

**CODE OF STANDARD PRACTICE
FOR STEEL BUILDINGS AND BRIDGES**

SECTION 1. GENERAL PROVISIONS

1.1. Scope

This Code sets forth criteria for the trade practices involved in steel buildings, bridges, and other structures, where other structures are defined as those structures designed, fabricated, and erected in a manner similar to buildings, with building-like vertical and lateral load resisting elements. In the absence of specific instructions to the contrary in the *contract documents*, the trade practices that are defined in this Code shall govern the fabrication and erection of *structural steel*.

Commentary:

The practices defined in this Code are the commonly accepted standards of custom and usage for *structural steel* fabrication and erection, which generally represent the most efficient approach. This Code is not intended to define a professional standard of care for the *owners designated representative for design*, change the duties and responsibilities of the *owner*, contractor, *architect* or *structural engineer of record* from those set forth in the *contract documents*, or assign to the *owner*, *architect* or *structural engineer of record* any duty or authority to undertake responsibility inconsistent with the provisions of the *contract documents*.

This Code is not applicable to steel joists or metal building systems, which are addressed by SJI and MBMA, respectively.

1.2. Referenced Specifications, Codes and Standards

The following documents are referenced in this Code:

AASHTO Specification—The 2010 AASHTO *LRFD Bridge Design Specifications*, 5th Edition.

AISC Seismic Provisions—AISC 341-10, the 2010 AISC *Seismic Provisions for Structural Steel Buildings*.

AISC Specification—AISC 360-10, the 2010 AISC *Specification for Structural Steel Buildings*.

ASME B46.1—ASME B46.1-02, Surface Texture (Surface Roughness, Waviness and Lay).

AREMA Specification—The 2010 AREMA *Manual for Railway Engineering, Volume II—Structures, Chapter 15*.

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- ASTM A6/A6M—09, *Standard Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling.*
- ASTM A53/A53M—07, *Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless.*
- ASTM A325—09, *Standard Specification for Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength.*
- ASTM A325M—09, *Standard Specification for High-Strength Bolts for Structural Steel Joints (Metric).*
- ASTM A490—08b, *Standard Specification for Heat-Treated Steel Structural Bolts, 150 ksi Minimum Tensile Strength.*
- ASTMA490M—08, *Standard Specification for High-Strength Steel Bolts, Classes 10.9 and 10.9.3, for Structural Steel Joints (Metric).*
- ASTM A500/A500M—07, *Standard Specification for Cold-Formed Welded and Seamless Carbon Steel Structural Tubing in Rounds and Shapes.*
- ASTM A501—07, *Standard Specification for Hot-Formed Welded and Seamless Carbon Steel Structural Tubing.* No metric equivalent exists.
- ASTM A618/A618M—04, *Standard Specification for Hot-Formed Welded and Seamless High-Strength Low-Alloy Structural Tubing.*
- ASTM A847/A847M—05, *Standard Specification for Cold-Formed Welded and Seamless High-Strength, Low-Alloy Structural Tubing with Improved Atmospheric Corrosion Resistance.*
- ASTM F1852/F1852M—08, *Standard Specification for "Twist-Off" Type Tension Control Structural Bolt/Nut/Washer Assemblies, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength.*
- AWS D1.1—The AWS D1.1 *Structural Welding Code—Steel*, 2008.
- CASE Document 11—*An Agreement Between Structural Engineer of Record and Contractor for Transfer of Computer Aided Drafting (CAD) files on Electronic Media*, 2000
- CASE Document 962—*The National Practice Guidelines for the Structural Engineer of Record*, Fourth Edition, 2000.
- RCSC Specification—*The Specification for Structural Joints Using High-Strength Bolts*, 2009.
- SSPC SP2—*SSPC Surface Preparation Specification No. 2, Hand Tool Cleaning*, 2004.
- SSPC SP6—*SSPC Surface Preparation Specification No. 6, Commercial Blast Cleaning*, 2004.

1.3. Units

In this Code, the values stated in either U.S. customary units or metric units shall be used. Each system shall be used independently of the other.

Commentary:

In this Code, dimensions, weights and other measures are given in U.S. customary units with rounded or rationalized metric-unit equivalents in

brackets. Because the values stated in each system are not exact equivalents, the selective combination of values from each of the two systems is not permitted.

1.4. Design Criteria

For buildings and other structures, in the absence of other design criteria, the provisions in the AISC Specification shall govern the design of the *structural steel*. For bridges, in the absence of other design criteria, the provisions in the AASHTO Specification and AREMA Specification shall govern the design of the *structural steel*, as applicable.

1.5. Responsibility for Design

1.5.1. When the *owner's designated representative for design* provides the design, *design drawings* and *specifications*, the *fabricator* and the *erector* are not responsible for the suitability, adequacy or building-code conformance of the design.

1.5.2. When the *owner* enters into a direct contract with the *fabricator* to both design and fabricate an entire, completed steel structure, the *fabricator* shall be responsible for the suitability, adequacy, conformance with *owner-established* performance criteria, and building-code conformance of the *structural steel* design. The *owner* shall be responsible for the suitability, adequacy and building-code conformance of the non-*structural steel* elements and shall establish the performance criteria for the *structural steel* frame.

