

G12 ISOLATED STRUCTURAL METAL MEMBERS

To be read with Preliminaries/ General conditions.

110 FABRICATION OF MEMBERS

- Steel sections: To BS 4-1, BS EN 10055, BS EN 10056 or BS EN 10210, as appropriate.
 - Steel: To BS EN 10025, grade S275.
 - Surface condition: Free from heavy pitting and rust, burrs, sharp edges and flame cutting dross.
- Cuts and holes: Accurate and neat.
- Welding: Metal arc method to BS EN 1011-2.
 - Welded joints: Fully fused, with mechanical properties not less than those of the parent metal.
 - Site welding: Obtain approval.

150 SHOP PRIMING

- Preparation: Loose scale and rust, burrs, fins, sharp edges and weld spatter removed; crevices cleaned out; surfaces thoroughly degreased, rinsed with clean water and allowed to dry.
- Primer: Zinc phosphate modified alkyd.
 - Application: One full coat within 8 hours of cleaning surfaces.

310 INSTALLATION

- Accuracy: Members positioned true to line and level using, if necessary, steel packs of sufficient area to allow full transfer of loads to bearing surfaces.
- Fixing: Use washers under bolt heads and nuts.
 - Tapered washers: Provide under bolt heads and nuts bearing on sloping surfaces. Match taper to slope angle and align correctly.