

2. Ultrasonic inspection to ISO 17640.
3. Magnetic particle inspection to ISO 9934.

H. The extent of non-destructive testing shall be as given in Table 1-1 below.

Table 1-1: Extent of Non-Destructive Examination

Type of Weld	Visual Inspection	Radiography	Ultrasonic	Magnetic Particle
Butt weld up to 50mm	100%	100%	N/A	100%
Butt weld over 50mm	100%	N/A	100%	100%
Tee joint full penetration	100%	N/A	100%	100%
Tee joint partial penetration	100%	N/A	N/A	100%
Fillet welds	100%	N/A	N/A	100%

- I. Any proposed repair work shall be reported to the Engineer and repair shall only proceed after authorization by the Engineer.

1.3.4 Field Erection

- A. Erection shall be to BS 5950.
- B. Erection of structural steelwork shall commence only after the foundation or other structure over which steelwork is to be erected is inspected, checked and approved by the Engineer.
- C. The Contractor shall check foundations regarding level, alignment, etc., and any necessary remedial work shall be performed well in advance of the steel erection.
- D. All fabricated steelwork shall be true and on its designed location with members plumb and level.
- E. Steel base plates shall be welded, shimmed or supported at the required elevations, set level and true and left in a stable condition whilst waiting to be grouted.
- F. Temporary bracing shall be provided during erection of steel as required for proper alignment and stability of the framing assembly. The bracing members shall be designed and located to carry all imposed loads to which the structure may be subjected while construction operations are underway.
- G. As erection progresses, the work shall be securely bolted, or welded, to minimize all dead load, wind and erection stresses. Wherever material, erection equipment or