SECTION 05 12 00
STRUCTURAL STEEL FRAMING

PART 1 - GENERAL

1.01 RELATED SECTIONS

A. Division 1 Sections

1.02 REFERENCES

AISC – Steel Construction Manual, 14th Edition.

AISC 303 – Code of Standard Practice for Steel Buildings and Bridges.

AISC 341-10 – Seismic Provisions for Structural Steel Buildings dated June 22, 2010.

AISC 360-10 – Specification for Structural Steel Buildings.

AISC – Specification for Structural Joints Using ASTM A325 or A490 Bolts prepared by the Research Council on Structural Connections.

AWS D1.1 – Structural Welding Code.

AWS A5.1 – Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding.

AWS A5.5 – Specification for Low-Alloy Steel Electrodes for Shielded Metal Arc Welding.

AWS A5.17 – Specification for Carbon Steel Electrodes and Fluxes for Submerged Arc Welding.

AWS A5.20 – Carbon Steel Electrodes for Flux Cored Arc Welding.

SSPC – Steel Structures Painting Manual.

ASTM A6 – Standard Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling.

ASTM A29 - Standard Specification for Steel Bars, Carbon and Alloy, Hot-Wrought, General Requirements for Grades 1010 through 1020.

ASTM A36 – Standard Specification for Carbon Structural Steel.

ASTM A53 – Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless

ASTM A123 – Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products.

ASTM A153 – Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware.

ASTM A307 – Standard Specification for Carbon Steel Bolts, Studs, and Threaded Rod 60,000 PSI Tensile Strength.

ASTM A325 – Standard Specification for Structural Bolts, Steel, Heat Treated, 120/105 KSI Minimum Tensile Strength.

ASTM A490 – Standard Specification for Structural Bolts, Alloy Steel, Heat-Treated, 150 KSI Minimum Tensile Strength.

ASTM A500 – Standard Specification for Cold-Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes.

ASTM A501 – Standard Specification for Hot-Formed Welded and Seamless Carbon Steel Structural Tubing.

ASTM A563 – Standard Specification for Carbons and Alloy Steel Nuts

ASTM A572 – Standard Specification for High-Strength Low-Alloy Columbium Vanadium Structural Steel.

ASTM A673 – Standard Specification for Sampling Procedure for Impact Testing of Structural Steel

ASTM A780 – Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings.

ASTM A992 – Standard Specification for Structural Steel Shapes.

ASTM A1085 – Standard Specification for Cold-Formed Welded Carbon Steel Hollow Structural Sections (HSS)

ASTM B695 – Standard Specification for Coatings of Zinc Mechanically Deposited on Iron and Steel

ASTM F436 – Standard Specification for Hardened Steel Washers.

ASTM F844 – Standard Specification for Washers, Steel, Plain (Flat), Unhardened for General Use.

ASTM F1554 – Standard Specification for Anchor Bolts, Steel, 36, 55, and 105-Ksi Yield Strength.

ASTM F1852 – Standard Specification for “Twist Off” Type Tension Control Structural Bolt/Nut/Washer Assemblies, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength.

ASTM F2280 – Standard Specification for “Twist Off” Type Tension Control Structural Bolt/Nut/Washer Assemblies, Steel, Heat Treated, 150 ksi Minimum Tensile Strength.

1.03 SUBMITTALS

A. Refer to Structural Quality Assurance Plan in the Structural Drawings for additional submittal requirements.

B. Shop Drawings:
   1. Contact Structural Engineer’s Construction Administrator prior to detailing structural steel shop drawings.
   2. Shop drawings shall be submitted on a 24” x 36” sheet minimum.

3. Shop drawings shall clearly indicate the profiles, sizes, ASTM Grade, spacing and locations of structural steel members, including connections, attachments, anchorages, framed openings, sizes and types of fasteners, method of tightening fasteners, cambers, and the number, type and spacing of the stud shear connectors and headed studs.
4. Beam sizes shall be shown on the erection drawings (plans).
5. Submit shop drawings for review.
6. Reproduction of Structural Drawings for shop drawings is not permitted. Electronic drawing files will not be provided to the Contractor.

C. Maintain at construction office written welding procedures for each type of welded joint used in accordance with AWS D1.1.

D. Submit certification that the fabricator meets the required qualifications and ultrasonic testing reports for complete penetration welds. If fabricator has an independent testing agency inspect fabrication as required by these specifications, submit the name and qualifications of the independent testing agency.

