

SECTION 05 12 00 - STRUCTURAL STEEL FRAMING

PART 1 - GENERAL

1.1 SUMMARY

- A. This Section includes structural steel and grout.

1.2 PERFORMANCE REQUIREMENTS

- A. Connections: Provide details of simple shear connections required by the Contract Documents to be selected or completed by structural-steel fabricator to withstand loads indicated and comply with other information and restrictions indicated.
 - 1. Select and complete connections using schematic details indicated and AISC's "Manual of Steel Construction, Load and Resistance Factor Design," Volume 2, Part 9.

1.3 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Shop Drawings: Show fabrication of structural-steel components.
- C. Welding certificates. All Welders must be WABO certified within the 6 months previous to the project start.
- D. Mill test reports.
- E. Source quality-control test reports.

1.4 QUALITY ASSURANCE

- A. Fabricator Qualifications: A qualified fabricator who participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category Sbd.
- B. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel."
- C. Comply with applicable provisions of AISC's "Code of Standard Practice for Steel Buildings and Bridges."
- D. Preinstallation Conference: Conduct conference at Project site.

PART 2 - PRODUCTS

2.1 STRUCTURAL-STEEL MATERIALS

- A. W-Shapes: [ASTM A 992/A 992M] [ASTM A 572/A 572M, Grade 50].
- B. Channels, Angles[, M] [, S]-Shapes: [ASTM A 36/A 36M] [ASTM A 572/A 572M, Grade 50].
- C. Plate and Bar: [ASTM A 36/A 36M] [ASTM A 572/A 572M, Grade 50].
- D. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade [B], structural tubing.
- E. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
- F. Welding Electrodes: Comply with AWS requirements.

2.2 BOLTS, CONNECTORS, AND ANCHORS

- A. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy hex steel structural bolts; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers.
 - 1. Finish: Plain finish only for interior work; Hot-dip zinc coating, ASTM A 153/A 153M, Class C must be used for all work exposed to unconditioned air and to the exterior.
 - 2. Direct-Tension Indicators: ASTM F 959, Type 325 compressible-washer type.
 - a. Finish: [Plain] [Mechanically deposited zinc coating, ASTM B 695, Class 50] [Mechanically deposited zinc coating, ASTM B 695, Class 50, baked epoxy coated].
- B. High-Strength Bolts, Nuts, and Washers: ASTM A 490, Type 1, heavy hex steel structural bolts; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers, plain.
 - 1. Direct-Tension Indicators: ASTM F 959, Type 490, compressible-washer type, plain.
- C. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F 1852, Type 1, [heavy hex] [round] head steel structural bolts with splined ends; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers.
 - 1. Finish: Plain and Mechanically deposited zinc coating, ASTM B 695, Class 50. Zinc coating must be used on all assemblies exposed to unconditioned air or to the exterior of the building.
- D. Shear Connectors: ASTM A 108, Grades 1015 through 1020, headed-stud type, cold-finished carbon steel; AWS D1.1, Type B.
- E. Unheaded Anchor Rods: [ASTM F 1554, Grade 36] [ASTM F 1554, Grade 55, weldable].

1. Configuration: [**Straight**] [**Hooked**].
 2. Finish: Plain may be used at interior assemblies in conditioned spaces; Hot-dip zinc coating, ASTM A 153/A 153M, Class C must be used for all exposures to unconditioned air or the exterior.
- F. Headed Anchor Rods: [**ASTM F 1554, Grade 36**] [**ASTM F 1554, Grade 55, weldable**], straight.
1. Finish: Plain may be used at interior assemblies in conditioned spaces; Hot-dip zinc coating, ASTM A 153/A 153M, Class C must be used for all exposures to unconditioned air or to the exterior.
- G. Threaded Rods: [**ASTM A 193/A 193M**] [**ASTM A 36/A 36M**].
1. Finish: [**Plain**] [**Hot-dip zinc coating, ASTM A 153/A 153M, Class C**] [**Mechanically deposited zinc coating, ASTM B 695, Class 50**].

2.3 PRIMER

- A. Primer: Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer.

2.4 GROUT

- A. Metallic, Shrinkage-Resistant Grout: ASTM C 1107, factory-packaged, metallic aggregate grout, mixed with water to consistency suitable for application and a 30-minute working time.
- B. Nonmetallic, Shrinkage-Resistant Grout: ASTM C 1107, factory-packaged, nonmetallic aggregate grout, noncorrosive, nonstaining, 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's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design and "Load and Resistance Factor Design Specification for Structural Steel Buildings."
- B. 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 and manufacturer's written instructions.

2.6 SHOP CONNECTIONS

- A. High-Strength Bolts: Shop install high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.

1. Joint Type: Snug tightened.

B. Weld Connections: Comply with AWS D1.1 for welding procedure specifications, tolerances, appearance, and quality of welds and for methods used in correcting welding work. All welding must be performed by WABO certified welders.

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.
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 dry film thickness of not less than 1.5 mils. Use priming methods that result in full coverage of joints, corners, edges, and exposed surfaces.

D. Galvanizing: hot dip galvanize to G60 coating all structural steel members exposed to the exterior. Touch up galvanizing at any weld locations.

2.8 SOURCE QUALITY CONTROL

A. Owner will engage an independent testing and inspecting agency to perform shop tests and inspections and prepare test reports. Comply with testing and inspection requirements of Part 3, Article "Field Quality Control."

B. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

C. In addition to visual inspection, shop-welded shear connectors will be tested and inspected according to requirements in AWS D1.1 for stud welding.

PART 3 - EXECUTION

3.1 ERECTION

- A. Examination: Verify elevations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments, with steel erector present, for compliance with requirements.
 - 1. Proceed with installation only after unsatisfactory conditions have been corrected.
- B. Set structural steel accurately in locations and to elevations indicated and according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design."
- C. 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 base plate.
 - 3. Snug-tighten anchor rods 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 before packing with grout.
 - 4. Promptly pack grout solidly between bearing surfaces and base or bearing plates so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for shrinkage-resistant grouts.
- D. Maintain erection tolerances of structural steel within AISC's "Code of Standard Practice for Steel Buildings and Bridges."

3.2 FIELD CONNECTIONS

- A. High-Strength Bolts: Install high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.
 - 1. Joint Type: Snug tightened.
- B. Weld Connections: Comply with AISC and AWS D1.1 for welding procedure specifications, tolerances, appearance, and quality of welds and for methods used in correcting welding work.
 - 1. Comply with AISC's "Code of Standard Practice for Steel Buildings and Bridges" and "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design" for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds. All welding must be performed by WABO certified welders.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to inspect field welds and high-strength bolted connections.
- B. Bolted Connections: Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- C. Welded Connections: Field welds will be visually inspected according to AWS D1.1.
 - 1. In addition to visual inspection, field welds will be tested according to AWS D1.1 and the following inspection procedures, at testing agency's option:
 - a. Liquid Penetrant Inspection: ASTM E 165.
 - b. 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.
 - c. Ultrasonic Inspection: ASTM E 164.
 - d. Radiographic Inspection: ASTM E 94.
- D. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

END OF SECTION 05 12 00