

**SECTION 051200 STRUCTURAL STEEL FRAMING**

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:

1. Structural steel.
2. Shear stud connectors, shop and field welded.
3. Shrinkage-resistant grout.

B. Related Requirements:

1. Section 053100 "Steel Decking" for field installation of shear stud connectors through deck.
2. Section 055000 "Metal Fabrications" for steel lintels and shelf angles not attached to structural-steel frame, miscellaneous steel fabrications, and other steel items not defined as structural steel.
3. Section 099113 "Exterior Painting" and Section 099123 "Interior Painting" and Section 099600 "High-Performance Coatings" for painting requirements.
4. Section 018113 "Sustainable Design Requirements"

1.2 DEFINITIONS

A. Structural Steel: Elements of the structural frame indicated on Drawings and as described in ANSI/AISC 303.

B. Heavy Sections: Rolled and built-up sections as follows:

1. Shapes included in ASTM A6/A6M with flanges thicker than 1-1/2 inches.
2. Welded built-up members with plates thicker than 2 inches.
3. Column base plates thicker than 2 inches.

1.3 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.

B. Coordinate installation of anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, sheet metal templates, instructions, and directions for installation.

1.4 PREINSTALLATION MEETINGS

A. Preinstallation Conference: Conduct conference at Project site.

1.5 ACTION SUBMITTALS

A. Product Data:

1. Structural-steel materials.
2. High-strength, bolt-nut-washer assemblies.
3. Shear stud connectors.
4. Anchor rods.
5. Threaded rods.
6. Shop primer.
7. Galvanized-steel primer.
8. Etching cleaner.
9. Shrinkage-resistant grout.

**B. Shop Drawings: Show fabrication of structural-steel components.**

1. Include details of cuts, connections, splices, camber, holes, and other pertinent data.
2. Include embedment Drawings.
3. Indicate welds by standard AWS symbols, distinguishing between shop and field welds, and show size, length, and type of each weld. Show backing bars that are to be removed and supplemental fillet welds where backing bars are to remain.
4. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical, high-strength bolted connections.

**C. Welding Procedure Specifications (WPSs) and Procedure Qualification Records (PQRs): Provide in accordance with AWS D1.1/D1.1M for each welded joint whether prequalified or qualified by testing or qualified by testing, including the following:**

1. Power source (constant current or constant voltage).
2. Electrode manufacturer and trade name, for demand-critical welds.

**D. Delegated Design Submittal: For structural-steel connections indicated on Drawings to comply with design loads, include analysis data signed and sealed by the qualified professional engineer responsible for their preparation.**

**1.6 INFORMATIONAL SUBMITTALS**

**A. Qualification Data: For Installer, fabricator, shop-painting applicators, professional engineer, and testing agency.**

**B. Welding certificates.**

**C. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.**

**D. Mill test reports for structural-steel materials, including chemical and physical properties.**

**E. Product Test Reports: For the following:**

1. Bolts, nuts, and washers, including mechanical properties and chemical analysis.
2. Direct-tension indicators.
3. Tension-control, high-strength, bolt-nut-washer assemblies.
4. Shear stud connectors.

**F. Survey of existing conditions.**

**G. Source quality-control reports.**

H. Field quality-control reports.

#### 1.7 QUALITY ASSURANCE

- A. Fabricator Qualifications: A qualified fabricator that participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category BU or is accredited by the IAS Fabricator Inspection Program for Structural Steel (Acceptance Criteria 172).
- B. Installer Qualifications: A qualified Installer who participates in the AISC Quality Certification Program and is designated an AISC-Certified Erector, Category CSE.
- C. Shop-Painting Applicators: Qualified in accordance with AISC's Sophisticated Paint Endorsement P1, Endorsement P2, or Endorsement P3 or to SSPC-QP 3.
- D. Welding Qualifications: Qualify procedures and personnel in accordance with AWS D1.1/D1.1M.
  - 1. Welders and welding operators performing work on bottom-flange, demand-critical welds shall pass the supplemental welder qualification testing, as required by AWS D1.8/D1.8M. FCAW-S and FCAW-G shall be considered separate processes for welding personnel qualification.