1.6. Patents and Copyrights

The entity or entities that are responsible for the specification and/or selection of proprietary structural designs shall secure all intellectual property rights necessary for the use of those designs.

1.7. Existing Structures

1.7.1. Demolition and shoring of any part of an existing structure are not within the scope of work that is provided by either the *fabricator* or the *erector*. Such demolition and shoring shall be performed in a timely manner so as not to interfere with or delay the work of the *fabricator* and the *erector*.

1.7.2. Protection of an existing structure and its contents and equipment, so as to prevent damage from normal erection processes, is not within the scope of work that is provided by either the *fabricator* or the *erector*. Such protection shall be performed in a timely manner so as not to interfere with or delay the work of the *fabricator* or the *erector*.

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- 1.7.3. Surveying or field dimensioning of an existing structure is not within the scope of work that is provided by either the *fabricator* or the *erector*. Such surveying or field dimensioning, which is necessary for the completion of *shop and erection drawings* and fabrication, shall be performed and furnished to the *fabricator* in a timely manner so as not to interfere with or delay the work of the *fabricator* or the *erector*.
- 1.7.4. Abatement or removal of *hazardous materials* is not within the scope of work that is provided by either the *fabricator* or the *erector*. Such abatement or removal shall be performed in a timely manner so as not to interfere with or delay the work of the *fabricator* and the *erector*.

1.8. Means, Methods and Safety of Erection

- 1.8.1. The *erector* shall be responsible for the means, methods and safety of erection of the *structural steel* frame.
- 1.8.2. The *structural engineer of record* shall be responsible for the structural adequacy of the design of the structure in the completed project. The *structural engineer of record* shall not be responsible for the means, methods and safety of erection of the *structural steel* frame. See also Sections 3.1.4 and 7.10.

1.9. Tolerances

Tolerances for materials, fabrication and erection shall be as stipulated in Sections 5, 6, 7, and 10.

Commentary:

Tolerances are not necessarily specified in this Code for every possible variation that could be encountered. For most projects, where a tolerance is not specified or covered in this Code, it is not needed to ensure that the fabricated and erected *structural steel* complies with the requirements in Section 6 and 7. If a special design concept or system component requires a tolerance that is not specified in this Code, the necessary tolerance should be specified in the *contract documents*. If a tolerance is not shown and is deemed by the *fabricator* and/or *erector* to be important to the successful fabrication and erection of the *structural steel*, it should be requested from the *owner's designated representative for design*. The absence of a tolerance in this Code for a particular condition does not mean that the tolerance is zero; rather, it means that no tolerance has been established. In any case, the default tolerance is not zero.

SECTION 2. CLASSIFICATION OF MATERIALS

2.1. Definition of Structural Steel

Structural steel shall consist of the elements of the structural frame that are shown and sized in the structural *design drawings*, essential to support the design loads and described as:

- Anchor rods* that will receive *structural steel*.
- Base plates, if part of the *structural steel* frame.
- Beams, including built-up beams, if made from *standard structural shapes* and/or plates.
- Bearing plates, if part of the *structural steel* frame.
- Bearings of steel for girders, trusses or bridges.
- Bracing, if permanent.
- Canopy framing, if made from *standard structural shapes* and/or plates.
- Columns, including built-up columns, if made from *standard structural shapes* and/or plates.
- Connection materials for framing *structural steel* to *structural steel*.
- Crane stops, if made from *standard structural shapes* and/or plates.
- Door frames, if made from *standard structural shapes* and/or plates and if part of the *structural steel* frame.
- Edge angles and plates, if attached to the *structural steel* frame or steel (open-web) joists.
- Embedded *structural steel* parts, other than bearing plates, that will receive *structural steel*.
- Expansion joints, if attached to the *structural steel* frame.
- Fasteners for connecting *structural steel* items: permanent shop bolts, nuts and washers; shop bolts, nuts and washers for shipment; field bolts, nuts and washers for permanent *connections*; and, permanent pins.
- Floor-opening frames, if made from *standard structural shapes* and/or plates and attached to the *structural steel* frame or steel (open-web) joists.
- Floor plates (checkered or plain), if attached to the *structural steel* frame.
- Girders, including built-up girders, if made from *standard structural shapes* and/or plates.
- Girts, if made from *standard structural shapes*.
- Grillage beams and girders.
- Hangers, if made from *standard structural shapes*, plates and/or rods and framing *structural steel* to *structural steel*.
- Leveling nuts and washers.
- Leveling plates.
- Leveling screws.
- Lintels, if attached to the *structural steel* frame.
- Marquee framing, if made from *standard structural shapes* and/or plates.

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Machinery supports, if made from *standard structural shapes* and/or plates and attached to the *structural steel* frame.

Monorail elements, if made from *standard structural shapes* and/or plates and attached to the *structural steel* frame.

Posts, if part of the *structural steel* frame.

Purlins, if made from *standard structural shapes*.

Relieving angles, if attached to the *structural steel* frame.

Roof-opening frames, if made from *standard structural shapes* and/or plates and attached to the *structural steel* frame or steel (open-web) joists.

