

SECTION 05 12 00 - STRUCTURAL STEEL FRAMING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes:
 - 1. Structural steel.
- B. This Section includes structural steel and architecturally exposed structural steel.
- C. Related Sections: The following Sections contain requirements that relate to this Section:
 - 1. Division 1 Section "Quality Control" for independent testing agency procedures and administrative requirements.
 - 2. Division 5 Section "Steel Deck" for field installation of shear connectors.
 - 3. Division 5 Section "Metal Fabrications" for loose steel bearing plates and miscellaneous steel framing.
 - 4. Division 9 Section "Special Coatings" for surface preparation and priming requirements.
 - 5. Division 9 Section "Painting" for surface preparation and priming requirements.

1.3 PERFORMANCE REQUIREMENTS

- A. Connections: Provide details of simple shear connections required by the Contract Documents to be selected or completed by structural-steel fabricator, including comprehensive engineering design by a qualified professional engineer, to withstand loads indicated and comply with other information and restrictions indicated.
 - 1. Select and complete connections using general notes provided on the plans and AISC 360.
 - 2. Engineering Responsibility: Fabricator's responsibilities include using a qualified licensed professional engineer to prepare structural analysis data for structural steel connections.

1.4 ACTION SUBMITTALS

- A. Product Data for each type of product specified.
- B. Shop Drawings: Show fabrication of structural-steel components.
 - 1. Include details of cuts, connections, splices, camber, holes, and other pertinent data.
 - 2. Include embedment drawings.
 - 3. Indicate welds by standard AWS symbols, distinguishing between shop and field welds, and show size, length, and type of each weld. Show backing bars that are to be removed and supplemental fillet welds where backing bars are to remain.
 - 4. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical high-strength bolted connections.
 - 5. For structural-steel connections indicated to comply with design loads, include structural design data signed and sealed by the qualified professional engineer responsible for their preparation.
 - 6. Prepare shop drawings in conformance with the best standards of the construction industry and not less complete than indicated by the applicable procedures shown in "Structural Steel Detailing" latest edition published by the AISC. Prepare shop drawings under the supervision of competent engineering personnel, licensed by the state in which the construction is taking place. During preparation of shop drawing, and prior to submittal, coordinate and cross check all shop drawings, including those prepared by subcontractors, for compliance with the Contract Documents. Each shop drawing shall bear the signature of the engineer in charge of structural steelwork for the steelwork subcontractor, and the initials of the individual actually preparing the drawing.
 - 7. Show clearly all work, including relationship of structural steel to the adjacent work of other trades and to significant lines of finishes of other trades.
 - 8. Do not fabricate or deliver work to the site before drawings reviewed by the Architect have been returned.
 - 9. Show explicitly the type of connection used in each location, the grade, size and number of bolts; the type, number, position, designation and orientation of each hole, and the size of each hole,