E. Upon request, submit the erection sequence and procedures to be used by the steel erector.

1.04 QUALITY ASSURANCE

A. Refer to the Structural Quality Assurance Plan in the Structural Drawings.

1.05 STORAGE

A. Store materials off ground to permit easy access for inspection and identification. Store steel members and packaged items in a manner that provides protection against contact with deleterious materials.

1.06 FABRICATOR'S QUALIFICATIONS

A. Steel fabricator shall meet the requirements in the Structural Quality Assurance Plan in the Structural Drawings.

PART 2 - PRODUCTS

2.01 ANCHOR RODS

A. Anchor Rods: Headed rod or a threaded rod with a heavy hexagonal nut and plate washer welded to the bottom of the threaded rod conforming to ASTM F1554.

B. Nuts and Washers: Two hexagonal nuts and two plate washers conforming to ASTM A36 for each anchor rod assembly.

2.02 PLATES

A. Plates : ASTM A36

2.03 PIPE STEEL STRUCTURAL SECTIONS

A. Pipe Structural Sections: ASTM A53, Gr. B, 35 ksi minimum yield strength.

2.04 NON-HIGH-STRENGTH FASTENERS

A. Non-High-Strength Bolts: ASTM A307, Grade A, 60 ksi minimum, where noted on the Structural Drawings.

B. Hardened Steel Washers: ASTM F436.

2.05 EXPANSION ANCHORS

A. Expansion Anchors: See Structural Notes.

2.06 SCREW ANCHORS

A. Screw Anchors: See Structural Notes.

2.07 HEADED STUDS

A. Headed Studs: shall conform to the requirements of AWS D1.1. Provide studs with the diameter shown on the Structural Drawings.

2.08 WELD ELECTRODES

A. Weld Electrodes: AWS A5.1, A5.5, A5.I7, or A5.20 E-70 series low hydrogen electrodes.

B. Properly store electrodes to maintain flux quality.

2.09 PAINT

A. Oxide Primer: AISC Specifications, Code of Standard Practice, and SSPC Steel Structure Painting Manual, unless indicated otherwise.

B. Paint Primer: Free of lead and chromate and comply with State and Federal volatile organic compound (VOC) requirements.

C. Paint Primer: Compatible with finish coating.

PART 3 - EXECUTION

3.01 GENERAL

A. Fabricate and erect structural steel in accordance with AISC Specifications and Code of Standard Practice.

B. Notify Architect/Structural Engineer and Structural Testing/Inspection Agency at least 48 hours prior to structural steel fabrication and erection.

3.02 ANCHOR ROD SETTING

A. Provide templates for setting anchor rods. Position anchor rods by using templates with two nuts to secure in place prior to placement of concrete.

B. Do not erect steel where anchor rod nuts will not have full threads.

3.03 EXPANSION ANCHOR INSTALLATION

A. Install in accordance with manufacturer's recommendation and the ICC ESR report for the particular anchor used.

B. Minimum Embedment: See Structural Notes on Drawings.

3.04 SCREW ANCHOR INSTALLATION

A. Install in accordance with manufacturer's recommendation and the ICC ESR report for the particular anchor used.

B. Minimum Embedment: See Structural Notes on Drawings.

3.05 HEADED STUDS

A. Headed studs shall be installed in accordance with AWS D1.1 with the resulting in-place length after burn-off as shown on the Structural Drawings.

B. Do not locate headed studs closer than 1-1/4 inches from the edge of embedded steel member to the centerline of the stud.

C. Remove ceramic arc shields after welding studs.

3.06 WELDING

A. Comply with AWS D1.1. Use prequalified weld procedures.

B. Provide end returns where fillet welds terminate at ends or sides. Returns shall be continuous for a distance of not less than two times the nominal size of the weld.

C. Remove all slag and weld splatter from deposited weld metal.

3.07 MILL SCALE

A. Remove loose mill scale.

3.08 BOLT HOLES

A. Cut, drill, or punch holes perpendicular to metal surfaces. Do not enlarge holes by burning. Drill or punch holes in bearing plates. Remove burrs.

3.09 PAINTING

A. Paint steel that is not encased in concrete, plaster, or sprayed fireproofing. Do not shop paint in areas to be field welded, contact surfaces of slip critical connections, or areas to receive special finishes.

B. Field paint as required steel that has been welded or that is unpainted after connections have been tightened.

END OF SECTION