Roof-screen support frames, if made from *standard structural shapes*.

Sag rods, if part of the *structural steel* frame and connecting *structural steel* to *structural steel*.

Shear stud connectors, if specified to be shop attached.

Shims, if permanent.

Struts, if permanent and part of the *structural steel* frame.

Tie rods, if part of the *structural steel* frame.

Trusses, if made from *standard structural shapes* and/or built-up members.

Wall-opening frames, if made from *standard structural shapes* and/or plates and attached to the *structural steel* frame.

Wedges, if permanent.

Commentary:

The *fabricator* normally fabricates the items listed in Section 2.1. Such items must be shown, sized and described in the structural *design drawings*. Bracing includes vertical bracing for resistance to wind and seismic load and structural stability, horizontal bracing for floor and roof systems and permanent stability bracing for components of the *structural steel* frame.

2.2. Other Steel, Iron or Metal Items

Structural steel shall not include other steel, iron or metal items that are not generally described in Section 2.1, even where such items are shown in the structural *design drawings* or are attached to the *structural steel* frame. Other steel, iron or metal items include but are not limited to:

Base plates, if not part of the *structural steel* frame.

Bearing plates, if not part of the *structural steel* frame.

Bearings, if non-steel.

Cables for permanent bracing or suspension systems.

Castings.

Catwalks.

Chutes.

Cold-formed steel products.

Cold-rolled steel products, except those that are specifically covered in the AISC Specification.
 Corner guards.
 Crane rails, splices, bolts and clamps.
 Crane stops, if not made from *standard structural shapes* or plates.
 Door guards.
 Embedded steel parts, other than bearing plates, that do not receive *structural steel* or that are embedded in precast concrete.
 Expansion joints, if not attached to the *structural steel* frame.
 Flagpole support steel.
 Floor plates (checkered or plain), if not attached to the *structural steel* frame.
 Forgings.
 Gage-metal products.
 Grating.
 Handrail.
 Hangers, if not made from *standard structural shapes*, plates and/or rods or not framing *structural steel* to *structural steel*.
 Hoppers.
 Items that are required for the assembly or erection of materials that are furnished by trades other than the *fabricator* or *erector*.
 Ladders.
 Lintels, if not attached to the *structural steel* frame.
 Masonry anchors.
 Miscellaneous metal.
 Ornamental metal framing.
 Pressure vessels.
 Reinforcing steel for concrete or masonry.
 Relieving angles, if not attached to the *structural steel* frame.
 Roof screen support frames, if not made from *standard structural shapes*.
 Safety cages.
 Shear stud connectors, if specified to be field installed.
 Stacks.
 Stairs.
 Steel deck.
 Steel (open-web) joists.
 Steel joist girders.
 Tanks.
 Toe plates.
 Trench or pit covers.

Commentary:

Section 2.2 includes many items that may be furnished by the *fabricator* if contracted to do so by specific notation and detail in the *contract documents*.

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When such items are contracted to be provided by the *fabricator*, coordination will normally be required between the *fabricator* and other material suppliers and trades. The provisions in this Code are not intended to apply to items in Section 2.2.

In previous editions of this Code, provisions regarding who should normally furnish field-installed shear stud connectors and cold-formed steel deck support angles were included in Section 7.8. These provisions have been eliminated since field-installed shear stud connectors and steel deck support angles are not defined as *structural steel* in this Code.

SECTION 3. DESIGN DRAWINGS AND SPECIFICATIONS

3.1. Structural Design Drawings and Specifications

Unless otherwise indicated in the *contract documents*, the structural *design drawings* shall be based upon consideration of the design loads and forces to be resisted by the *structural steel* frame in the completed project.

The structural *design drawings* shall clearly show the work that is to be performed and shall give the following information with sufficient dimensions to accurately convey the quantity and nature of the *structural steel* to be fabricated:

- (a) The size, section, material grade and location of all members;
- (b) All geometry and working points necessary for layout;
- (c) Floor elevations;
- (d) Column centers and offsets;
- (e) The camber requirements for members;
- (f) Joining requirements between elements of built-up members; and,
- (g) The information that is required in Sections 3.1.1 through 3.1.6.

The *structural steel specifications* shall include any special requirements for the fabrication and erection of the *structural steel*.

The structural *design drawings*, *specifications* and addenda shall be numbered and dated for the purposes of identification.

Commentary:

Contract documents vary greatly in complexity and completeness. Nonetheless, the *fabricator* and the *erector* must be able to rely upon the accuracy and completeness of the *contract documents*. This allows the *fabricator* and the *erector* to provide the *owner* with bids that are adequate and complete. It also enables the preparation of the *shop* and *erection drawings*, the ordering of materials and the timely fabrication and erection of shipping pieces.

In some cases, the *owner* can benefit when reasonable latitude is allowed in the *contract documents* for alternatives that can reduce cost without compromising quality. However, critical requirements that are necessary to protect the *owner's* interest, that affect the integrity of the structure or that are necessary for the *fabricator* and the *erector* to proceed with their work must be included in the *contract documents*. Some examples of critical information may include, when applicable:

Standard specifications and codes that govern *structural steel* design and construction, including bolting and welding.