- whether slotted or round. Ensure that an adequate wrench clearance for correct bolt tightening is provided and note special bolt tightening sequences were necessary.
10. Prepare original shop drawings. The use of the engineer's or architect's drawings as a base for photographic or other reproduction for shop drawings or details will not be permitted. Show clearly the size and location of each member and the erection mark assigned to each member. Show each field connection with all data and details necessary for assembling the structure. Direct special attention to the possible need for special guying, bracing, or shoring to prevent deformation of existing or new structure due to stresses caused by erection procedures and equipment, by construction loadings, and by forces of natural phenomena.
 11. Prepare, keep up-to-date, and submit a complete drawing index cross-referencing each assigned piece mark with the drawing number in which the piece is detailed. Detail drawings submitted without an up-to-date index and the applicable erection drawing(s) showing the location of each piece will be deemed an incomplete submission and will not be accepted as subject to and agreed shop drawing review schedule.
 12. Prepare anchor bolt and baseplate erection drawings containing complete location and placing details, including details of all templates. Provide anchor bolt erection drawings to the concrete trade in advance of applicable concrete work and in coordination with the concrete construction sequence.
 13. Direct the architect's attention in writing to any proposed deviations from the Contract Documents, prior to the submission of shop drawings showing the proposed deviation. Submit requests for deviations on the steelwork subcontractor's letterhead. Deviations not identified, or identified only in letters of transmittal or in shop drawings or both, without the required written request, may not be accepted, and shall be sufficient cause for the architect to return each shop drawing containing such deviations without further action. Acceptance of shop drawings containing deviations not detected by the architect during shop drawing review shall not relieve the steelwork subcontractor from responsibility to conform strictly to the Contract Documents.
 14. Prior to resubmission of shop drawings with additions or corrections, circle and identify all changes. Drawings submitted without each change being clearly identified are subject to return for resubmission.
- C. Qualification Data: For qualified Installer, fabricator, professional engineer.
 - D. Welding certificates.
 - E. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.
 - F. Mill test reports for structural steel, including chemical and physical properties.
 - G. Product Test Reports: For the following:
 1. Bolts, nuts, and washers including mechanical properties and chemical analysis.
 2. Direct-tension indicators.
 3. Tension-control, high-strength bolt-nut-washer assemblies.
 4. Shear stud connectors.
 5. Shop primers.
 6. Nonshrink grout.
 - H. Source quality-control reports.
 - I. Field quality-control and special inspection reports.
- 1.5 QUALITY ASSURANCE
- A. Installer Qualifications: A qualified installer, who to the satisfaction of the Architect and Owner, has successfully completed similar projects in size and complexity to the proposed project, and who can provide suitable documentation to confirm this experience and capabilities. Said documentation shall be data for recent project experience including, but not limited to; owner name and contact information, location, name and contact information for general contractor, gross area of building, use of building, contract amount, and any other information that is deemed appropriate to communicate the installer is appropriately qualified. Installer shall also provide a copy of their detailed written quality assurance plan/program. Qualified installer shall participate in the AISC Quality Certification Program and be designated an AISC-Certified Erector, Category CSE or provide a similar quality program acceptable to the Architect.
 - B. Fabricator Qualifications: A qualified fabricator that participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category STD.
 - C. Comply with applicable provisions of the following specifications and documents:

1. AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design."
 2. AISC's "Load and Resistance Factor Design (LFRD) Specification for Structural Steel Buildings."
 3. AISC's "Specification for Allowable Stress Design of Single-Angle Members."
 4. AISC's "Specification for Load and Resistance Factor Design of Single-Angle Members."
 5. AISC's "Seismic Provisions for Structural Steel Buildings."
 6. ASTM A 6 (ASTM A 6M) "Specification for General Requirements for Rolled Steel Plates, Shapes, Sheet Piling, and Bars for Structural Use."
 7. Research Council on Structural Connections' (RCSC) "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
 8. Research Council on Structural Connections' (RCSC) "Load and Resistance Factor Design Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- D. Professional Engineer Qualifications: A professional engineer who is legally authorized to practice in the jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for projects with structural steel framing that are similar to that indicated for this Project in material, design, and extent.
- E. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- F. Comply with applicable provisions of the following specifications and documents:
1. AISC 303.
 2. AISC 360.
 3. RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- G. Preinstallation Conference: Conduct conference at Project site.
- 1.6 DELIVERY, STORAGE, AND HANDLING
- A. Deliver structural steel to Project site in such quantities and at such times to ensure continuity of installation.
- B. Store materials to permit easy access for inspection and identification. Keep steel members off ground by using pallets, platforms, or other supports. Protect steel members and packaged materials from erosion and deterioration.
1. Store fasteners in a protected place. Clean and relubricate bolts and nuts that become dry or rusty before use.
 2. Do not store materials on structure in a manner that might cause distortion or damage to members or supporting structures. Repair or replace damaged materials or structures as directed.
- C. Store fasteners in a protected place in sealed containers with manufacturer's labels intact.
1. Fasteners may be repackaged provided Owner's testing and inspecting agency observes repackaging and seals containers.
 2. Clean and relubricate bolts and nuts that become dry or rusty before use.
 3. Comply with manufacturers' written recommendations for cleaning and lubricating ASTM F 1852 fasteners and for retesting fasteners after lubrication.
- 1.7 COORDINATION
- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, sheet metal templates, instructions, and directions for installation.
- 1.8 COORDINATION
- A. Field Measurements: Obtain all field measurements required for proper fabrication and installation of work. Submit prior to installation, all measurements indicating discrepancies from the drawings. Describe in writing, and where applicable, by sketches proposed methods of correcting the discrepancies. Measurements are the responsibility of the contractor.
- B. Lay out each part of the work in strict accordance with the architectural, structural, mechanical, electrical, plumbing and all other drawings and be responsible for correct location of the same. Lay out from at least two pre-established benchmarks and axis lines, individually correct for length and bearing.

