

SECTION 051200 - STRUCTURAL STEEL FRAMING

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:

1. Structural-steel materials.
2. Shrinkage-resistant grout.

B. Related Requirements:

1. Section 099600 "High-Performance Coatings" for painting requirements.

1.2 DEFINITIONS

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

B. AESS: Architecturally Exposed Structural Steel.

C. Category AESS 3: Structural steel that is categorized by ANSI/AISC 303, Section 10, as AESS 3 and is designated as AESS 3 or Category AESS 3 in the Contract Documents.

1.3 COORDINATION

A. 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.

1.4 PREINSTALLATION MEETINGS

A. Preinstallation Conference: Conduct conference at Project site.

1.5 ACTION SUBMITTALS

A. Product Data:

1. Structural-steel materials.
2. High-strength, bolt-nut-washer assemblies.
3. Anchor rods.
4. Threaded rods.
5. Shrinkage-resistant grout.

B. Shop Drawings: Show fabrication of structural-steel components.

1. Include details of cuts, connections, 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. 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, including the following:
1. Power source (constant current or constant voltage).
 2. Electrode manufacturer and trade name, for demand-critical welds.

1.6 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. Field quality-control reports.

1.7 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) and is experienced in fabricating AECS similar to that indicated on this Project.
- B. Installer Qualifications: A qualified Installer who participates in the AISC Quality Certification Program and is designated an AISC-Certified Erector, Category ACSE and is experienced in erecting AECS similar to that indicated on this Project.
- C. Welding Qualifications: Qualify procedures and personnel in accordance with AWS D1.1/D1.1M.

1.8 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.

- 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 360.
 - 2. RCSC's "Specification for Structural Joints Using High-Strength Bolts."
 - 3. Comply with requirements of ANSI/AISC 303, Sections 1 through 9 and as modified in Section 10, "Architecturally Exposed Structural Steel."
- B. Connection Design Information:
 - 1. Option 1: Connection designs have been completed and connections indicated on the Drawings.

2.2 STRUCTURAL-STEEL MATERIALS

- A. Angles: ASTM A36/A36M.
- B. Plate and Bar: ASTM A36/A36M unless noted otherwise on drawings.
- C. Cold-Formed Hollow Structural Sections: ASTM A500/A500M, Grade C structural tubing.
- D. Steel Pipe: ASTM A53/A53M, Type E or Type S, Grade B.
- E. Welding Electrodes: Comply with AWS requirements.

2.3 BOLTS AND CONNECTORS

- A. High-Strength A325 Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A325N, 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. Unheaded Anchor Rods: ASTM F1554, Grade 36.

1. Configuration: Hooked unless noted otherwise on structural drawings.
 2. Nuts: ASTM A563 heavy-hex carbon steel.
 3. Plate Washers: ASTM A36/A36M carbon steel.
 4. Washers: ASTM F436, Type 1, hardened carbon steel.
 5. Finish: Hot-dip zinc coating, ASTM A153/A153M, Class C.
- B. Headed Anchor Rods: ASTM F1554, Grade 36, unless noted otherwise on Structural Drawings, straight.
1. Nuts: ASTM A563 heavy-hex carbon steel.
 2. Plate Washers: ASTM A36/A36M carbon steel.
 3. Washers: ASTM F436, Type 1, hardened carbon steel.
 4. Finish: Hot-dip zinc coating, ASTM A153/A153M, Class C.

2.5 FILLER

- A. Polyester filler intended for use in repairing dents in automobile bodies.

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. Identify high-strength structural steel in accordance with ASTM A6/A6M and maintain markings until structural-steel framing has been erected.
 2. Mark and match-mark materials for field assembly.
 3. 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. 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.

