

3.2.3 Materials - Aluminium

- A. Extruded Aluminum: ASTM B221, Alloy 6063, Temper T5. DIN 4113.
- B. Sheet Aluminium: ASTM B209, BS 1470 Alloy, Temper.
- C. Aluminium-Alloy Drawn Seamless Tubes: ASTM B210, Alloy 6063, Temper T6.
- D. Aluminium-Alloy Bars: ASTM B211, Alloy 6063 BS 1474, Temper T6.
- E. Aluminium-Alloy Sand Castings: ASTM B26, Alloy.
- F. Aluminium-Alloy Die Castings: ASTM B85, Alloy, Temper.
- G. Bolts, Nuts, and Washers: Stainless steel ASTM F738M, Nuts, and Washers F836M. Steel, galvanised to ASTM A153.
- H. Welding Materials: AWS D1.1; type required for materials being welded BS 3571 - inert-gas metal-arc welding.

3.2.4 Fabrication

- A. Fit and shop assemble items in largest practical sections, for delivery to site.
- B. Fabricate items with joints tightly fitted and secured to US Federal Specifications FF-B-558/FF-S-92/FF-S-111/FF-S-325/FF-W-92/DIN 18800 Part 7.
- C. Continuously seal joined members by continuous welds.
- D. Grind exposed joints flush and smooth with adjacent finish surface. Make exposed joints butt tight, flush, and hairline. Ease exposed edges to small uniform radius.
- E. Exposed Mechanical Fastenings: Flush countersunk screws or bolts; unobtrusively located; consistent with design of component, except where specifically noted otherwise.
- F. Supply components required for anchorage of fabrications. Fabricate anchors and related components of same material and finish as fabrication, except where specifically noted otherwise.

3.2.5 Fabrication Tolerances

- A. Square ness: 3 mm maximum difference in diagonal measurements.
- B. Maximum Offset between Faces: 1.5 mm.
- C. Maximum Misalignment of Adjacent Members: 1.5 mm.
- D. Maximum Bow: 3 mm in 1.2 m.
- E. Maximum Deviation from Plane: 1.5 mm in 1.2 m.