- C. Templates: Furnish templates and layout drawings for exact locations of items to be embedded in concrete, with setting instructions required for installation of embedded items.
- D. Contractor shall provide a certified survey showing the exact location of the centers of the columns at their top most level, exactly as installed. This information shall be incorporated into the "as built" drawings.

PART 2 - PRODUCTS

2.1 STRUCTURAL-STEEL MATERIALS

- A. Recycled Content of Steel Products: Provide products with an average recycled content of steel products so postconsumer recycled content plus one-half of preconsumer recycled content is not less than the following:
 - 1. W-Shapes: 35 percent.
 - 2. Channels, Angles, M, S-Shapes: 35 percent.
 - 3. Plate and Bar: 25 percent.
 - 4. Cold-Formed Hollow Structural Sections: 35 percent.
 - 5. Steel Pipe: 25 percent.
 - 6. All Other Steel Materials: 25 percent.
- B. W-Shapes: ASTM A 992/A 992M.
- C. Channels, Angles, M, S-Shapes: ASTM A 36/A 36M.
- D. Plate and Bar: ASTM A 36/A 36M.
- E. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B, structural tubing.
- F. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
 - 1. Weight Class: As indicated.
 - 2. Finish: Black except where indicated to be galvanized.
- G. Steel Castings: ASTM A 216/A 216M, Grade WCB with supplementary requirement S11.
- H. Steel Forgings: ASTM A 668/A 668M.
- I. Welding Electrodes: Comply with AWS requirements

2.2 BOLTS, CONNECTORS, AND ANCHORS

- A. High-Strength Bolts, Nuts, and Washers: ASTM A 325 or ASTM A490; Cold forged with rolled threads. Do not use A325 and A490 bolts of the same diameter. Different grade bolts must vary in diameter by a minimum of ¼ inch.
 - 1. Direct-Tension Indicators: ASTM F 959, Type 325 compressible-washer type with plain finish.
- B. Zinc-Coated High-Strength Bolts, Nuts, and Washers: ASTM A 325 (ASTM A 325M), Type 1, heavy-hex steel structural bolts; ASTM A 563, Grade DH (ASTM A 563M, Class 10S) heavy-hex carbon-steel nuts; and ASTM F 436 (ASTM F 436M), Type 1, hardened carbon-steel washers.
 - 1. Finish: Hot-dip zinc coating.
 - 2. Direct-Tension Indicators: ASTM F 959, Type 325 (ASTM F 959M, Type 8.8), compressible-washer type with mechanically deposited zinc coating, baked epoxy-coated finish.
- C. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F 1852, Type 1, round head assemblies consisting of steel structural bolts with splined ends, heavy-hex carbon-steel nuts, and hardened carbon-steel washers.
 - 1. Finish: Plain.
- D. Shear Connectors: ASTM A 108, Grades 1015 through 1020, headed-stud type, cold-finished carbon steel; AWS D1.1/D1.1M, Type B.
- E. Unheaded Anchor Rods: ASTM F 1554, Grade 36.
 - 1. Configuration: Straight or Hooked.
 - 2. Nuts: ASTM A 563 (ASTM A 563M) heavy-hex carbon steel.
 - 3. Plate Washers: ASTM A 36/A 36M carbon steel.
 - 4. Washers: ASTM F 436 (ASTM F 436M), Type 1, hardened carbon steel.
 - 5. Finish: Plain except where indicated to be hot-dip zinc coating, ASTM A 153/A 153M, Class C.
- F. Threaded Rods: ASTM A 36/A 36M.

