

SECTION 051200
STRUCTURAL STEEL

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 the following:
 - 1. Structural steel.
 - 2. Architecturally exposed structural steel.
 - 3. Prefabricated building columns.
 - 4. Grout.

1.3 DEFINITIONS

- A. Structural Steel: Elements of structural-steel frame, as classified by AISC's "Code of Standard Practice for Steel Buildings and Bridges," that support design loads.
- B. Architecturally Exposed Structural Steel: Structural steel designated as architecturally exposed structural steel in the Contract Documents.

1.4 PERFORMANCE REQUIREMENTS

- A. Connections: Provide details of 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,"
 - 2. Engineering Responsibility: Fabricator's responsibilities include using a qualified professional engineer to prepare structural analysis data for structural-steel connections.

1.5 SUBMITTALS

- A. Product Data: For each type of product indicated.

- 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.
 - 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 analysis data prepared by the qualified professional engineer responsible for their preparation.
- C. Welding certificates.
- D. Mill Test Reports: Signed by manufacturers certifying that the following products comply with requirements:
 - 1. Structural steel including chemical and physical properties.
 - 2. Bolts, nuts, and washers including mechanical properties and chemical analysis.
 - 3. Direct-tension indicators.
 - 4. Tension-control, high-strength bolt-nut-washer assemblies.
 - 5. Shear stud connectors.
 - 6. Shop primers.
 - 7. Non-shrink grout.
- E. Source quality-control test reports.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: A qualified installer who participates in the AISC Quality Certification Program and is designated an AISC-Certified Erector.
- B. Fabricator Qualifications: A qualified fabricator who participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant.
- C. Shop-Painting Applicators: Qualified according to "Standard Procedure for Evaluating Qualifications of Shop Painting Applicators."
- D. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel."
- E. Comply with applicable provisions of the following specifications and documents:
 - 1. AISC's "Code of Standard Practice for Steel Buildings and Bridges."
 - 2. AISC's "Seismic Provisions for Structural Steel Buildings" and "Supplement No. 2."

3. AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design or Load and Resistance Factor Design Specification for Structural Steel Buildings."
 4. AISC's "Specification for the Design of Steel Hollow Structural Sections."
 5. AISC's "Specification for Allowable Stress Design of Single-Angle Members or Specification for Load and Resistance Factor Design of Single-Angle Members."
 6. RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- F. Mockups: Build mockups of architecturally exposed structural steel to set quality standards for fabrication and installation.
1. Coordinate finish painting requirements with Division 9 painting Sections.
 2. Approved mockups may become part of the completed Work if undisturbed at time of Substantial Completion.
- G. Preinstallation Conference: Conduct conference at Project site to comply with requirements in Division 1 Section "Project Management and Coordination."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Store materials to permit easy access for inspection and identification. Keep steel members off ground and spaced by using pallets, dunnage, or other supports and spacers. 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, damage, or overload to members or supporting structures. Repair or replace damaged materials or structures as directed.

1.8 COORDINATION

- A. Furnish 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.

PART 2 - PRODUCTS

2.1 STRUCTURAL-STEEL MATERIALS

- A. W-Shapes: ASTM A 992/A 992M, Grade 50.
- B. Channels, Angles, M or , S-Shapes: ASTM A 36/A 36M.

- C. Plate and Bar: ASTM A 36/A 36M.
- D. Corrosion-Resisting Structural Steel: ASTM A 588/A 588M, Grade 50.
- E. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B or C, structural tubing.
- F. Corrosion-Resisting Cold-Formed Hollow Structural Sections: ASTM A 847, structural tubing.
- G. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
 - 1. Weight Class: Standard.
 - 2. Finish: Black, except where indicated to be galvanized.
- H. Medium-Strength Steel Castings: ASTM A 27/A 27M, Grade 65-35, carbon steel.
- I. High-Strength Steel Castings: ASTM A 148/A 148M, Grade 80-50, carbon or alloy steel.
- J. 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: Mechanically deposited zinc coating, ASTM B 695, Class 50.
 - 2. Direct-Tension Indicators: ASTM F 959, Type 325 compressible-washer type.
 - a. Finish: Plain Mechanically deposited zinc coating, ASTM B 695, Class 50.
- 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 Mechanically deposited zinc coating, ASTM B 695, Class 50.
- 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 ASTM A 354 ASTM A 449 ASTM A 572/A 572M, Grade 50.
 - 1. Configuration: Hooked.
 - 2. Nuts: ASTM A 563 [heavy]hex carbon steel.
 - 3. Plate Washers: ASTM A 36/A 36M carbon steel.
 - 4. Washers: ASTM F 436 hardened carbon steel.
 - 5. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C Mechanically deposited zinc coating, ASTM B 695, Class 50.

- F. Headed Anchor Rods: ASTM F 1554, Grade 36 ASTM F 1554, Grade 55, weldable ASTM A 307, Grade A , straight.
 - 1. Nuts: ASTM A 563 heavy hex carbon steel.
 - 2. Plate Washers: ASTM A 36/A 36M carbon steel.
 - 3. Washers: ASTM F 436 hardened carbon steel.
 - 4. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C.

- G. Threaded Rods: ASTM A 307, Grade A .
 - 1. Nuts: ASTM A 563 heavy hex carbon steel.
 - 2. Washers: ASTM A 36/A 36M carbon steel.
 - 3. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C.

