

PART 1 GENERAL

1.1 SCOPE:

- A. PROVIDE FABRICATION AND ERECTION OF STRUCTURAL STEEL AND OTHER ITEMS AS SHOWN ON THE DRAWINGS OR REQUIRED BY OTHER SECTIONS OF THESE SPECIFICATIONS.

1.2 REFERENCES:

- A. AMERICAN INSTITUTE OF STEEL CONSTRUCTION (AISC):
MANUAL OF STEEL CONSTRUCTION, ALLOWABLE STRESS DESIGN (ASD).
- B. AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM):
ASTM A36: STRUCTURAL STEEL
ASTM A53: PIPE, STEEL, BLACK AND HOT DIPPED, ZINC-COATED WELDED AND SEAMLESS
ASTM A108: STEEL BARS, CARBON, COLD FINISHED, STANDARD QUALITY.
ASTM A123: ZINC (HOT-DIP GALVANIZED) COATINGS ON IRON AND STEEL PRODUCTS.
ASTM A307: CARBON STEEL BOLTS AND STUDS, 60,000 PSI TENSILE STRENGTH.
ASTM A325: HIGH-STRENGTH BOLTS FOR STRUCTURAL STEEL JOINTS.
ASTM A490: HEAT-TREATED, STRUCTURAL STEEL BOLTS, 150 (KSI) (1035MPA) TENSILE STRENGTH.
ASTM A500: COLD-FORMED WELDED AND SEAMLESS CARBON STEEL STRUCTURAL TUBING IN ROUNDS AND SHAPES.
ASTM A563: CARBON AND ALLOY STEEL NUTS.
ASTM B695: COATINGS OF ZINC MECHANICALLY DEPOSITED ON IRON AND STEEL.
ASTM F436: HARDENED STEEL WASHERS.
ASTM F959: COMPRESSIBLE-WASHER-TYPE DIRECT TENSION INDICATOR FOR USE WITH STRUCTURAL FASTENERS.
- C. AMERICAN WELDING SOCIETY (AWS):
AWS A5.1: COVERED CARBON STEEL ARC WELDING ELECTRODES.
AWS A5.5: LOW ALLOY STEEL COVERED ARC WELDING ELECTRODES.
AWS D1.1: STRUCTURAL WELDING CODE - STEEL.
- D. RESEARCH COUNCIL ON STRUCTURAL CONNECTIONS (RCSC):
"SPECIFICATIONS FOR STRUCTURAL JOINTS USING ASTM A325 BOLTS OR ASTM A490 BOLTS," AS ENDORSED BY AISC.
- E. STEEL STRUCTURES PAINTING COUNCIL (SSPC):
SSPC-SP3: POWER TOOL CLEANING.
SSPC-PAINT 11: RED IRON OXIDE, ZINC CHROME, RAW LINSEED OIL AND ALKYD PAINT.

1.3 SUBMITTALS:

- A. SUBMIT THE FOLLOWING FOR APPROVAL:
- FABRICATION AND ERECTION DRAWINGS SHOWING ALL DETAILS, CONNECTIONS, MATERIAL DESIGNATIONS, AND ALL TOP OF STEEL ELEVATIONS.
- B. WELDERS SHALL BE QUALIFIED AS PRESCRIBED IN AWS D1.1.

PART 2 PRODUCTS

2.1 STRUCTURAL STEEL:

- A. SHAPES, PLATES AND BARS SHALL CONFORM TO ASTM A36.
- B. STRUCTURAL TUBING SHALL CONFORM TO ASTM A500, GRADE B.
- C. STEEL PIPE SHALL CONFORM TO ASTM A53, TYPE E OR S, GRADE B.

2.2 ANCHOR BOLTS:

- A. ANCHOR BOLTS SHALL CONFORM TO ASTM A307 WITH HEAVY HEXAGONAL NUTS.

2.3 BOLTS:

- A. COMMON (MACHINE) BOLTS SHALL CONFORM TO ASTM A307 GRADE A AND NUTS TO ASTM A563. ONE COMMON BOLT ASSEMBLY SHALL CONSIST OF A BOLT, A HEAVY HEX NUT AND A HARDENED WASHER.
- B. HIGH STRENGTH BOLTS SHALL CONFORM TO ASTM A325. ONE HIGH STRENGTH BOLT ASSEMBLY SHALL CONSIST OF A HEAVY HEX STRUCTURAL BOLT, A HEAVY HEX NUT, A HARDENED WASHER CONFORMING WITH ASTM F436 AND A DIRECT TENSION INDICATOR CONFORMING WITH ASTM F959. THE HARDENED WASHER SHALL BE INSTALLED AGAINST THE ELEMENT TURNED IN TIGHTENING.

