

**SECTION 05 12 00**  
**STRUCTURAL STEEL FRAMING**

**PART 1 - GENERAL**

**1.1 DESCRIPTION:**

A. This section specifies structural steel shown and classified by Section 2, Code of Standard Practice for Steel Buildings and Bridges.

**1.2 QUALITY ASSURANCE:**

A. Fabricator and erector shall maintain a program of quality assurance in conformance with Section 8, Code of Standard Practice for Steel Buildings and Bridges. Work shall be fabricated in an AISC certified Category Std fabrication plant.

B. Before authorizing the commencement of steel erection, the controlling contractor shall ensure that the steel erector is provided with the written notification required by 29 CFR 1926.752. Provide copy of this notification to the Contracting Officers Representative (COR).

**1.3 TOLERANCES:**

A. Fabrication tolerances for structural steel shall be held within limits established by ASTM A6, by AISC 303, Sections 6 and 7, Code of Standard Practice for Buildings and Bridges, except as follows:

B. Elevation tolerance for closure plates at the building perimeter and at slab openings prior to concrete placement is 6 mm (1/4 inch).

**1.4 DESIGN:**

A. Connections: Design and detail all connections for each member size, steel grade and connection type to resist the loads and reactions indicated on the drawings or specified herein. Use details consistent with the details shown on the Drawings, supplementing where necessary. The details shown on the Drawings are conceptual and do not indicate the required weld sizes or number of bolts unless specifically noted. Use rational engineering design and standard practice in detailing, accounting for all loads and eccentricities in both the connection and the members. Promptly notify the COR of any location where the connection design criteria is not clearly indicated. The design of all connections is subject to the review and acceptance of the COR. Submit structural calculations prepared and sealed by a qualified engineer registered in the state where the project is located. Submit calculations for review before preparation of detail drawings.

**1.5 REGULATORY REQUIREMENTS:**

- A. AISC 360: Specification for Structural Steel Buildings
- B. AISC 303: Code of Standard Practice for Steel Buildings and Bridges.

**1.6 SUBMITTALS:**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Shop and Erection Drawings: Complete
- C. Certificates:
  - 1. Structural steel.
  - 2. Steel for all connections.
  - 3. Welding materials.
  - 4. Shop coat primer paint.
- D. Test Reports:
  - 1. Welders' qualifying tests.
- E. Design Calculations and Drawings:
  - 1. Connection calculations, if required.
- F. Record Surveys.

**1.7 APPLICABLE PUBLICATIONS:**

- A. Publications listed below form a part of this specification to extent referenced. Publications are referenced in text by basic designation only.
- B. American Institute of Steel Construction (AISC):
  - 1. AISC 360-10 Specification for Structural Steel Buildings
  - 2. AISC 303-10 Code of Standard Practice for Steel Buildings and Bridges
- C. American National Standards Institute (ANSI):
  - 1. B18.22.1-65(R2008) Plain Washers
  - 2. B18.22M-81(R2000) Metric Plain Washers
- D. American Society for Testing and Materials (ASTM):
  - 1. A6/A6M-11 .....Standard Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling
  - 2. A36/A36M-08 ....Standard Specification for Carbon Structural Steel
  - 3. A53/A53M-10 ....Standard Specification for Pipe, Steel and Hot-Dipped, Zinc-Coated Welded and Seamless
  - 4. A123/A123M-09 ..Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
  - 5. A242/A242M-04(R2009) Standard Specification for High-Strength Low-Alloy Structural Steel

6. A283/A283M-03(R2007) Standard Specification for Low and Intermediate Tensile Strength Carbon Steel Plates
  7. A307-10 .....Standard Specification for Carbon Steel Bolts and Studs, 60,000 psi Tensile Strength
  8. A325-10 .....Standard Specification for Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength
  9. A490-12 .....Standard Specification for Heat-Treated Steel Structural Bolts 150 ksi Minimum Tensile Strength
  10. A500/A500M-10a Standard Specification for Cold Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes
  11. A501-07 .....Standard Specification for Hot-Formed Welded and Seamless Carbon Steel Structural Tubing
  12. A572/A572M-07 .Standard Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel
  13. A992/A992M-11 .Standard Specification for Structural Steel Shapes
- E. American Welding Society (AWS):
1. D1.1/D1.1M-10 ..Structural Welding Code-Steel
- F. Research Council on Structural Connections (RCSC) of The Engineering Foundation: Specification for Structural Joints Using ASTM A325 or A490 Bolts
- G. Military Specifications (Mil. Spec.):
1. MIL-P-21035 ....Paint, High Zinc Dust Content, Galvanizing, Repair
- H. Occupational Safety and Health Administration (OSHA):
1. 29 CFR Part 1926-2001 Safety Standards for Steel Erection

## **PART 2 - PRODUCTS**

### **2.1 MATERIALS:**

- A. Structural Steel: ASTM A572, Grade A992.
- B. Structural Tubing: ASTM A500, Grade B.
- C. Structural Tubing: ASTM A501.
- D. Steel Pipe: ASTM A53, Grade B.
- E. Bolts, Nuts and Washers:
  1. High-strength bolts, including nuts and washers: ASTM A325.
  2. Plain washers, other than those in contact with high-strength bolt heads and nuts: ANSI Standard B18.22.1.
- F. Zinc Coating: ASTM A123.
- G. Galvanizing Repair Paint: Mil. Spec. MIL-P-21035.

**PART 3 - EXECUTION**

**3.1 CONNECTIONS (SHOP AND FIELD):**

- A. Welding: Welding in accordance with AWS D1.1. Welds shall be made only by welders and welding operators who have been previously qualified by tests as prescribed in AWS D1.1 to perform type of work required.
- B. High-Strength Bolts: High-strength bolts tightened to a bolt tension not less than 70% of their minimum tensile strength. Tightening done with properly calibrated wrenches, by turn-of-nut method or by use of direct tension indicators (bolts or washers). Tighten bolts in connections identified as slip-critical using Direct Tension Indicators. Twist-off torque bolts are not an acceptable alternate fastener for slip critical connections.

**3.2 FABRICATION:**

Fabrication in accordance with Chapter M, AISC 360. .

**3.3 SHOP PAINTING:**

- A. Zinc Coated (Hot Dip Galvanized) per ASTM A123 (after fabrication):  
Touch-up after erection: Clean and wire brush any abraded and other spots worn through zinc coating, including threaded portions of bolts and welds and touch-up with galvanizing repair paint.

**3.4 ERECTION:**

- A. General: Erection in accordance with AISC 303, Section 7B. Temporary Supports: Temporary support of structural steel frames during erection in accordance with AISC 303, Section 7

**3.5 SURVEY:**

- A. Upon completion of finish bolting or welding on any part of the work, and prior to start of work by other trades that may be supported, attached, or applied to the structural steel work, submit a certified report of survey to COR for approval. Reports shall be prepared by Registered Land Surveyor or Registered Civil Engineer as specified in Section 01 00 00, GENERAL REQUIREMENTS. Report shall specify that location of structural steel is acceptable for plumbness, level and alignment within specified tolerances specified in the AISC Manual.

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