1. Nuts: ASTM A 563 (ASTM A 563M) heavy-hex carbon steel.
2. Washers: ASTM F 436 (ASTM F 436M), Type 1, hardened carbon steel.
3. Finish: Plain except where indicated to be hot-dip zinc coating, ASTM A 153/A 153M, Class C

2.3 PRIMER

- A. Primer: Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer complying with MPI#79 and compatible with topcoat.
 1. Compatible with Section 099600 "High-Performance Coatings."
- B. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20 and/or ASTM A 780.
- C. VOC Content: Products shall comply with VOC limits of authorities having jurisdiction [and, for interior paints and coatings applied at Project site, the following VOC limits, exclusive of colorants added to a tint base, when calculated according to 40 CFR 59, Subpart D (EPA Method 24)].
 1. Flat Paints and Coatings: 50 g/L.
 2. Nonflat Paints and Coatings: 150 g/L.
 3. Primers, Sealers, and Undercoaters: 200 g/L.
 4. Anticorrosive and Antirust Paints Applied to Ferrous Metals: 250 g/L.
 5. Zinc-Rich Industrial Maintenance Primers: 340 g/L.

2.4 GROUT

- A. Non-metallic, Shrinkage-Resistant Grout: ASTM C 1107, factory-packaged, non-metallic aggregate grout, non-corrosive and non-staining, mixed with water to consistency suitable for application and a 30-minute working time.

2.5 FABRICATION

- A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and AISC 360.
 1. Camber structural-steel members where indicated.
 2. Fabricate beams with rolling camber up.
 3. Identify high-strength structural steel according to ASTM A 6/A 6M and maintain markings until structural steel has been erected.
 4. Mark and match-mark materials for field assembly.
 5. Complete structural-steel assemblies, including welding of units, before starting shop-priming operations.
- B. Thermal Cutting: Perform thermal cutting by machine to greatest extent possible.
 1. Plane thermally cut edges to be welded to comply with requirements in AWS D1.1/D1.1M.
- C. Bolt Holes: Cut, drill or punch standard bolt holes perpendicular to metal surfaces.
- D. Finishing: Accurately finish ends of columns and other members transmitting bearing loads.
- E. Cleaning: Clean and prepare steel surfaces that are to remain unpainted according to SSPC-SP 1, "Solvent Cleaning."
- F. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.
- G. Holes: Provide holes required for securing other work to structural steel and for other work to pass through steel framing members.
 1. Cut, drill, or punch holes perpendicular to steel surfaces. Do not thermally cut bolt holes or enlarge holes by burning.
 2. Baseplate Holes: Cut, drill, mechanically thermal cut, or punch holes perpendicular to steel surfaces.
 3. Weld threaded nuts to framing and other specialty items indicated to receive other work.

2.6 SHOP CONNECTIONS

- A. Shop install and tighten non high-strength bolts, except where high-strength bolts are indicated.
- B. Shop install and tighten high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."