2.4 WELDING ELECTRODES:

- A. WELDING ELECTRODES SHALL COMPLY WITH AWS D1.1 USING AWS A5.1 OR AWS A5.5 E70XX AND SHALL BE COMPATIBLE WITH THE WELDING PROCESS SELECTED.

2.5 PRIMER:

- A. PRIMER SHALL BE A RED OXIDE-CHROMATE PRIMER COMPLYING WITH SSPC PAINT SPECIFICATION NO. 11.

PART 3 EXECUTION

3.1 FABRICATION:

- A. SHOP FABRICATE AND ASSEMBLE MATERIALS AS SPECIFIED HEREIN.
- FABRICATE ITEMS OF STRUCTURAL STEEL IN ACCORDANCE WITH THE AISC-ASD SPECIFICATIONS, AND AS INDICATED ON THE APPROVED SHOP DRAWINGS.
 - ALL EXPOSED STRUCTURAL STEEL SHALL BE HOT DIP GALVANIZED PER ASTM.
 - PROPERLY MARK AND MATCH-MARK MATERIALS FOR FIELD ASSEMBLY AND FOR IDENTIFICATION AS TO LOCATION FOR WHICH INTENDED.
 - FABRICATE AND DELIVER IN A SEQUENCE WHICH WILL EXPEDITE ERECTION AND MINIMIZE FIELD HANDLING OF MATERIALS.
 - WHERE FINISHING IS REQUIRED, COMPLETE THE ASSEMBLY, INCLUDING WELDING OF UNITS, BEFORE START OF FINISHING OPERATIONS.
 - PROVIDE FINISH SURFACE OF MEMBERS EXPOSED IN THE FINAL STRUCTURE FREE FROM MARKINGS, BURRS, AND OTHER DEFECTS.
- B. PROVIDE CONNECTIONS AS SPECIFIED HEREIN.
- PROVIDE BOLTS AND WASHERS OF TYPES AND SIZE REQUIRED FOR COMPLETION OF FIELD ERECTION. USE 3/4 INCH DIAMETER A325N BOLTS UNLESS NOTED OTHERWISE.
 - INSTALL HIGH STRENGTH THREADED FASTENERS IN ACCORDANCE WITH AISC "SPECIFICATIONS FOR STRUCTURAL JOINTS USING ASTM A325 OR ASTM A490 BOLTS."
 - WELDED CONSTRUCTION SHALL COMPLY WITH AWS D1.1 FOR PROCEDURES, APPEARANCE, QUALITY OF WELDS, AND METHODS USED IN CORRECTING WELDED WORK.
 - THE FABRICATOR SHALL FURNISH AND INSTALL ERECTION CLIPS FOR FIT-UP OF WELDED CONNECTIONS.
 - DOUBLE ANGLE MEMBERS SHALL HAVE WELDED FILLERS SPACED IN ACCORDANCE WITH CHAPTER E4 OF THE AISC-ASD SPECIFICATION.
 - GUSSET AND STIFFENER PLATES SHALL BE 3/8 INCH THICK MINIMUM.