Material specifications.

Special material requirements to be reported on the material test reports.

Welded-joint configuration.

Weld-procedure qualification.
 Special requirements for work of other trades.
 Final disposition of backing bars and runoff tabs.
 Lateral bracing.
 Stability bracing.
Connections or data for *connection* selection and/or completion.
 Restrictions on *connection* types.
 Column stiffeners (also known as continuity plates).
 Column web doubler plates.
 Bearing stiffeners on beams and girders.
 Web reinforcement.
 Openings for other trades.
 Surface preparation and shop painting requirements.
 Shop and field inspection requirements.
 Non-destructive testing requirements, including acceptance criteria.
 Special requirements on delivery.
 Special erection limitations.
 Identification of non-*structural steel* elements that interact with the *structural steel* frame to provide for the lateral stability of the *structural steel* frame (see Section 3.1.4).
 Column differential shortening information (see Commentary to Section 7.13).
 Anticipated deflections and the associated loading conditions for major structural elements, such as transfer girders and trusses, supporting columns and hangers (see Commentary to Section 7.13).
 Special fabrication and erection tolerances for AESS.
 Special pay-weight provisions.

- 3.1.1. Permanent bracing, column stiffeners, column web doubler plates, bearing stiffeners in beams and girders, web reinforcement, openings for other trades and other special details, where required, shall be shown in sufficient detail in the structural *design drawings* so that the quantity, detailing and fabrication requirements for these items can be readily understood.
- 3.1.2. The *owner's designated representative for design* shall indicate one of the following options for each *connection*:
- (1) The complete *connection* design shall be shown in the structural *design drawings*;
 - (2) In the structural *design drawings* or *specifications*, the *connection* shall be designated to be selected or completed by an experienced *steel detailer*; or,
 - (3) In the structural *design drawings* or *specifications*, the *connection* shall be designated to be designed by a licensed professional engineer working for the *fabricator*.

In all of the above options,

- (a) The requirements of Section 3.1.1 shall apply; and,
- (b) The approvals process in Section 4.4 shall be followed.

When option (2) above is specified, the experienced *steel detailer* shall utilize tables or schematic information provided in the structural *design drawings* in the selection or completion of the *connections*. When such information is not provided, tables in the AISC *Steel Construction Manual*, or other reference information as approved by the *owner's designated representative for design*, shall be used.

When option (2) or (3) above is specified, the *owner's designated representative for design* shall provide the following information in the structural *design drawings* and *specifications*:

- (a) Any restrictions on the types of *connections* that are permitted;
- (b) Data concerning the loads, including shears, moments, axial forces and transfer forces, that are to be resisted by the individual members and their *connections*, sufficient to allow the selection, completion, or design of the *connection* details while preparing the *shop* and *erection drawings*;
- (c) Whether the data required in (b) is given at the service-load level or the factored-load level;
- (d) Whether LRFD or ASD is to be used in the selection, completion, or design of *connection* details; and,
- (e) What *substantiating connection information*, if any, is to be provided with the *shop* and *erection drawings* to the *owner's designated representative for design*.

When option (3) above is specified:

- (a) The *fabricator* shall submit in a timely manner representative samples of the required *substantiating connection information* to the *owner's designated representatives for design* and *construction*. The *owner's designated representative for design* shall confirm in writing in a timely manner that these representative samples are consistent with the requirements in the *contract documents*, or shall advise what modifications are required to bring the representative samples into compliance with the requirements in the *contract documents*. This initial submittal and review is in addition to the requirements in Section 4.4.
- (b) The licensed professional engineer in responsible charge of the *connection* design shall review and confirm in writing as part of the *substantiating connection information*, that the *shop* and *erection drawings* properly incorporate the *connection* designs. However, this review by the licensed

professional engineer in responsible charge of the *connection* design does not replace the approval process of the *shop* and *erection drawings* by the *owner's designated representative for design* in Section 4.4.

- (c) The *fabricator* shall provide a means by which the *substantiating connection information* is referenced to the related *connections* on the *shop* and *erection drawings* for the purpose of review.

Commentary:

There are three options covered in Section 3.1.2:

- (1) When the *owner's designated representative for design* shows the complete design of the *connections* in the structural *design drawings*, the following information is included:
- (a) All weld types, sizes, and lengths;
 - (b) All bolt sizes, locations, quantities, and grades;
 - (c) All plate and angle sizes, thicknesses and dimensions; and,
 - (d) All work point locations and related information.

The intent of this approach is that complete design information necessary for detailing the *connection* is shown in the structural *design drawings*. Typical details are shown for each *connection* type, set of geometric parameters and adjacent framing conditions. The *steel detailer* will then be able to transfer this information to the *shop* and *erection drawings*, applying it to the individual pieces being detailed.

- (2) When the *owner's designated representative for design* allows an experienced *steel detailer* to select or complete the *connections*, this is commonly done by referring to tables or schematic information in the structural *design drawings*, tables in the AISC *Steel Construction Manual*, or other reference information approved by the *owner's designated representative for design*, such as journal papers and recognized software output. Tables and schematic information in the structural *design drawings* should provide such information as weld types and sizes, plate thicknesses and quantities of bolts. However, there may be some geometry and dimensional information that the *steel detailer* must develop. The *steel detailer* will then configure the *connections* based upon the design loads and other information given in the structural *design drawings* and *specifications*.