- H. Clevises Turnbuckles: ASTM A 108, Grade 1035, cold-finished carbon steel.

- I. Eye Bolts and Nuts: ASTM A 108, Grade 1030, cold-finished carbon steel.

- J. Sleeve Nuts: ASTM A 108, Grade 1018, cold-finished carbon steel.

2.3 PRIMER

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

- B. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20.

2.4 GROUT

- A. Cement Grout: Portland cement, ASTM C 150, Type I; and clean, natural sand, ASTM C 404, Size No. 2. Mix at ratio of 1 part cement to 2-1/2 parts sand, by volume, with minimum water required for placement and hydration.

- B. 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.

- C. 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 or Load and Resistance Factor Design Specification for Structural Steel Buildings."
 - 1. Camber structural-steel members where indicated.
 - 2. Identify high-strength structural steel according to ASTM A 6/ A 6M and maintain markings until structural steel has been erected.
 - 3. Mark and match-mark materials for field assembly.
 - 4. Complete structural-steel assemblies, including welding of units, before starting shop-priming operations.
- B. Architecturally Exposed Structural Steel: Comply with fabrication requirements, including tolerance limits, of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for structural steel identified as architecturally exposed structural steel.
 - 1. Fabricate with exposed surfaces smooth, square, and free of surface blemishes including pitting, rust, scale, seam marks, roller marks, rolled trade names, and roughness.
 - 2. Remove blemishes by filling or grinding or by welding and grinding, before cleaning, treating, and shop priming.
- C. 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.
- D. Bolt Holes: Cut, drill, mechanically thermal cut, or punch standard bolt holes perpendicular to metal surfaces.
- E. Finishing: Accurately finish ends of columns and other members transmitting bearing loads.
- F. Cleaning: Clean and prepare steel surfaces that are to remain unpainted.
- G. 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.

- H. Steel Wall-Opening Framing: Select true and straight members for fabricating steel wall-opening framing to be attached to structural steel. Straighten as required to provide uniform, square, and true members in completed wall framing.
- I. Welded Door Frames: Build up welded door frames attached to structural steel. Weld exposed joints continuously and grind smooth. Plug-weld fixed steel bar stops to frames. Secure removable stops to frames with countersunk, cross-recessed head machine screws, uniformly spaced not more than 10 inches o.c., unless otherwise indicated.
- J. Holes: Provide holes required for securing other work to structural steel and for passage of other work 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. Base-Plate 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. 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.
 - 1. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 - 2. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.
 - 3. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Grind butt welds flush.
 - b. Grind or fill exposed fillet welds to smooth profile. 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.
 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."
 3. SSPC-SP 5/NACE No. 1, "White Metal Blast Cleaning."
 4. SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 5. SSPC-SP 7/NACE No. 4, "Brush-Off Blast Cleaning."
 6. SSPC-SP 8, "Pickling."
 7. SSPC-SP 10/NACE No. 2, "Near-White Blast Cleaning."
 8. SSPC-SP 11, "Power Tool Cleaning to Bare Metal."
 9. SSPC-SP 14/NACE No. 8, "Industrial Blast 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.
1. Stripe paint corners, crevices, bolts, welds, and sharp edges.
 2. Apply two coats of shop paint to inaccessible surfaces after assembly or erection. Change color of second coat to distinguish it from first.
- D. Painting: Apply a 1-coat, non-asphaltic 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 holes and grind smooth after galvanizing.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. 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.
- B. Proceed with installation only after 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.
 - 1. Do not remove temporary shoring supporting composite deck construction until cast-in-place concrete has attained its design compressive strength.

3.3 ERECTION

- A. 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 or Load and Resistance Factor Design Specification for Structural Steel Buildings."
- 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 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.

- C. Maintain erection tolerances of structural steel and 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 with members. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 - 1. Level and plumb individual members of structure.
 - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure is 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. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.
- I. 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.

3.4 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 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 or Load and Resistance Factor Design Specification for Structural Steel Buildings" for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds.
 - 2. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 - 3. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.

4. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Grind butt welds flush.
 - b. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

3.5 PREFABRICATED BUILDING COLUMNS

- A. Install prefabricated building columns to comply with AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design or Load and Resistance Factor Design Specification for Structural Steel Buildings," manufacturer's written recommendations, and requirements of testing and inspecting agency that apply to the fire-resistance rating indicated.

3.6 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. In addition to visual inspection, test and inspect field-welded shear connectors according to requirements in AWS D1.1 for stud welding and as follows:
 1. Perform bend tests if visual inspections reveal either a less-than- continuous 360-degree flash or welding repairs to any shear connector.
 2. Conduct tests on additional shear connectors if weld fracture occurs on shear connectors already tested, according to requirements in AWS D1.1.
- E. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

3.7 REPAIRS AND PROTECTION

- A. Repair damaged galvanized coatings on galvanized items with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Touchup Painting: After installation, promptly clean, prepare, and prime or reprime field connections, rust spots, and abraded surfaces of prime-painted joists and accessories, bearing plates, and abutting structural steel.
 - 1. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC-SP 3 power-tool cleaning.
 - 2. Apply a compatible primer of same type as shop primer used on adjacent surfaces.
- C. Touchup Painting: Cleaning and touchup painting are specified in Division 9 painting Sections.

END OF DOCUMENT 051200