#### 1.8 DELIVERY, STORAGE, AND HANDLING

- A. Store materials to permit easy access for inspection and identification. Keep steel members off ground and spaced by using pallets, dunnage, or other supports and spacers. Protect steel members and packaged materials from corrosion and deterioration.
  - 1. Do not store materials on structure in a manner that might cause distortion, damage, or overload to members or supporting structures. Repair or replace damaged materials or structures as directed.
- B. Store fasteners in a protected place in sealed containers with manufacturer's labels intact.
  - 1. Fasteners may be repackaged provided Owner's testing and inspecting agency observes repackaging and seals containers.
  - 2. Clean and relubricate bolts and nuts that become dry or rusty before use.
  - 3. Comply with manufacturers' written recommendations for cleaning and lubricating ASTM F3125/F3125M, Grade F1852 bolt assemblies and for retesting bolt assemblies after lubrication.

### PART 2 - PRODUCTS

#### 2.1 PERFORMANCE REQUIREMENTS

- A. Comply with applicable provisions of the following specifications and documents:
  - 1. ANSI/AISC 303.
  - 2. ANSI/AISC 360.
  - 3. RCSC's "Specification for Structural Joints Using High-Strength Bolts."
- B. Connection Design Information:

1. Option 3 and 3B: Design connections and final configuration of member reinforcement at connections in accordance with ANSI/AISC 303 by fabricator's qualified professional engineer.
  - a. Use Load and Resistance Factor Design; data are given at factored-load level or Allowable Stress Design; data are given at service-load level.

C. Moment Connections: Type FR, fully restrained.

D. Construction: Shear wall system

## 2.2 STRUCTURAL-STEEL MATERIALS

A. W-Shapes: ASTM A992/A992M

B. Channels, Angles: ASTM A36/A36M

C. Plate and Bar: ASTM A36/A36M

D. Cold-Formed Hollow Structural Sections: ASTM A500/A500M, Grade B structural tubing

E. Steel Pipe: ASTM A53/A53M, Type E or Type S, Grade B.

1. Weight Class: Standard
2. Finish: Black except where indicated to be galvanized.

F. Steel Castings: ASTM A216/A216M, Grade WCB, with supplementary requirement S11.

G. Steel Forgings: ASTM A668/A668M.

H. Welding Electrodes: Comply with AWS requirements.

## 2.3 BOLTS AND CONNECTORS

A. High-Strength A325 Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A325 (Grade A325M), Type 1, heavy-hex steel structural bolts; ASTM A563, Grade DH (ASTM A563M, Class 10S), heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers; all with plain finish.

1. Direct-Tension Indicators: ASTM F959/F959M, Type 325-1 (Type 8.8-1), compressible-washer type with plain finish.

B. Zinc-Coated High-Strength A325 Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A325 (Grade A325M), Type 1, heavy-hex steel structural bolts; ASTM A563, Grade DH (ASTM A563M, Class 10S), heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers.

1. Finish: Hot-dip or mechanically deposited zinc coating.
2. Direct-Tension Indicators: ASTM F959/F959M, Type 325-1 (Type 8.8-1), compressible-washer type with mechanically deposited zinc coating finish.

C. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F3125/F3125M, Grade F1852, Type 1, heavy-hex head assemblies, consisting of steel structural bolts with splined

ends; ASTM A563, Grade DH (ASTM A563M, Class 10S), heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers.

1. Plain or mechanically deposited zinc coating.

D. Shear Stud Connectors: ASTM A108, AISI C-1015 through C-1020, headed-stud type, cold-finished carbon steel; AWS D1.1/D1.1M, Type B.

## 2.4 RODS

A. Unheaded Anchor Rods: ASTM F1554, Grade 36 or ASTM F1554, Grade 55, weldable

1. Configuration: Straight.
2. Nuts: ASTM A563 (ASTM A563M) heavy-hex carbon steel.
3. Plate Washers: ASTM A36/A36M carbon steel.
4. Washers: ASTM F436 (ASTM F436M), Type 1, hardened carbon steel.
5. Finish: Plain, Hot-dip zinc coating, ASTM A153/A153M, Class C, or Mechanically deposited zinc coating, ASTM B695, Class 50.

