

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.
- 2. Shrinkage-resistant grout.

- B. Related Requirements:

- 1. Section 099113 "Exterior Painting" and Section 099123 "Interior Painting" for painting requirements.

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 selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written 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.

1.5 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. Anchor rods.
4. Threaded rods.
5. Shop primer.
6. Galvanized-steel primer.
7. Etching cleaner.
8. Galvanized repair paint.
9. Shrinkage-resistant grout.

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.

1.7 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For Installer, fabricator, testing agency.
- B. Welding certificates.
- C. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.
- D. Mill test reports for structural-steel materials, including chemical and physical properties.
- E. Source quality-control reports.
- F. Field quality-control reports.

1.8 QUALITY ASSURANCE

- A. Fabricator Qualifications: A qualified fabricator that has at least 10 years of similar project experience.
- B. Installer Qualifications: A qualified Installer that has at least 5 years of similar project experience.
- C. Shop-Painting Applicators: Qualified in accordance with AISC's Sophisticated Paint Endorsement P1 or to SSPC-QP 3.
- D. Welding Qualifications: Qualify procedures and personnel in accordance with AWS D1.1/D1.1M.

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.
- B. Connection Design Information:
 - 1. Fabricator's experienced steel detailer shall select or complete connections in accordance with ANSI/AISC 303.
 - a. Select and complete connections using schematic details indicated and ANSI/AISC 360.

2.2 STRUCTURAL-STEEL MATERIALS

- A. W-Shapes: ASTM A992/A992M.
- B. Channels, Angles: ASTM A36/A36M.
- C. Plate and Bar: ASTM A36/A36M.
- D. Corrosion-Resisting (Weathering) Structural-Steel Shapes, Plates, and Bars: ASTM A588/A588M, 50 ksi (345 MPa).
- E. Cold-Formed Hollow Structural Sections: ASTM A500/A500M, Grade B structural tubing.

- F. Corrosion-Resisting (Weathering), Cold-Formed Hollow Structural Sections: ASTM A847/A847M structural tubing.
- G. Steel Pipe: ASTM A53/A53M, Type E or Type S, Grade B.
 - 1. Weight Class: As indicated.
 - 2. Finish: Black except where indicated to be galvanized.
- H. Welding Electrodes: Comply with AWS requirements.

2.3 BOLTS AND CONNECTORS

- A. High-Strength A325 Bolts, Nuts, and Washers: ASTM F3125/F3125M, **Grade A325 (Grade A325M)**, Type 1, heavy-hex steel structural bolts; **ASTM A563, Grade DH (ASTM A563M, Class 10S)**, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers; all with plain finish.
 - 1. Direct-Tension Indicators: ASTM F959/F959M, **Type 325-1 (Type 8.8-1)**, compressible-washer type with plain finish.
- B. High-Strength A490 Bolts, Nuts, and Washers: ASTM F3125/F3125M, **Grade A490 (Grade A490M)**, Type 1, heavy-hex steel structural bolts or Grade F2280 tension-control, bolt-nut-washer assemblies with splined ends; **ASTM A563, Grade DH (ASTM A563M, Class 10S)**, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers; all with plain finish.
 - 1. Direct-Tension Indicators: ASTM F959/F959M, **Type 490-1 (Type 10.9-1)**, compressible-washer type with plain finish.
- C. Zinc-Coated High-Strength A325 Bolts, Nuts, and Washers: ASTM F3125/F3125M, **Grade A325 (Grade A325M)**, Type 1, heavy-hex steel structural bolts; **ASTM A563, Grade DH (ASTM A563M, Class 10S)**, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers.
 - 1. Finish: Hot-dip or mechanically deposited zinc coating.
 - 2. Direct-Tension Indicators: ASTM F959/F959M, **Type 325-1 (Type 8.8-1)**, compressible-washer type with mechanically deposited zinc coating finish.
- D. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F3125/F3125M, Grade F1852, Type 1, heavy-hex head assemblies, consisting of steel structural bolts with splined ends; **ASTM A563, Grade DH (ASTM A563M, Class 10S)**, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers.
 - 1. Finish: Plain.

2.4 RODS

- A. Headed Anchor Rods: ASTM F1554, Grade 36, straight.
 - 1. Nuts: **ASTM A563 (ASTM A563M)** heavy-hex carbon steel.

2. Plate Washers: ASTM A36/A36M carbon steel.
3. Washers: **ASTM F436** (**ASTM F436M**), Type 1, hardened carbon steel.
4. Finish: Plain.

B. Threaded Rods: ASTM A36/A36M.

1. Nuts: **ASTM A63** (**ASTM A563M**) heavy-hex carbon steel.
2. Washers: **ASTM F436** (**ASTM F436M**), Type 1, hardened carbon steel.
3. Finish: Plain.