F. Steel Identified as Category AESS 3:

1. Comply with overall profile dimensions of AWS D1.1/D1.1M for welded built-up members. Keep appearance and quality of welds consistent. Maintain true alignment of members without warp exceeding specified tolerances.
2. Prepare surfaces according to Part 2 "Shop Priming" Article and SSPC-SP 6 (WAB)/NACE WAB-3.
3. Grind sheared, punched, and flame-cut edges to remove burrs and provide smooth surfaces and eased edges.
4. Make intermittent welds appear continuous, using filler or additional welding.
5. Seal weld open ends of hollow structural sections with 3/8-inch closure plates.
6. Limit butt and plug weld projections to 1/16 inch.
7. Install bolt heads on the same side of each connection and maintain orientation consistently from one connection to another.
8. Remove weld spatter, slivers, and similar surface discontinuities.
9. Remove blemishes and surface irregularities resulting from temporary braces or fixtures by filling or grinding, before cleaning, treating, and shop priming.
10. Grind tack welds smooth unless incorporated into final welds.
11. Remove backing and runoff tabs and grind welds smooth.
12. Limit as-fabricated straightness tolerance to one-half that permitted for structural-steel materials in ANSI/AISC 303.
13. Limit as-fabricated curved structural steel tolerance to that permitted for structural-steel materials in ANSI/AISC 303.
14. Limit as-fabricated straightness tolerance of welded built-up members to one-half that permitted by AWS D1.1/D1.1M.
15. Conceal fabrication and erection markings from view in the completed structure.
16. Make welds uniform and smooth.
17. Cut out mill marks from mill material or hide these markings from view in the completed structure. Where neither method is possible, remove mill marks by grinding and filling surfaces as approved by Architect.
18. Grind butt and plug welds smooth or fill, removing weld splatter exposed to view.
19. Orient HSS seams as indicated or away from view.
20. Align and match abutting member cross sections.
21. At visible open joints of copes, miters, and cuts, maintain uniform clear gaps of 1/8 inch. At closed joints, maintain uniform contact within 1/16 inch.
22. Fabricate with exposed surfaces smooth, square, and of surface quality approved by Architect.

2.8 SHOP CONNECTIONS

- A. 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.

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. Do not quench or apply post-galvanizing treatments that might interfere with paint adhesion.
2. 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.

2.10 SOURCE QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform quality control 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. 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.
 3. 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. Examine AESS for twists, kinks, warping, gouges, and other imperfections before erecting.
- C. 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.
 - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure is completed and in service.
- 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.
- G. Take special care during erection to avoid marking or distorting the AESS and to minimize damage to shop painting. Set AESS accurately in locations and to elevations indicated and according to ANSI/AISC 303 and ANSI/AISC 360.
 - 1. Remove welded tabs that were used for attaching temporary bracing and safety cabling and that are exposed to view in the completed Work. Take care to avoid any blemishes, holes, or unsightly surfaces resulting from the use or removal of temporary elements.
 - 2. Grind tack welds smooth.
 - 3. Remove backing and runoff tabs and grind welds smooth.
 - 4. Orient bolt heads on the same side of each connection and maintain orientation consistently from one connection to another.
 - 5. Conceal fabrication and erection markings from view in the completed structure.
- H. In addition to ANSI/AISC 303, Section 10 requirements comply with the following.
 - 1. Erection of Category AESS 3:
 - a. Erect AESS to the standard frame tolerances specified in ANSI/AISC 303 for

- non-AESS.
- b. Comply with AWS D1.1/D1.1M. Keep appearance and quality of welds consistent. Maintain true alignment of members without warp exceeding specified tolerances.
- c. Remove weld spatter, slivers, and similar surface discontinuities.
- d. Grind off butt and plug weld projections larger than 1/16 inch.
- e. Continuous welds are to be of uniform size and profile.
- f. Ream holes that must be enlarged. Use of drift pins or burning is not permitted. Replace misaligned connection plates where holes cannot be aligned with acceptable appearance.
- g. Splice members only where indicated on Drawings.
- h. No torch cutting or field fabrication is permitted.
- i. Weld profiles, quality, and finish are to be as approved by Architect.
- j. Make joint welds, including tack welds, appear continuous by filling intermittent welds.

3.4 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: Contractor to engage a qualified testing agency to perform quality control tests and inspections.
 - 1. Bolted Connections: Inspect and test 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.
 - 3. Radiographic Inspection: ASTM E94/E94M

END OF SECTION 051200