B. Headed Anchor Rods: ASTM F1554, Grade 36 or ASTM F1554, Grade 55, weldable, straight.

1. Nuts: ASTM A563 (ASTM A563M) heavy-hex carbon steel.
2. Plate Washers: ASTM A36/A36M carbon steel.
3. Washers: ASTM F436 (ASTM F436M), Type 1, hardened carbon steel.
4. Finish: Plain, Hot-dip zinc coating, ASTM A153/A153M, Class C, or Mechanically deposited zinc coating, ASTM B695, Class 50.

C. Threaded Rods: ASTM A36/A36M

1. Nuts: ASTM A63 (ASTM A563M) heavy-hex carbon steel.
2. Washers: ASTM F436 (ASTM F436M), Type 1, hardened or ASTM A36/A36M carbon steel.
3. Finish: Plain, Hot-dip zinc coating, ASTM A153/A153M, Class C, or Mechanically deposited zinc coating, ASTM B695, Class 50.

## 2.5 PRIMER

A. Steel Primer:

1. Comply with Section 099113 "Exterior Painting," Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."
2. SSPC-Paint 23, latex primer.
3. Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer complying with MPI#79 and compatible with topcoat.

B. Galvanized-Steel Primer: MPI#26, MPI#80, or MPI#134.

1. Etching Cleaner: MPI#25, for galvanized steel.
2. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20, ASTM A780/A780M.

2.6 SHRINKAGE-RESISTANT GROUT

- A. Metallic, Shrinkage-Resistant Grout: ASTM C1107/C1107M, factory-packaged, metallic aggregate grout, mixed with water to consistency suitable for application and a 30-minute working time.
- B. Nonmetallic, Shrinkage-Resistant Grout: ASTM C1107/C1107M, factory-packaged, nonmetallic aggregate grout, noncorrosive and non-staining, mixed with water to consistency suitable for application and a 30-minute working time.

2.7 FABRICATION

- A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate in accordance with ANSI/AISC 303 and to ANSI/AISC 360.
  - 1. Camber structural-steel members where indicated.
  - 2. Fabricate beams with rolling camber up.
  - 3. Identify high-strength structural steel in accordance with ASTM A6/A6M and maintain markings until structural-steel framing has been erected.
  - 4. Mark and match-mark materials for field assembly.
  - 5. Complete structural-steel assemblies, including welding of units, before starting shop-priming operations.
- B. Thermal Cutting: Perform thermal cutting by machine to greatest extent possible.
  - 1. Plane thermally cut edges to be welded to comply with requirements in AWS D1.1/D1.1M.
- C. Bolt Holes: Cut, drill, mechanically thermal cut, or punch standard bolt holes perpendicular to metal surfaces.
- D. Finishing: Accurately finish ends of columns and other members transmitting bearing loads.
- E. Cleaning: Clean and prepare steel surfaces that are to remain unpainted in accordance with SSPC-SP 1, SSPC-SP 2, or SSPC-SP 3.
- F. Shear Stud Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Weld using automatic end welding of headed-stud shear connectors in accordance with AWS D1.1/D1.1M and manufacturer's written instructions.
- G. Steel Wall-Opening Framing: Select true and straight members for fabricating steel wall-opening framing to be attached to structural-steel frame. Straighten as required to provide uniform, square, and true members in completed wall framing. Build up welded framing, weld exposed joints continuously, and grind smooth.
- H. Welded-Steel Door Frames: Build up welded-steel door frames attached to structural- steel frame. Weld exposed joints continuously and grind smooth. Plug-weld fixed steel bar stops to frames. Secure removable stops to frames with countersunk machine screws, uniformly spaced not more than 10 inches o.c. unless otherwise indicated on Drawings.
- I. Holes: Provide holes required for securing other work to structural steel and for other work to pass through steel members.

1. Cut, drill, or punch holes perpendicular to steel surfaces. Do not thermally cut bolt holes or enlarge holes by burning.
2. Baseplate Holes: Cut, drill, mechanically thermal cut, or punch holes perpendicular to steel surfaces.
3. Weld threaded nuts to framing and other specialty items indicated to receive other work.