The intent of this method is that the *steel detailer* will select the *connection* materials and configuration from the referenced tables or complete the specific *connection* configuration (e.g., dimensions, edge distances and bolt spacing) based upon the *connection* details that are shown in the structural *design drawings*.

The *steel detailer* must be experienced and familiar with the AISC requirements for *connection* configurations, the use of the *connection* tables in the AISC *Steel Construction Manual*, the calculation of dimensions and adaptation of typical *connection* details to similar situations. Notations of loadings in the structural *design drawings* are only to facilitate selection of the *connections* from the referenced tables. It is not the intent that this method be used when the practice of engineering is required.

- (3) Option 3 reflects a practice in some areas of the U.S. to have a licensed professional engineer working for or retained by the *fabricator* design the *connections*, and recognizes the information required by the *fabricator* to do this work. The *owner's designated representative for design*, who has the knowledge of the structure as a whole, must review and approve the *shop* and *erection drawings*, and take such action on *substantiating connection information* as the *owner's designated representative for design* deems appropriate. See Section 4.4 for the approval process.

When, under Section 3.1.2, the *owner's designated representative for design* designates that *connections* be designed by a licensed professional engineer employed or retained by the *fabricator*, this work is incidental to, and part of, the overall means and methods of fabricating and constructing the steel frame. The licensed professional engineer performing the *connection* design is not providing a peer-review of the *contract documents*.

The *owner's designated representative for design* reviews the *shop* and *erection drawings* during the approvals process as specified in Section 4.4 for conformance with the specified criteria and compatibility with the design of the primary structure.

One of these options should be indicated for each *connection* in a project. It is acceptable to group *connection* types and utilize a combination of these options for the various *connection* types involved in a project. Option (3) is not normally specified for *connections* that can be selected or completed as noted in Option (2) without practicing engineering.

If there are any restrictions as to the types of *connections* to be used, it is required that these limitations be set forth in the structural *design drawings* and *specifications*. There are a variety of *connections* available in the AISC *Steel Construction Manual* for a given situation. Preference for a particular type will vary between *fabricators* and *erectors*. Stating these limitations, if any, in the structural *design drawings* and *specifications* will help to avoid repeated changes to the *shop* and *erection drawings* due to the selection of a *connection* that is not acceptable to the *owner's designated representative for design*, thereby avoiding additional cost and/or delay for the redrawing of the *shop* and *erection drawings*.

The structural *design drawings* must indicate the method of design used as LRFD or ASD. In order to conform to the spirit of the AISC

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Specification, the *connections* must be selected using the same method and the corresponding references.

Substantiating connection information, when required, can take many forms. When option (2) is designated, *shop* and *erection drawings* may suffice with no additional *substantiating connection information* required. When option (3) is designated, the *substantiating connection information* may take the form of hand calculations and/or software output.

When *substantiating connection information* is required, it is recommended that representative samples of that information be agreed upon prior to preparation of *shop* and *erection drawings*, in order to avoid additional cost and/or delay for the *connection* redesign and/or redrawing that might otherwise result.

The *owner's designated representative for design* may require that the *substantiating connection information* be signed and sealed for option (3). The signing and sealing of the cover letter transmitting the *shop* and *erection drawings* and *substantiating connection information* may suffice. This signing and sealing indicates that a professional engineer performed the work but does not replace the approval process provided in Section 4.4.

A requirement to sign and seal each sheet of the *shop* and *erection drawings* is discouraged as it may serve to confuse the design responsibility between the *owner's designated representative for design* and the licensed professional engineer's work in performing the *connection* design.

- 3.1.3. When leveling plates are to be furnished as part of the contract requirements, their locations and required thickness and sizes shall be specified in the *contract documents*.
- 3.1.4. When the *structural steel* frame, in the completely erected and fully connected state, requires interaction with non-*structural steel* elements (see Section 2) for strength and/or stability, those non-*structural steel* elements shall be identified in the *contract documents* as required in Section 7.10.

Commentary:

Examples of non-*structural steel* elements include diaphragms made of steel deck, diaphragms made of concrete on steel deck and masonry and/or concrete shear walls.

- 3.1.5. When camber is required, the magnitude, direction and location of camber shall be specified in the structural *design drawings*.

Commentary:

For cantilevers, the specified camber may be up or down, depending upon the framing and loading.

- 3.1.6. Specific members or portions thereof that are to be left unpainted shall be identified in the *contract documents*. When shop painting is required, the painting requirements shall be specified in the *contract documents*, including the following information:
- (a) The identification of specific members or portions thereof to be painted;
 - (b) The surface preparation that is required for these members;
 - (c) The paint specifications and manufacturer's product identification that are required for these members; and,
 - (d) The minimum dry-film shop-coat thickness that is required for these members.

Commentary:

Some members or portions thereof may be required to be left unpainted, such as those that will be in contact and acting compositely with concrete, or those that will receive spray-applied fire protection materials.