- C. Shop install and tighten high-strength bolts according to RCSC's "Load and Resistance Factor Design Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
 - 1. Bolts: ASTM A 325 (ASTM A 325M) high-strength bolts, unless otherwise indicated.
 - 2. Bolts: ASTM A 490 (ASTM A 490M) high-strength bolts, unless otherwise indicated.
 - 3. Connection Type: Snug tightened, unless indicated as slip-critical, direct-tension, or tensioned shear/bearing connections.
 - 4. Connection Type: Slip-critical, direct-tension, or tensioned shear/bearing connections as indicated.
 - D. Weld Connections: Comply with AWS D1.1 for procedures, appearance and quality of welds, and methods used in correcting welding work.
 - 1. Assemble and weld built-up sections by methods that will maintain true alignment of axes without warp.
 - 2. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent surface bleeding of back-side welding on exposed steel surfaces. Grind smooth exposed fillet welds 1/2 inch (13 mm) and larger. Grind flush butt welds. Dress exposed welds.
- 2.7 SHOP PRIMING
- A. Shop prime steel surfaces except the following:
 - 1. Surfaces embedded in concrete or mortar. Extend priming of partially embedded members to a depth of 2 inches.
 - 2. Surfaces to be field welded.
 - 3. Surfaces to be high-strength bolted with slip-critical connections.
 - 4. Surfaces to receive sprayed fire-resistive materials (applied fireproofing).
 - 5. Galvanized surfaces.
 - B. Surface Preparation: Clean surfaces to be painted. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces according to the following specifications and standards:
 - 1. SSPC-SP 2, "Hand Tool Cleaning."
 - 2. SSPC-SP 3, "Power Tool Cleaning."
 - C. Priming: Immediately after surface preparation, apply primer according to manufacturer's written instructions and at rate recommended by SSPC to provide a minimum dry film thickness of 1.5 mils. Use priming methods that result in full coverage of joints, corners, edges, and exposed surfaces.
 - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.
 - 2. Apply two coats of shop paint to surfaces that are inaccessible after assembly or erection. Change color of second coat to distinguish it from first.
 - D. Painting: Prepare steel and apply a one-coat, nonasphaltic primer complying with SSPC-PS Guide 7.00, "Painting System Guide 7.00: Guide for Selecting One-Coat Shop Painting Systems," to provide a dry film thickness of not less than 1.5 mils.
- 2.8 GALVANIZING
- A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process to structural steel according to ASTM A 123/A 123M.
 - 1. Fill vent and drain holes that will be exposed in the finished Work unless they will function as weep holes, by plugging with zinc solder and filing off smooth.
 - 2. Galvanize lintels, shelf angles and members which are permanently exposed to weather.
- 2.9 SOURCE QUALITY CONTROL
- A. Owner will engage an independent testing and inspecting agency to perform shop inspections and tests and to prepare test reports.
 - 1. Testing agency will conduct and interpret tests and state in each report whether test specimens comply with or deviate from requirements.
 - 2. Provide testing agency with access to places where structural steel Work is being fabricated or produced so required inspection and testing can be accomplished.

- B. Correct deficiencies in or remove and replace structural steel that inspections and test reports indicate do not comply with specified requirements.
- C. Additional testing, at Contractor's expense, will be performed to determine compliance of corrected Work with specified requirements.
- D. Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- E. Shop-bolted connections will be tested and inspected according to RCSC's "Load and Resistance Factor Design Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
 - 1. Direct-tension indicator gaps will be verified to comply with ASTM F 959, Table 2.
- F. In addition to visual inspection, shop-welded connections will be inspected and tested according to AWS D1.1 and the inspection procedures listed below, at testing agency's option.
 - 1. Liquid Penetrant Inspection: ASTM E 165.
 - 2. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
 - 3. Radiographic Inspection: ASTM E 94 and ASTM E 142; minimum quality level "2-2T."
 - 4. Ultrasonic Inspection: ASTM E 164.
- G. In addition to visual inspection, shop-welded shear connectors will be inspected and tested according to requirements of AWS D1.1 for stud welding and as follows:
 - 1. Bend tests will be performed when visual inspections reveal either less than a continuous 360-degree flash or welding repairs to any shear connector.
 - 2. Tests will be conducted on additional shear connectors when weld fracture occurs on shear connectors already tested, according to requirements of AWS D1.1.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Before erection proceeds, and with the steel erector present, verify elevations of concrete and masonry bearing surfaces and locations of anchorages for compliance with requirements.
 - 1. Prepare a certified survey of existing conditions. Include bearing surfaces, anchor rods, bearing plates and other embedments showing dimensions, locations, angles and elevations.
- B. Do not proceed with erection until unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Provide temporary shores, guys, braces, and other supports during erection to keep structural steel secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural steel, connections, and bracing are in place unless otherwise indicated.

3.3 ERECTION

- A. Set structural steel accurately in locations and to elevations indicated and according to AISC specifications referenced in this Section.
- B. Base and Bearing Plates: Clean concrete and masonry bearing surfaces of bond-reducing materials and roughen surfaces prior to setting base and bearing plates. Clean bottom surface of base and bearing plates.
 - 1. Set base and bearing plates for structural members on wedges, shims, or setting nuts as required.
 - 2. Weld plate washers to top of baseplate.
 - 3. Tighten anchor bolts after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of base or bearing plate prior to packing with grout.
 - 4. Pack grout solidly between bearing surfaces and plates so no voids remain. Finish exposed surfaces, protect installed materials, and allow to cure.
 - a. Comply with manufacturer's instructions for proprietary grout materials.
- C. Maintain erection tolerances of structural steel within AISC's "Code of Standard Practice for Steel Buildings and Bridges."

