
SECTION 05 12 00
STRUCTURAL STEEL FRAMING**PART 1 GENERAL****1.1 SECTION INCLUDES**

- A. Structural steel framing members.
- B. Structural steel support members.
- C. Base plates, shear stud connectors.
- D. Grouting under base plates.

1.2 RELATED REQUIREMENTS

- A. Section 05 21 00 - Steel Joist Framing.
- B. Section 05 31 00 - Steel Decking: Support framing for small openings in deck.
- C. Section 05 50 00 - Miscellaneous Metals: Steel fabrications affecting structural steel work.

1.3 REFERENCE STANDARDS

- A. AISC (MAN) - Steel Construction Manual 2017.
- B. AISC 303 - Code of Standard Practice for Steel Buildings and Bridges 2022.
- C. ASTM A36/A36M - Standard Specification for Carbon Structural Steel 2019.
- D. ASTM A53/A53M - Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless 2022.
- E. ASTM A108 - Standard Specification for Steel Bar, Carbon and Alloy, Cold-Finished 2018.
- F. ASTM A153/A153M - Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware 2016a.
- G. ASTM A307 - Standard Specification for Carbon Steel Bolts, Studs, and Threaded Rod 60 000 PSI Tensile Strength 2021.
- H. ASTM A500/A500M - Standard Specification for Cold-Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes 2021a.
- I. ASTM A501/A501M - Standard Specification for Hot-Formed Welded and Seamless Carbon Steel Structural Tubing 2021.
- J. ASTM A563 - Standard Specification for Carbon and Alloy Steel Nuts 2021a.
- K. ASTM A563M - Standard Specification for Carbon and Alloy Steel Nuts (Metric) 2021a.
- L. ASTM A572/A572M - Standard Specification for High-Strength Low-Alloy Columbium-Vanadium Structural Steel 2021, with Editorial Revision.
- M. ASTM A992/A992M - Standard Specification for Structural Steel Shapes 2022.
- N. ASTM A1011/A1011M - Standard Specification for Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, and Ultra-High Strength 2018a.
- O. ASTM C1107/C1107M - Standard Specification for Packaged Dry, Hydraulic-Cement Grout (Nonshrink) 2020.
- P. ASTM E94/E94M - Standard Guide for Radiographic Examination Using Industrial Radiographic Film 2017.
- Q. ASTM E164 - Standard Practice for Contact Ultrasonic Testing of Weldments 2019.
- R. ASTM E165/E165M - Standard Practice for Liquid Penetrant Testing for General Industry 2018.

- S. ASTM E709 - Standard Guide for Magnetic Particle Testing 2021.
- T. ASTM F3125/F3125M - Standard Specification for High Strength Structural Bolts and Assemblies, Steel and Alloy Steel, Heat Treated, Inch Dimensions 120 ksi and 150 ksi Minimum Tensile Strength, and Metric Dimensions 830 MPa and 1040 MPa Minimum Tensile Strength 2022.
- U. ASTM F436/F436M - Standard Specification for Hardened Steel Washers Inch and Metric Dimensions 2019.
- V. ASTM F959/F959M - Standard Specification for Compressible-Washer-Type Direct Tension Indicators for Use with Structural Fasteners, Inch and Metric Series 2017a.
- W. AWS A2.4 - Standard Symbols for Welding, Brazing, and Nondestructive Examination 2020.
- X. AWS B2.1/B2.1M - Specification for Welding Procedure and Performance Qualification 2021.
- Y. AWS D1.1/D1.1M - Structural Welding Code - Steel 2020, with Errata (2022).
- Z. IAS AC172 - Accreditation Criteria for Fabricator Inspection Programs for Structural Steel AC172 2019.
- AA. RCSC (HSBOLT) - Specification for Structural Joints Using High-Strength Bolts; Research Council on Structural Connections 2020.
- BB. SSPC-Paint 15 - Steel Joist Shop Primer/Metal Building Primer 2004.
- CC. SSPC-SP 3 - Power Tool Cleaning 2018.
- DD. UL (FRD) - Fire Resistance Directory Current Edition.

1.4 SUBMITTALS

- A. See Section 01 30 00 - Administrative Requirements, for submittal procedures.
- B. Shop Drawings:
 - 1. Indicate profiles, sizes, spacing, locations of structural members, openings, attachments, and fasteners.
 - 2. Connections not detailed.
 - 3. Indicate cambers and loads.
 - 4. Indicate welded connections with AWS A2.4 welding symbols. Indicate net weld lengths.
- C. Manufacturer's Mill Certificate: Certify that products meet or exceed specified requirements.
- D. Mill Test Reports: Indicate structural strength, destructive test analysis and non-destructive test analysis.
- E. Fabricator Test Reports: Comply with ASTM A1011/A1011M.
- F. Welders' Qualification Statement: Welders' certificates in accordance with AWS B2.1/B2.1M and dated no more than 12 months before start of scheduled welding work.
- G. Fabricator's Qualification Statement: Provide documentation showing steel fabricator is approved in compliance with IBC 1704.2.2.