3.2. Architectural, Electrical and Mechanical Design Drawings and Specifications

All requirements for the quantities, sizes and locations of *structural steel* shall be shown or noted in the structural *design drawings*. The use of architectural, electrical and/or mechanical *design drawings* as a supplement to the structural *design drawings* is permitted for the purposes of defining detail configurations and construction information.

3.3. Discrepancies

When discrepancies exist between the *design drawings* and *specifications*, the *design drawings* shall govern. When discrepancies exist between scale dimensions in the *design drawings* and the figures written in them, the figures shall govern. When discrepancies exist between the structural *design drawings* and the architectural, electrical or mechanical *design drawings* or *design drawings* for other trades, the structural *design drawings* shall govern.

When a discrepancy is discovered in the *contract documents* in the course of the *fabricator's* work, the *fabricator* shall promptly notify the *owner's designated representative for construction* so that the discrepancy can be resolved by the *owner's designated representative for design*. Such resolution shall be timely so as not to delay the *fabricator's* work. See Sections 3.5 and 9.3.

Commentary:

While it is the *fabricator's* responsibility to report any discrepancies that are discovered in the *contract documents*, it is not the *fabricator's* responsibility to discover discrepancies, including those that are associated with the coordination

of the various design disciplines. The quality of the *contract documents* is the responsibility of the entities that produce those documents.

3.4. Legibility of Design Drawings

Design drawings shall be clearly legible and drawn to an identified scale that is appropriate to clearly convey the information.

Commentary:

Historically, the most commonly accepted scale for *structural steel* plans has been 1/8 in. per ft [10 mm per 1 000 mm]. There are, however, situations where a smaller or larger scale is appropriate. Ultimately, consideration must be given to the clarity of the drawing.

The scaling of the *design drawings* to determine dimensions is not an accepted practice for detailing the *shop* and *erection drawings*. However, it should be remembered when preparing *design drawings* that scaling may be the only method available when early-submission drawings are used to determine dimensions for estimating and bidding purposes.

3.5. Revisions to the Design Drawings and Specifications

Revisions to the *design drawings* and *specifications* shall be made either by issuing new *design drawings* and *specifications* or by reissuing the existing *design drawings* and *specifications*. In either case, all *revisions*, including *revisions* that are communicated through responses to RFIs or the annotation of *shop* and/or *erection drawings* (see Section 4.4.2), shall be clearly and individually indicated in the *contract documents*. The *contract documents* shall be dated and identified by *revision* number. Each *design drawings* shall be identified by the same drawing number throughout the duration of the project, regardless of the *revision*. See also Section 9.3.

Commentary:

Revisions to the *design drawings* and *specifications* can be made by issuing sketches and supplemental information separate from the *design drawings* and *specifications*. These sketches and supplemental information become amendments to the *design drawings* and *specifications* and are considered new *contract documents*. All sketches and supplemental information must be uniquely identified with a number and date as the latest instructions until such time as they may be superseded by new information.

When *revisions* are made by revising and re-issuing the existing structural *design drawings* and/or *specifications*, a unique *revision* number and date must be added to those documents to identify that information as the latest instructions until such time as they may be superseded by new information. The same unique drawing number must identify each *design drawings* throughout the duration of the project so that *revisions* can be properly tracked, thus

avoiding confusion and miscommunication among the various entities involved in the project.

When *revisions* are communicated through the annotation of *shop* or *erection drawings* or contractor submissions, such changes must be confirmed in writing by one of the aforementioned methods. This written confirmation is imperative to maintain control of the cost and schedule of a project and to avoid potential errors in fabrication.

3.6. Fast-Track Project Delivery

When the fast-track project delivery system is selected, release of the structural *design drawings* and *specifications* shall constitute a *release for construction*, regardless of the status of the architectural, electrical, mechanical and other interfacing designs and *contract documents*. Subsequent *revisions*, if any, shall be the responsibility of the *owner* and shall be made in accordance with Sections 3.5 and 9.3.

Commentary:

The fast-track project delivery system generally provides for a condensed schedule for the design and construction of a project. Under this delivery system, the *owner* elects to *release for construction* the structural *design drawings* and *specifications*, which may be partially complete, at a time that may precede the completion of and coordination with architectural, mechanical, electrical and other design work and *contract documents*. The release of these structural *design drawings* and *specifications* may also precede the release of the General Conditions and Division 1 Specifications.

Release of the structural *design drawings* and *specifications* to the *fabricator* for ordering of material constitutes a *release for construction*. Accordingly, the *fabricator* and the *erector* may begin their work based upon those partially complete documents. As the architectural, mechanical, electrical and other design elements of the project are completed, *revisions* may be required in design and/or construction. Thus, when considering the fast-track project delivery system, the *owner* should balance the potential benefits to the project schedule with the project cost contingency that may be required to allow for these subsequent *revisions*.

SECTION 4. SHOP AND ERECTION DRAWINGS

4.1. Owner Responsibility

The *owner* shall furnish, in a timely manner and in accordance with the *contract documents*, complete structural *design drawings* and *specifications* that have been *released for construction*. Unless otherwise noted, *design drawings* that are provided as part of a contract bid package shall constitute authorization by the *owner* that the *design drawings* are *released for construction*.