2.5 PRIMER

A. Steel Primer:

1. Comply with Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."
2. SSPC-Paint 23, latex primer.
3. Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer complying with MPI#79 and compatible with topcoat.

B. Galvanized-Steel Primer: MPI#26.

1. Etching Cleaner: MPI#25, for galvanized steel.
2. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20.

2.6 SHRINKAGE-RESISTANT GROUT

- A. Nonmetallic, Shrinkage-Resistant Grout: ASTM C1107/C1107M, factory-packaged, nonmetallic aggregate grout, noncorrosive and nonstaining, mixed with water to consistency suitable for application and a 30-minute working time.

2.7 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 2.
- F. Welded-Steel Door Frames: Build up welded-steel door frames attached to structural-steel frame. Weld exposed joints continuously and grind smooth. Plug-weld fixed steel bar stops to frames. Secure removable stops to frames with countersunk machine screws, uniformly spaced not more than **10 inches (250 mm)** o.c. unless otherwise indicated on Drawings.
- G. 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.
 - 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.

2.8 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/D1.1M and AWS D1.8/D1.8M 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.

2.9 GALVANIZING

- A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process to structural steel in accordance with ASTM A123/A123M.
 - 1. Fill vent and drain holes that are exposed in the finished Work unless they function as weep holes, by plugging with zinc solder and filing off smooth.
 - 2. Galvanize lintels, shelf angles and welded door frames attached to structural-steel frame and located in exterior walls.

2.10 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 (50 mm)**.
 - 2. Surfaces to be field welded.

3. Surfaces of high-strength bolted, slip-critical connections.
 4. Surfaces to receive sprayed fire-resistive materials (applied fireproofing).
 5. Galvanized surfaces.
 6. Corrosion-resisting (weathering) steel surfaces.
- 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 2.
 2. SSPC-SP 3.
 3. SSPC-SP 7 (WAB)/NACE WAB-4.
 4. SSPC-SP 14 (WAB)/NACE WAB-8.
 5. SSPC-SP 11.
 6. SSPC-SP 6 (WAB)/NACE WAB-3.
 7. SSPC-SP 10 (WAB)/NACE WAB-2.
 8. SSPC-SP 5 (WAB)/NACE WAB-1.
 9. SSPC-SP 8.
- C. Surface Preparation of Galvanized Steel: Prepare galvanized-steel surfaces for shop priming by thoroughly cleaning steel of grease, dirt, oil, flux, and other foreign matter, and treating with etching cleaner or in accordance with SSPC-SP 16.
- D. 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 (0.038 mm)**. 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.

2.11 SOURCE QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified testing agency to perform shop tests and inspections.
1. Allow testing agency access to places where structural-steel work is being fabricated or produced to perform tests and inspections.
 2. Bolted Connections: Inspect shop-bolted connections in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts."
 3. Welded Connections: Visually inspect shop-welded connections in accordance with AWS D1.1/D1.1M and the following inspection procedures, at testing agency's option:
 - a. Liquid Penetrant Inspection: ASTM E165/E165M.
 - b. Magnetic Particle Inspection: ASTM E709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration are not accepted.
 - c. Ultrasonic Inspection: ASTM E164.
 - d. Radiographic Inspection: ASTM E94/E94M.

4. Prepare test and inspection reports.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Verify, with certified steel erector present, elevations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments 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 on Drawings.

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. Baseplates, Bearing Plates and Leveling Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting plates. Clean bottom surface of plates.
 1. Set plates for structural members on wedges, shims, or setting nuts as required.
 2. Weld plate washers to top of baseplate.
 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 plate before packing with grout.
 4. Promptly pack shrinkage-resistant grout solidly between bearing surfaces and plates, so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for grouting.
- C. Maintain erection tolerances of structural steel within ANSI/AISC 303.
- D. 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 slopes indicated on Drawings.
- E. Splice members only where indicated.

- F. Do not use thermal cutting during erection.
- G. 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/D1.1M and AWS D1.8/D1.8M 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, 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 INSTALLATION OF PREFABRICATED BUILDING COLUMNS

- A. Install prefabricated building columns to comply with ANSI/AISC 360, manufacturer's written recommendations, and requirements of testing and inspecting agency that apply to the fire-resistance rating indicated.

3.6 REPAIR

- A. Galvanized Surfaces: Clean areas where galvanizing is damaged or missing, and repair galvanizing to comply with ASTM A780/A780M.
- B. 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.
 - 2. Cleaning and touchup painting are specified in Section 099113 "Exterior Painting." Section 099123 "Interior Painting."
- C. Touchup Priming: Cleaning and touchup priming are specified in Section 099600 "High-Performance Coatings."

3.7 FIELD QUALITY CONTROL

- 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. Verify weld materials and inspect welds.
 - 3. Verify connection materials and inspect high-strength bolted connections.

- B. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.
 - 1. Bolted Connections: Inspect bolted connections in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts."
 - 2. 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.

END OF SECTION 051200