## 2.8 SHOP CONNECTIONS

- A. High-Strength Bolts: Shop install high-strength bolts in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts" for type of bolt and type of joint specified.
  1. Joint Type: Snug tightened, Pretensioned, or Slip critical.
- B. Weld Connections: Comply with AWS D1.1/D1.1M and AWS D1.8/D1.8M for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.
  1. Assemble and weld built-up sections by methods that maintain true alignment of axes without exceeding tolerances in ANSI/AISC 303 for mill material.

## 2.9 GALVANIZING

- A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process to structural steel in accordance with ASTM A123/A123M.
  1. Fill vent and drain holes that are exposed in the finished Work unless they function as weep holes, by plugging with zinc solder and filing off smooth.
  2. Galvanize lintels, shelf angles, and welded door frames attached to structural-steel frame and located in exterior walls.

## 2.10 SHOP PRIMING

- A. Shop prime steel surfaces, except the following:
  1. Surfaces embedded in concrete or mortar. Extend priming of partially embedded members to a depth of 2 inches.
  2. Surfaces to be field welded.
  3. Surfaces of high-strength bolted, slip-critical connections.
  4. Surfaces to receive sprayed fire-resistive materials (applied fireproofing).
  5. Galvanized surfaces unless indicated to be painted.
  6. Corrosion-resisting (weathering) steel surfaces.
  7. Surfaces enclosed in interior construction.
- B. Surface Preparation of Steel: Clean surfaces to be painted. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces in accordance with the following specifications and standards:
  1. SSPC-SP 2.
  2. SSPC-SP 3.
- C. Surface Preparation of Galvanized Steel: Prepare galvanized-steel surfaces for shop priming by thoroughly cleaning steel of grease, dirt, oil, flux, and other foreign matter, and treating with etching cleaner or in accordance with SSPC-SP 16.

- D. Priming: Immediately after surface preparation, apply primer in accordance with manufacturer's written instructions and at rate recommended by SSPC to provide a minimum dry film thickness of 1.5 mils. Use priming methods that result in full coverage of joints, corners, edges, and exposed surfaces.
  - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.
  - 2. Apply two coats of shop paint to surfaces that are inaccessible after assembly or erection. Change color of second coat to distinguish it from first.

## 2.11 SOURCE QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified testing agency to perform shop tests and inspections.
  - 1. Allow testing agency access to places where structural-steel work is being fabricated or produced to perform tests and inspections.
  - 2. Bolted Connections: Inspect and test shop-bolted connections in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts."
  - 3. Welded Connections: Visually inspect shop-welded connections in accordance with AWS D1.1/D1.1M and the following inspection procedures, at testing agency's option:
    - a. Liquid Penetrant Inspection: ASTM E165/E165M.
    - b. Magnetic Particle Inspection: ASTM E709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration are not accepted.
    - c. Ultrasonic Inspection: ASTM E164.
    - d. Radiographic Inspection: ASTM E94/E94M.
  - 4. In addition to visual inspection, test and inspect shop-welded shear stud connectors in accordance with requirements in AWS D1.1/D1.1M for stud welding and as follows:
    - a. Perform bend tests if visual inspections reveal either a less-than- continuous 360-degree flash or welding repairs to any shear stud connector.
    - b. Conduct tests in accordance with requirements in AWS D1.1/D1.1M on additional shear stud connectors if weld fracture occurs on shear stud connectors already tested.
  - 5. Prepare test and inspection reports.

## PART 3 - EXECUTION

### 3.1 EXAMINATION

- A. Verify, with certified steel erector present, elevations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments for compliance with requirements.
  - 1. Prepare a certified survey of existing conditions. Include bearing surfaces, anchor rods, bearing plates, and other embedments showing dimensions, locations, angles, and elevations.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

### 3.2 PREPARATION

- A. Provide temporary shores, guys, braces, and other supports during erection to keep structural steel secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural steel, connections, and bracing are in place unless otherwise indicated on Drawings.
  - 1. Do not remove temporary shoring supporting composite deck construction and structural-steel framing until cast-in-place concrete has attained its design compressive strength.

