items requiring assembly by screws or as indicated.
- .4 Where possible, fit and shop assemble Work, ready for erection.
- .5 Ensure exposed welds are continuous for length of each joint. File or grind exposed welds smooth and flush.

2.3 REFINISHING

- .1 Apply one shop coat of primer to metal items, with exception of stainless steel, aluminum, 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 C.
- .3 Clean surfaces to be field welded; do not paint.

PART 3 - EXECUTION

3.1 ERECTION

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- .1 Erect metal Work square, plumb, straight, and true, accurately fitted with tight joints and intersections.
- .2 Provide suitable means of anchorage such as dowels, anchor clips, bar anchors, expansion bolts and shields, toggles.
- .3 Make field connections with high tensile bolts, or weld to C.S.A. W59 - 1989 and C.S.A. S16.1 - 94.
- .4 Hand items over for casting into concrete or building into masonry to appropriate trades together with setting templates.
- .5 Touch-up rivets, field welds, bolt and burnt or scratched surfaces after completion of erection.
- .6 Touch-up galvanized surfaces with zinc primer where burned by field welding.

END OF SECTION