

HYER STANDARDS

Structural Steel Fabrication and Erection

The Hansen Yuncken HYer Standards provide guidance on the minimum level of compliance expected for high risk activities on all projects.

Materials and Fabrication



- Steel grade must be per structural design requirements and identifiable at all stages of fabrication.
- Steel members are to be fabricated to dimensions specified in shop drawings.
- Connection plates and bolt holes are to be the correct size per shop drawings.
- Steel members are to be fabricated to allow for services penetrations per shop drawings (if applicable).

Installation



- Footings must reach their required concrete strength.
- Holding down bolts must be the correct size/location.
- Holding down bolts are to be pull-tested and approved for erection.
- All bolts must be checked, and torque verified 24 hours after erection.
- The steel members delivered must be of the correct size and grade.
- Bolts/nuts/ washers must comply with structural design requirements
- Levelling shims/packers are to be per specified requirements.
- Steel members must be installed per structural design/shop drawings.
- Column verticality/alignment and spacing of steel members must meet specified requirements and be suitable for subsequent trades.

Welding and Finishing



- A welding procedure must be developed by a qualified welding supervisor and communicated to welders.
- Welders must have appropriate qualifications/competencies.
- Qualified welding supervisors must supervise welding activities.
- Non-destructive testing (NDT) must be conducted on the welds.
- Abrasive blasting is to be carried out on the steel as specified.
- Protective coating must be correct type/grade and applied to the specified thickness
- All required base plates must be grouted.

Compliance

Hold Points

- Welding Procedure approved.
- Welder qualifications approved.
- Shop drawings approved and issued for fabrication.
- Surface Treatment Protective coating system approved.
- Delivery of elements.

Supporting Records

- Steel Heat Grade/Mill Certificates.
- Welding Procedure.
- Qualifications / Competencies.
- Non-Destructive Test (NDT) Reports.
- Protective Coating Compliance Certificate.
- Hot-Dip Galvanising Compliance Certificate (if applicable).
- Steel survey report.



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**STRUCTURAL STEEL FABRICATION
AND ERECTION PROCEDURE**