### 3.3 ERECTION

- A. Set structural steel accurately in locations and to elevations indicated and in accordance with ANSI/AISC 303 and ANSI/AISC 360.
- B. Baseplates, Bearing Plates, and Leveling Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting plates. Clean bottom surface of plates.
  - 1. Set plates for structural members on wedges, shims, or setting nuts as required.
  - 2. Weld plate washers to top of baseplate.
  - 3. Snug-tighten or Pretension anchor rods after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of plate before packing with grout.
  - 4. Promptly pack shrinkage-resistant grout solidly between bearing surfaces and plates, so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for grouting.
- C. Maintain erection tolerances of structural steel within ANSI/AISC 303.
- D. Align and adjust various members that form part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that are in permanent contact with members. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
  - 1. Level and plumb individual members of structure. Slope roof framing members to slopes indicated on Drawings.
  - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure is completed and in service.
- E. Splice members only where indicated.
- F. Do not use thermal cutting during erection unless approved by Architect. Finish thermally cut sections within smoothness limits in AWS D1.1/D1.1M.
- G. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.

### 3.4 FIELD CONNECTIONS

- A. High-Strength Bolts: Install high-strength bolts in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts" for bolt and joint type specified.

1. Joint Type: Snug tightened, Pretensioned, or Slip critical.
- B. Weld Connections: Comply with AWS D1.1/D1.1M and AWS D1.8/D1.8M for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.
  1. Comply with ANSI/AISC 303 and ANSI/AISC 360 for bearing, alignment, adequacy of temporary connections, and removal of paint on surfaces adjacent to field welds.
  2. Remove backing bars or runoff tabs where indicated, back gouge, and grind steel smooth.
  3. Assemble and weld built-up sections by methods that maintain true alignment of axes without exceeding tolerances in ANSI/AISC 303 for mill material.
- C. Shear Stud Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Weld using end welding of headed-stud shear connectors in accordance with AWS D1.1/D1.1M and manufacturer's written instructions.

### 3.5 REPAIR

- A. Galvanized Surfaces: Clean areas where galvanizing is damaged or missing, and repair galvanizing to comply with ASTM A780/A780M.
- B. Touchup Painting:
  1. Immediately after erection, clean exposed areas where primer is damaged or missing, and paint with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
    - a. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC- SP 3 power-tool cleaning.
  2. Cleaning and touchup painting are specified in Section 099113 "Exterior Painting.", Section 099123 "Interior Painting.", and Section 099600 "High- Performance Coatings."
- C. Touchup Priming: Cleaning and touchup priming are specified in Section 099600 "High-Performance Coatings."

### 3.6 FIELD QUALITY CONTROL

- A. Special Inspections: Owner will engage a special inspector to perform the following special inspections:
  1. Verify structural-steel materials and inspect steel frame joint details.
  2. Verify weld materials and inspect welds.
  3. Verify connection materials and inspect high-strength bolted connections.
- B. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.
  1. Bolted Connections: Inspect and test bolted connections in accordance with RCSC's "Specification for Structural Joints Using High-Strength Bolts."
  2. Welded Connections: Visually inspect field welds in accordance with AWS D1.1/D1.1M

- a. In addition to visual inspection, test and inspect field welds in accordance with AWS D1.1/D1.1M and the following inspection procedures, at testing agency's option:
  - 1) Liquid Penetrant Inspection: ASTM E165/E165M.
  - 2) Magnetic Particle Inspection: ASTM E709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration are not accepted.
  - 3) Ultrasonic Inspection: ASTM E164.
  - 4) Radiographic Inspection: ASTM E94/E94M.
3. Shear Stud Connectors: In addition to visual inspection, test and inspect field-welded shear connectors according to requirements in AWS D1.1/D1.1M for stud welding and as follows:
  - a. Perform bend tests if visual inspections reveal either a less-than-continuous 360-degree flash or welding repairs to any shear connector.
  - b. Conduct tests according to requirements in AWS D1.1/D1.1M on additional shear connectors if weld fracture occurs on shear connectors already tested.

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