Commentary:

When the *owner* issues *design drawings* and *specifications* that are *released for construction*, the *fabricator* and the *erector* rely on the fact that these are the *owner's* requirements for the project. This release is required by the *fabricator* prior to the ordering of material and the preparation and completion of *shop* and *erection drawings*.

To ensure the orderly flow of material procurement, detailing, fabrication and erection activities, on phased construction projects, it is essential that designs are not continuously revised after they have been *released for construction*. In essence, once a portion of a design is *released for construction*, the essential elements of that design should be “frozen” to ensure adherence to the contract price and construction schedule. Alternatively, all parties should reach a common understanding of the effects of future changes, if any, as they affect scheduled deliveries and added costs.

A pre-detailing conference, held after the *structural steel* fabrication contract is awarded, can benefit the project. Typical attendees may include the *owner's designated representative for construction*, the *owner's designated representative for design*, the *fabricator*, the *steel detailer*, and the *erector*. Topics of the meeting should relate to the specifics of the project, and might include:

- Contract document review and general project overview, including clarifications of scope of work, tolerances, layouts and sequences, and special considerations.
- Detailing and coordination needs, such as bolting, welding, and *connection* considerations, constructability considerations, OSHA requirements, coordination with other trades, and the advanced bill of materials.
- The project communication system, including distribution of contact information for relevant parties to the contract, identification of the primary and alternate contacts in the general contractor's office, and the RFI system to be used on the project.
- The submittal schedule, including how many copies of documents are required, *connection* submittals, and identification of schedule-critical areas of the project, if any.

- Review of quality and inspection requirements, including the approvals process for corrective work.

Record of the meeting should be written and distributed to all parties. Subsequent meetings to discuss progress and issues that arise during construction also can be helpful, particularly when they are held on a regular schedule.

4.2. Fabricator Responsibility

Except as provided in Section 4.5, the *fabricator* shall produce *shop* and *erection drawings* for the fabrication and erection of the *structural steel* and is responsible for the following:

- (a) The transfer of information from the *contract documents* into accurate and complete *shop* and *erection drawings*; and,
- (b) The development of accurate, detailed dimensional information to provide for the fit-up of parts in the field.

Each *shop* and *erection drawing* shall be identified by the same drawing number throughout the duration of the project and shall be identified by *revision* number and date, with each specific *revision* clearly identified.

When the *fabricator* submits a request to change *connection* details that are described in the *contract documents*, the *fabricator* shall notify the *owner's designated representatives for design and construction* in writing in advance of the submission of the *shop* and *erection drawings*. The *owner's designated representative for design* shall review and approve or reject the request in a timely manner.

When requested to do so by the *owner's designated representative for design*, the *fabricator* shall provide to the *owner's designated representatives for design and construction* its schedule for the submittal of *shop* and *erection drawings* so as to facilitate the timely flow of information between all parties.

Commentary:

The *fabricator* is permitted to use the services of independent *steel detailers* to produce *shop* and *erection drawings*, and to perform other support services such as producing advanced bills of material and bolt summaries.

As the *fabricator* develops the detailed dimensional information for production of the *shop* and *erection drawings*, there may be discrepancies, missing information or conflicts discovered in the *contract documents*. See Section 3.3.

When the *fabricator* intends to make a submission of alternative *connection* details to those shown in the *contract documents*, the *fabricator* must notify the *owner's designated representatives for design and construction* in advance. This will allow the parties involved to plan for the increased effort

that may be required to review the alternative *connection* details. In addition, the *owner* will be able to evaluate the potential for cost savings and/or schedule improvements against the additional design cost for review of the alternative *connection* details by the *owner's designated representative for design*. This evaluation by the *owner* may result in the rejection of the alternative *connection* details or acceptance of the submission for review based upon cost savings, schedule improvements and/or job efficiencies.

The *owner's designated representative for design* may request the *fabricator's* schedule for the submittal of *shop* and *erection drawings*. This process is intended to allow the parties to plan for the staffing demands of the submission schedule. The *contract documents* may address this issue in more detail. In the absence of the requirement to provide this schedule, none need be provided.

When the *fabricator* provides a schedule for the submission of the *shop* and *erection drawings*, it must be recognized that this schedule may be affected by *revisions* and the response time to requests for missing information or the resolution of discrepancies.

4.3. Use of CAD Files and/or Copies of Design Drawings

The *fabricator* shall neither use nor reproduce any part of the *design drawings* as part of the *shop* or *erection drawings* without the written permission of the *owner's designated representative for design*. When CAD files or copies of the *design drawings* are made available for the *fabricator's* use, the *fabricator* shall accept this information under the following conditions:

- (a) All information contained in the CAD files or copies of the *design drawings* shall be considered instruments of service of the *owner's designated representative for design* and shall not be used for other projects, additions to the project or the completion of the project by others. CAD files and copies of the *design drawings* shall remain the property of the *owner's designated representative for design* and in no case shall the transfer of these CAD files or copies of the *design drawings* be considered a sale.
- (b) The CAD files or copies of the *design drawings* shall not be considered to be *contract documents*. In the event of a conflict between the *design drawings* and the CAD files or copies thereof, the *design drawings* shall govern;
- (c) The use of CAD files or copies of the *design drawings* shall not in any way obviate the *fabricator's* responsibility for proper checking and coordination of dimensions, details, member sizes and fit-up and quantities of materials as required to facilitate the preparation of *shop* and *erection drawings* that are complete and accurate as required in Section 4.2; and,
- (d) The *fabricator* shall remove information that is not required for the fabrication or erection of the *structural steel* from the CAD files or copies of the *design drawings*.