3.2 PRIMING:

- A. STRUCTURAL STEEL SHALL BE PRIMED AS SPECIFIED HEREIN, UNLESS SHOWN OTHERWISE ON THE DRAWINGS.
- B. STRUCTURAL STEEL SURFACE PREPARATION SHALL CONFORM TO SSPC- SP3, "POWER TOOL CLEANING."
- C. SURFACE PREPARATION AND PRIMER SHALL BE IN ACCORDANCE WITH AISC CODE OF STANDARD PRACTICE AS INCLUDED IN THE ASD MANUAL OF STEEL CONSTRUCTION.
- D. STORING, THINNING, MIXING, HANDLING AND APPLICATION OF PAINT MATERIALS SHALL REMAIN CLOSED UNTIL REQUIRED FOR USE. MANUFACTURER'S POT-LIFE REQUIREMENTS SHALL BE STRICTLY ADHERED TO.
- E. PRIMER SHALL BE APPLIED TO DRY, CLEAN, PREPARED SURFACES AND UNDER FAVORABLE CONDITIONS IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. UNLESS OTHERWISE RECOMMENDED BY THE MANUFACTURER, PRIMING SHALL NOT BE DONE WHEN AMBIENT TEMPERATURE IS LESS THAN 50° F, THE RELATIVE HUMIDITY IS MORE THAN 90 PERCENT, OR THE SURFACE TEMPERATURE IS LESS THAN 5° F ABOVE THE DEW POINT.
- F. GENERALLY, ALL PRIMER SHALL BE SPRAY APPLIED. BRUSH OR ROLLER APPLICATION SHALL BE RESTRICTED TO TOUCH-UP AND TO AREAS NOT ACCESSIBLE BY SPRAY GUN.
- G. PRIMER SHALL BE UNIFORMLY APPLIED WITHOUT RUNS, SAGS, SOLVENT BLISTERS, DRY SPRAY OR OTHER BLEMISHES. ALL BLEMISHES AND OTHER IRREGULARITIES SHALL BE REPAIRED OR REMOVED AND THE AREA RE-COATED. SPECIAL ATTENTION SHALL BE PAID TO CREVICES, WELD LINES, BOLT HEADS, CORNERS, EDGES, ETC., TO OBTAIN THE REQUIRED NOMINAL FILM THICKNESS.
- H. THE DRY FILM THICKNESS OF THE PRIMER SHALL BE 2.0 MILS.
- I. IF THE PRIMER IS DAMAGED BY WELDING OR PHYSICAL ABUSE, THE AREA SHALL BE TOUCHED-UP AND REPAIRED. THE TOUCH-UP PAINT SHALL BE COMPATIBLE WITH THE APPLIED PRIMER WITH MINIMUM DRY FILM THICKNESS OF 1.5 MILS.

3.3 INSTALLATION:

- A. INSTALLATION OF STRUCTURAL STEEL SHALL COMPLY WITH AISC "CODE OF STANDARD PRACTICE."
- B. STRUCTURAL FIELD WELDING SHALL BE DONE BY THE ELECTRIC SUBMERGED OR SHIELDED METAL ARC PROCESS. WELDED CONSTRUCTION SHALL COMPLY WITH AWS D1.1.
- C. PROVIDE ANCHOR BOLTS AND OTHER CONNECTORS REQUIRED FOR SECURING STRUCTURAL STEEL TO ELEVATOR SHAFT WALLS AND OTHER IN-PLACE WORK. PROVIDE TEMPLATES AND OTHER DEVICES NECESSARY FOR PRESETTING BOLTS AND ANCHORS TO ACCURATE LOCATIONS.
- D. SPLICE MEMBERS ONLY WHERE INDICATED ON THE DRAWINGS.
- E. ANY GAS CUTTING TORCHES HAVE TO BE APPROVED IN WRITING BY THE PROJECT STRUCTURAL ENGINEER.
- F. PROVIDE TEMPORARY SHORING AND BRACING WITH CONNECTIONS OF SUFFICIENT STRENGTH TO BEAR IMPOSED LOADS. REMOVE TEMPORARY CONNECTIONS AND MEMBERS WHEN PERMANENT MEMBERS ARE IN PLACE AND THE FINAL CONNECTIONS HAVE BEEN MADE.
- G. ALIGN AND ADJUST MEMBERS, AND OTHER SURFACES WHICH WILL BE IN THE PERMANENT CONTACT, BEFORE ASSEMBLY.
- H. INSTALL AND FULLY TENSION HIGH STRENGTH THREADED FASTENERS IN ACCORDANCE WITH AISC, "SPECIFICATIONS FOR STRUCTURAL JOINTS USING ASTM A325 OR ASTM A490 BOLTS."

END OF SECTION




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STATE OF MISSOURI
REGISTERED PROFESSIONAL ENGINEER
SHELTON D. KEISING
NUMBER E-20702

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REGISTERED PROFESSIONAL ENGINEER
SHELTON D. KEISING
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PROJECT NO: 852614-1

DRAWN BY: ANP

CHECKED BY: HAN/RWQ

SUBMITTALS			
A	04/21/05	ISSUED FOR REVIEW	ANP
0	05/03/05	ISSUED FOR CONSTRUCTION	MTG

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CITY OF O'FALLON
(USCC SITE NAME: ST. PAUL)

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SHEET TITLE
SPECIFICATIONS (4 OF 6)SHEET NUMBER
SP-4