

- C. Fabrication shall be carried out in the shop to the fullest extent possible with connection and joint details designed and arranged to reduce fieldwork to a minimum.
- D. Components to be shipped loose shall be fabricated in the largest units' possible compatible with safe handling.

1.3.2 Connections

- A. As far as possible shop connections shall be welded. High strength friction grip bolts may be used when welding is impracticable. Connections shall be in accordance with BS 5950.
- B. All mating surfaces of structural connections formed by friction grip bolting shall be abrasive blast cleaned to a minimum degree of surface cleanliness of Sa2½ and shall be immediately masked to prevent corrosion. The masking shall not be removed until immediately prior to joint assembly.
- C. Suitable mastic shall be used for sealing the friction grip joint to prevent the ingress of moisture and corrosive materials.
- D. Field connections shall be made with bolts to BS 4190 for ladders, stair stringers, removable members and floor plates, platform framing and purlins. All other connections shall be made with high strength friction grip bolts.
- E. Not less than two bolts shall be used in end connections. Minimum size of structural bolts shall be generally 20 mm diameter.
- F. Bolt heads and nuts shall bear evenly on the surfaces of the members they connect, using washers as appropriate. Bevel washers shall be furnished where the surface of a bolted part has a slope of more than 1 to 20 to compensate for lack of parallelism. Washers shall be used under the heads of all bolts and nuts.
- G. Holes that must be enlarged to admit bolts shall be reamed. Drifting shall not be allowed.
- H. Torch cutting of holes shall not be permitted at any time.

1.3.3 Welding

- A. Notwithstanding the requirements of ISO 15609-1 the following shall be considered essential variables and shall require requalification of the welding procedure
 - 1. Any change in type of groove or any change from single sided to double sided.
 - 2. Any change of welding consumables from those used in the qualification test.