

SECTION 051200 - 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 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:
 - 1. Structural steel.

1.3 DEFINITIONS

- A. Structural Steel: Elements of the structural frame indicated on Drawings and as described in ANSI/AISC 303.

1.4 COORDINATION

- A. Coordinate miscellaneous steel support for roof-top mechanical units with the exact location and unit being provided.

1.5 PREINSTALLATION MEETINGS

- A. Preinstallation Conference: Conduct conference at Project Site.

1.6 ACTION SUBMITTALS

- A. Product Data:
 - 1. Structural-steel materials.
 - 2. High-strength, bolt-nut-washer assemblies.
 - 3. Threaded rods.
 - 4. Shop primer.
- B. Shop Drawings: Show fabrication of structural-steel components.

1. Include details of cuts, connections, splices, camber, holes, and other pertinent data.
 2. 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.
 3. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical, high-strength bolted connections.
 4. Identify members not to be shop primed.
- C. Welding Procedure Specifications (WPSs) and Procedure Qualification Records (PQRs): Provide in accordance with AWS D1.1/D1.1M for each welded joint qualified by testing, including the following:
1. Power source (constant current or constant voltage).
 2. Electrode manufacturer and trade name, for demand-critical welds.
- D. Delegated-Design Submittal: For structural-steel connections indicated on Drawings to comply with design loads, include analysis data signed and sealed by the qualified professional engineer responsible for their preparation. In addition, the professional engineer responsible for connection design shall review the shop drawings prior to submittal to verify that the connections detailed comply with the calculations provided as well as the design requirements. A review letter, signed and sealed by the professional engineer responsible for connection design, shall be provided with the shop drawings and calculations submittal stating that this review and verification has been completed.

1.7 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For Installer and Fabricator.
- B. Welding certificates.
- C. Mill test reports for structural-steel materials, including chemical and physical properties.
- D. Product Test Reports: For the following:
 1. Bolts, nuts, and washers, including mechanical properties and chemical analysis.
- E. Survey of existing conditions.
- F. Source quality-control reports.
- G. Field quality-control reports.

1.8 QUALITY ASSURANCE

- A. Fabricator Qualifications: A qualified fabricator that participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category BU or is accredited by the IAS Fabricator Inspection Program for Structural Steel (Acceptance Criteria 172).
- B. Installer Qualifications: A qualified Installer who participates in the AISC Quality Certification Program and is designated an AISC-Certified Erector, Category CSE.
- C. Welding Qualifications: Qualify procedures and personnel in accordance with AWS D1.1/D1.1M.
 - 1. Welders and welding operators performing work on bottom-flange, demand-critical welds shall pass the supplemental welder qualification testing, as required by AWS D1.8/D1.8M. FCAW-S and FCAW-G shall be considered separate processes for welding personnel qualification.

1.9 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 corrosion and deterioration.
 - 1. 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.
- B. 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 F3125/F3125M, Grade F1852 bolt assemblies and for retesting bolt assemblies after lubrication.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. Comply with applicable provisions of the following specifications and documents:
 - 1. ANSI/AISC 303.
 - 2. ANSI/AISC 360.

3. RCSC's "Specification for Structural Joints Using High-Strength Bolts."

B. Connection Design Information:

1. Option 1: Connection designs have been completed and connections indicated on the Drawings.
2. Option 3 and 3B: Design connections and final configuration of member reinforcement at connections in accordance with ANSI/AISC 303 by fabricator's qualified professional engineer.
 - a. Use Load and Resistance Factor Design; data are given at factored-load level.

C. Moment Connections: Type FR, fully restrained.

2.2 STRUCTURAL-STEEL MATERIALS

- A. W-Shapes: ASTM A992, Grade 50
- B. Channels, Angles: ASTM A36 Grade 36
- C. Plate and Bar: ASTM A36 Grade 36.
- D. Cold-Formed Hollow Structural Sections: ASTM A500/A500M, Grade C structural tubing.
- E. Welding Electrodes: Comply with AWS requirements.

2.3 BOLTS AND CONNECTORS

- A. High-Strength A325 Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A325 Type 1, heavy-hex steel structural bolts; ASTM A563, Grade DH, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers; all with plain finish.

