PART 1 - GENERAL

1.1 SUMMARY

A. Includes But Not Limited To:
   1. Quality of structural bolts used on Project.
   2. Requirements and standards for site welded metal-to-metal connections.

B. Related Sections:
   1. Furnishing and installing of structural bolts specified under Section concerned.
   2. Performance of welding specified under Section concerned.

1.2 REFERENCES

A. American Society For Testing And Materials:
   1. ASTM A 36-03a, 'Standard Specification for Carbon Structural Steel.'
   2. ASTM A 307-03, 'Standard Specification for Carbon Steel Bolts and Studs, 60 000 psi Tensile Strength.'

B. American Welding Society / American National Standards Institute:
   1. AWS / ANSI D1.1-2003, 'Structural Welding Code - Steel.'
   2. AWS / ANSI D1.3-1998, 'Structural Welding Code - Sheet Steel.'

1.3 QUALITY ASSURANCE

A. Qualifications: Welders shall be certified 30 days minimum before beginning work on Project. If there is doubt as to proficiency of welder, Architect may require welder to take another test, at no expense to Owner. Certification shall be by Pittsburgh Laboratories or other authority approved by Architect.

B. Certifications: Maintain welder's certifications on job-site.

PART 2 - PRODUCTS

2.1 MANUFACTURED UNITS

A. Bolts And Threaded Fasteners:
   1. Anchor Rods For Steeple Base Connections: Conform to ASTM A 36.
   2. Bolts:
      a. Anchor Bolts: Non-headed type threaded 2 inches 50 mm minimum conforming to ASTM A 307, Grade A. Anchor hook to project 2 inches 50 mm minimum including bolt diameter.
      b. All Other Bolts: Conform to requirements of ASTM A 307, Grade A.

B. Arc-Welding Electrodes: Type E70XX AWS Iron and Steel Arc-welding electrodes and meeting current AISC Specifications.
PART 3 - EXECUTION

3.1 PERFORMANCE

A. Welding shall meet requirements of ANSI / AWS D1.1 and D1.3.

B. Minimum weld sizes, unless detailed otherwise.
   1. Weld pipe columns to base plates and top plates with 1/4 inch 6 mm fillet weld all around.
   2. Weld glu-lam connection side plates to base plates with 1/4 inch 6 mm fillet weld all along outside edges.
   3. Weld stiffeners to pipe columns with 1/4 inch 6 mm fillet weld all around.

C. Installation of bolts shall meet AISC requirements.

END OF SECTION