1. Maintain erection tolerances of architecturally exposed structural steel within AISC's "Code of Standard Practice for Steel Buildings and Bridges."
- D. Align and adjust various members forming part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that will be in permanent contact. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 1. Level and plumb individual members of structure.
 2. Establish required leveling and plumbing measurements on mean operating temperature of structure. Make allowances for difference between temperature at time of erection and mean temperature at which structure will be when completed and in service.
- E. Splice members only where indicated.
- F. Remove erection bolts on welded, architecturally exposed structural steel; fill holes with plug welds; and grind smooth at exposed surfaces.
- G. Do not use thermal cutting during erection.
- H. Finish sections thermally cut during erection equal to a sheared appearance.
- I. Do not enlarge unfair holes in members by burning or by using drift pins. Ream holes that must be enlarged to admit bolts.

3.4 FIELD CONNECTIONS

- A. Install and tighten nonhigh-strength bolts, except where high-strength bolts are indicated.
- B. Install and tighten high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- C. Install and tighten high-strength bolts according to RCSC's "Load and Resistance Factor Design Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
 1. Bolts: ASTM A 325 (ASTM A 325M) high-strength bolts, unless otherwise indicated.
 2. Bolts: ASTM A 490 (ASTM A 490M) high-strength bolts, unless otherwise indicated.
 3. Connection Type: Snug tightened, unless indicated as slip-critical, direct-tension, or tensioned shear/bearing connections.
 4. Connection Type: Slip-critical, direct-tension, or tensioned shear/bearing connections as indicated.
- D. Weld Connections: Comply with AWS D1.1 for procedures, appearance and quality of welds, and methods used in correcting welding work.
 1. Comply with AISC specifications referenced in this Section for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds.
 2. Assemble and weld built-up sections by methods that will maintain true alignment of axes without warp.
 3. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent surface bleeding of back-side welding on exposed steel surfaces. Grind smooth exposed fillet welds 1/2 inch (13 mm) and larger. Grind flush butt welds. Dress exposed welds.

3.5 FIELD QUALITY CONTROL

- A. Owner will engage an independent testing and inspecting agency to perform field inspections and tests and to prepare test reports.
 1. Testing agency will conduct and interpret tests and state in each report whether tested Work complies with or deviates from requirements.
- B. Correct deficiencies in or remove and replace structural steel that inspections and test reports indicate do not comply with specified requirements.
- C. Additional testing, at Contractor's expense, will be performed to determine compliance of corrected Work with specified requirements.
- D. Field-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- E. Field-bolted connections will be tested and inspected according to RCSC's "Load and Resistance Factor Design Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
 1. Direct-tension indicator gaps will be verified to comply with ASTM F 959, Table 2.

- F. In addition to visual inspection, field-welded connections will be inspected and tested according to AWS D1.1 and the inspection procedures listed below, at testing agency's option.
 - 1. Liquid Penetrant Inspection: ASTM E 165.
 - 2. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
 - 3. Radiographic Inspection: ASTM E 94 and ASTM E 142; minimum quality level "2-2T."
 - 4. Ultrasonic Inspection: ASTM E 164.
- G. In addition to visual inspection, field-welded shear connectors will be inspected and tested according to requirements of AWS D1.1 for stud welding and as follows:
 - 1. Bend tests will be performed when visual inspections reveal either less than a continuous 360-degree flash or welding repairs to any shear connector.
 - 2. Tests will be conducted on additional shear connectors when weld fracture occurs on shear connectors already tested, according to requirements of AWS D1.1.

3.6 REPAIRS AND PROTECTION

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint. Apply paint to exposed areas using same material as used for shop painting.
 - 1. Apply by brush or spray to provide a minimum dry film thickness of 1.5 mils (0.038 mm).
- B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint on structural steel are included in Division 9 Section "Painting."
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and apply galvanizing repair paint according to ASTM A 780.

END OF SECTION 051200