2.4 RODS

- A. Threaded Rods: ASTM A36 Grade 36.
 1. Nuts: ASTM A563 heavy-hex carbon steel.
 2. Washers: ASTM F436, Type 1, hardened carbon steel.
 3. Finish: Plain

2.5 PRIMER

- A. Steel Primer:

1. Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer complying with MPI#79 and compatible with topcoat.

2.6 FABRICATION

- A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate in accordance with ANSI/AISC 303 and to ANSI/AISC 360.
 1. Camber structural-steel members where indicated.
 2. Fabricate beams with rolling camber up.
 3. Identify high-strength structural steel in accordance with ASTM A6/A6M and maintain markings until structural-steel framing 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 in accordance with SSPC-SP 3.
- F. Holes: Provide holes required for securing other work to structural steel and for other work to pass through steel 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.

2.7 SHOP CONNECTIONS

- A. High-Strength Bolts: Shop install high-strength bolts in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts" for type of bolt and type of joint specified.
 1. Joint Type: **Snug tightened.**

- B. Weld Connections: Comply with AWS D1.1 for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.
 - 1. Assemble and weld built-up sections by methods that maintain true alignment of axes without exceeding tolerances in ANSI/AISC 303 for mill material.

2.8 SHOP PRIMING

- A. Shop prime steel surfaces, except the following:
 - 1. Surfaces to be field welded.
 - 2. Surfaces to receive sprayed fire-resistive materials (applied fireproofing).
- B. Surface Preparation of Steel: Clean surfaces to be painted. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces in accordance with the following specifications and standards:
 - 1. SSPC-SP 3.
- C. Priming: Immediately after surface preparation, apply primer in accordance with 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.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Verify, with certified steel erector present, elevations and dimensions of existing structure for compliance with requirements.
 - 1. Prepare a certified survey of existing conditions, showing dimensions, locations, angles, and elevations.
- B. Proceed with installation only after existing conditions have been verified compliant with the structural drawings, fabrication drawings, and erection drawings.

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 on Drawings.
 - 1. Do not remove temporary shoring supporting composite deck construction and structural-steel framing 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 in accordance with ANSI/AISC 303 and ANSI/AISC 360.
- B. Maintain erection tolerances of structural steel within ANSI/AISC 303.
- C. Align and adjust various members that form part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that are in permanent contact with members. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 - 1. Level and plumb individual members of structure. Slope roof framing members to match existing roof slopes.
 - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure is completed and in service.
- D. Splice members only where indicated.
- E. Do not use thermal cutting during erection.
- F. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.

3.4 FIELD CONNECTIONS

- A. High-Strength Bolts: Install high-strength bolts in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts" for bolt and joint type specified.
 - 1. Joint Type: Snug tightened.
- B. Weld Connections: Comply with AWS D1.1 for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.

1. Comply with ANSI/AISC 303 and ANSI/AISC 360 for bearing, alignment, adequacy of temporary connections, and removal of paint on surfaces adjacent to field welds.
2. Remove backing bars or runoff tabs where indicated, back gouge, and grind steel smooth.
3. Assemble and weld built-up sections by methods that maintain true alignment of axes without exceeding tolerances in ANSI/AISC 303 for mill material.

3.5 REPAIR

A. Touchup Painting:

1. Immediately after erection, clean exposed areas where primer is damaged or missing, and paint with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 - a. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC-SP 3 power-tool cleaning.

3.6 SPECIAL INSPECTIONS

A. Special Inspections: Owner will engage a special inspector to perform the following special inspections:

1. Verify structural-steel materials and inspect steel frame joint details.
2. Bolted Connections: Inspect and test bolted connections in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts."
3. Welded Connections: Visually inspect field welds in accordance with AWS D1.1/D1.1M.
 - a. In addition to visual inspection, test and inspect field welds in accordance with AWS D1.1/D1.1M and the following inspection procedures, at testing agency's option:
 - 1) Liquid Penetrant Inspection: ASTM E165/E165M.
 - 2) Magnetic Particle Inspection: ASTM E709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration are not accepted.
 - 3) Ultrasonic Inspection: ASTM E164.
 - 4) Radiographic Inspection: ASTM E94/E94M.
- 4.

END OF SECTION 051200