1.5 QUALITY ASSURANCE

- A. Fabricate structural steel members in accordance with AISC (MAN) "Steel Construction Manual."
- B. Structural steel members designated as architecturally-exposed structural steel (AESS) to also comply with Section 05 12 13.
- C. Maintain one copy of each document on site.
- D. Fabricator: Company specializing in performing the work of this section with minimum five years of documented experience.
- E. Welder Qualifications: Welding processes and welding operators qualified in accordance with AWS D1.1/D1.1M and no more than 12 months before start of scheduled welding work.

- F. Fabricator Qualifications: A qualified steel fabricator that is accredited by the International Accreditation Service (IAS) Fabricator Inspection Program for Structural Steel in accordance with IAS AC172.
- G. Erector: Company specializing in performing the work of this section with minimum five years of documented experience.
- H. Design connections not detailed on drawings under direct supervision of a Professional Structural Engineer experienced in design of this work and licensed in the State in which the Project is located.

PART 2 PRODUCTS**2.1 MATERIALS**

- A. Steel Angles and Channels: ASTM A36/A36M.
- B. Steel W Shapes and Tees: ASTM A992/A992M.
- C. Rolled Steel Structural Shapes: ASTM A992/A992M.
- D. Steel Plates and Bars: ASTM A572/A572M, Grade 50 (345) high-strength, columbium-vanadium steel.
- E. Cold-Formed Structural Tubing: ASTM A500/A500M, Grade B.
- F. Hot-Formed Structural Tubing: ASTM A501/A501M, seamless or welded.
- G. Pipe: ASTM A53/A53M, Grade B, Finish black.
- H. Shear Stud Connectors: Made from ASTM A108 Grade 1015 bars.
- I. High-Strength Structural Bolts, Nuts, and Washers: ASTM F3125/F3125M, Type 1, with matching compatible ASTM A563 or ASTM A563M nuts and ASTM F436/F436M washers.
- J. Headed Anchor Rods:
- K. Load Indicator Washers: Provide washers complying with ASTM F959/F959M at connections requiring high-strength bolts.
- L. Welding Materials: AWS D1.1/D1.1M; type required for materials being welded.
- M. Grout: ASTM C1107/C1107M; Non-shrink; premixed compound consisting of non-metallic aggregate, cement, water reducing and plasticizing agents.
 - 1. Minimum Compressive Strength at 48 Hours: 2,000 pounds per square inch.
 - 2. Minimum Compressive Strength at 28 Days: 7,000 pounds per square inch.
- N. Shop and Touch-Up Primer: Fabricator's standard, complying with VOC limitations of authorities having jurisdiction.

2.2 FABRICATION

- A. Shop fabricate to greatest extent possible.
- B. Continuously seal joined members by continuous welds. Grind exposed welds smooth.
- C. Fabricate connections for bolt, nut, and washer connectors.

2.3 FINISH

- A. Prepare structural component surfaces in accordance with SSPC-SP 3.
- B. Shop prime structural steel members. Do not prime surfaces that will be field welded, in contact with concrete, or high strength bolted.

2.4 SOURCE QUALITY CONTROL

- A. Provide shop testing and analysis of structural steel.
- B. High-Strength Bolts: Provide testing and verification of shop-bolted connections in accordance with RCSC (HSBOLT) "Specification for Structural Joints Using High-Strength Bolts," testing at least 25 percent

of bolts at each connection.

- C. Welded Connections: Visually inspect all shop-welded connections and test at least 25 percent of welds using one of the following:
1. Radiographic testing performed in accordance with ASTM E94/E94M.
 2. Ultrasonic testing performed in accordance with ASTM E164.
 3. Liquid penetrant inspection performed in accordance with ASTM E165/E165M.
 4. Magnetic particle inspection performed in accordance with ASTM E709.

PART 3 EXECUTION

3.1 EXAMINATION

- A. Verify that conditions are appropriate for erection of structural steel and that the work may properly proceed.

3.2 ERECTION

- A. Erect structural steel in compliance with AISC 303.
- B. Allow for erection loads and provide sufficient temporary bracing to maintain structure in safe condition, plumb, and in true alignment until completion of erection and installation of permanent bracing.
- C. Field weld components and shear studs indicated on shop drawings.
- D. Use carbon steel bolts only for temporary bracing during construction, unless otherwise specifically permitted on drawings. Install high-strength bolts in accordance with RCSC (HSBOLT) "Specification for Structural Joints Using High-Strength Bolts".
- E. Do not field cut or alter structural members without approval of Architect.
- F. After erection, prime welds, abrasions, and surfaces not shop primed, except surfaces to be in contact with concrete.
- G. Grout solidly between column plates and bearing surfaces, complying with manufacturer's instructions for nonshrink grout. Trowel grouted surfaces smooth, splaying neatly to 45 degrees.

3.3 TOLERANCES

- A. Maximum Variation From Plumb: 1/4 inch per story, non-cumulative.
- B. Maximum Offset From True Alignment: 1/4 inch.

3.4 FIELD QUALITY CONTROL

- A. An independent testing agency will perform field quality control tests, as specified in Section 01 40 00 - Quality Requirements.
- B. High-Strength Bolts: Provide testing and verification of field-bolted connections in accordance with RCSC (HSBOLT) "Specification for Structural Joints Using High-Strength Bolts," testing at least 25 percent of bolts at each connection.
- C. Welded Connections: Visually inspect all field-welded connections and test at least 25 percent of welds using one of the following:
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END OF SECTION 05 12 00