

CONSTRUCTION SPECIFICATION

MI-172. METAL FABRICATION AND INSTALLATION

1. SCOPE

The work shall consist of furnishing, fabricating and erecting metal-work, including the metal parts of composite structures, as shown on the drawings.

2. MATERIALS

Unless otherwise specified, steel shall be structural quality. Castings shall be thoroughly cleaned and subjected to careful inspection before installation. Finished surfaces shall be smooth and true to assure proper fit. Galvanizing, where specified, shall be zinc coated by the hot dip process, except that bolts and other small hardware may be protected by electrodeposited zinc or cadmium coating.

3. FABRICATION

The materials shall be carefully fabricated as shown on the drawings. The fabrication shall be smooth and true to assure proper fit and pleasing appearance.

4. ERECTION

The frame of metal structures shall be carried up true and plumb. Temporary bracing shall be placed wherever necessary to resist all loads to which the structure may be subjected, including those applied by the installation and operation of equipment. Such bracing shall be left in place as long as may be necessary for safety.

As erection progresses, the work shall be securely bolted up, or welded, to resist all dead load, wind and erection stresses. The Contractor shall furnish such fitting up bolts, nuts and washers as may be required.

No riveting or welding shall be done until as much of the structure as will be stiffened thereby has been properly aligned.

Rivets driven in the field shall be heated and driven with the same care as those driven in the shop.

All field welding shall be done in conformance to the requirements for shop fabrication, except those that expressly apply to shop conditions only.

Galvanized items shall not be cut, welded or drilled after the zinc coating is applied.

5. PROTECTIVE COATINGS

Items specified to be galvanized shall be completely fabricated for field assembly before the application of the zinc coatings.