Commentary:

With the advent of electronic media and the internet, electronic copies of *design drawings* are readily available to the *fabricator*. As a result, the *owner's designated representative for design* may have reduced control over the unauthorized use of the *design drawings*. There are many copyright and other legal issues to be considered.

The *owner's designated representative for design* may choose to make CAD files or copies of the *design drawings* available to the *fabricator*, and may charge a service or licensing fee for this convenience. In doing so, a carefully negotiated agreement should be established to set out the specific responsibilities of both parties in view of the liabilities involved for both parties. For a sample contract, see CASE Document 11.

The CAD files and/or copies of the *design drawings* are provided to the *fabricator* for convenience only. The information therein should be adapted for use only in reference to the placement of *structural steel* members during erection. The *fabricator* should treat this information as if it were fully produced by the *fabricator* and undertake the same level of checking and quality assurance. When amendments or *revisions* are made to the *contract documents*, the *fabricator* must update this reference material.

When CAD files or copies of the *design drawings* are provided to the *fabricator*, they often contain other information, such as architectural backgrounds or references to other *contract documents*. This additional material should be removed when producing *shop* and *erection drawings* to avoid the potential for confusion.

4.4. Approval

Except as provided in Section 4.5, the *shop* and *erection drawings* shall be submitted to the *owner's designated representatives for design* and *construction* for review and approval. The *shop* and *erection drawings* shall be returned to the *fabricator* within 14 calendar days.

Final *substantiating connection information*, if any, shall also be submitted with the *shop* and *erection drawings*. The *owner's designated representative for design* is the final authority in the event of a disagreement between parties regarding *connection* design.

Approved *shop* and *erection drawings* shall be individually annotated by the *owner's designated representatives for design* and *construction* as either approved or approved subject to corrections noted. When so required, the *fabricator* shall subsequently make the corrections noted and furnish corrected *shop* and *erection drawings* to the *owner's designated representatives for design* and *construction*.

Commentary:

As used in this Code, the 14-day allotment for the return of *shop* and *erection drawings* is intended to represent the *fabricator's* portal-to-portal time. The intent in this Code is that, in the absence of information to the contrary in the *contract documents*, 14 days may be assumed for the purposes of bidding, contracting and scheduling. When additional time is desired, such as when *substantiating connection information* is part of the submittals, the modified allotment should be specified in the *contract documents*. A submittal schedule is commonly used to facilitate the approval process.

If a *shop* or *erection drawing* is approved subject to corrections noted, the *owner's designated representative for design* may or may not require that it be re-submitted for record purposes following correction. If a *shop* or *erection drawing* is not approved, revisions must be made and the drawing re-submitted until approval is achieved.

- 4.4.1. Approval of the *shop* and *erection drawings*, approval subject to corrections noted and similar approvals shall constitute the following:
- (a) Confirmation that the *fabricator* has correctly interpreted the *contract documents* in the preparation of those submittals;
 - (b) Confirmation that the *owner's designated representative for design* has reviewed and approved the *connection* details shown on the *shop* and *erection drawings* and submitted in accordance with Section 3.1.2, if applicable; and,
 - (c) Release by the *owner's designated representatives for design and construction* for the *fabricator* to begin fabrication using the approved submittals.

Such approval shall not relieve the *fabricator* of the responsibility for either the accuracy of the detailed dimensions in the *shop* and *erection drawings* or the general fit-up of parts that are to be assembled in the field.

The *fabricator* shall determine the fabrication schedule that is necessary to meet the requirements of the contract.

Commentary:

When considering the current language in this Section, the Committee sought language that would parallel the practices of CASE. In CASE Document 962, CASE indicates that when the design of some element of the primary structural system is left to someone other than the *structural engineer of record*, "...such elements, including *connections* designed by others, should be reviewed by the *structural engineer of record*. He [or she] should review such designs and details, accept or reject them and be responsible for their effects on the primary structural system." Historically, this Code has embraced this same concept.

From the inception of this Code, AISC and the industry in general have recognized that only the *owner's designated representative for design* has all the

information necessary to evaluate the total impact of *connection* details on the overall structural design of the project. This authority traditionally has been exercised during the approval process for *shop* and *erection drawings*. The *owner's designated representative for design* has thus retained responsibility for the adequacy and safety of the entire structure since at least the 1927 edition of this Code.

- 4.4.2. Unless otherwise noted, any additions, deletions or *revisions* that are indicated in responses to RFIs or on the approved *shop* and *erection drawings* shall constitute authorization by the *owner* that the additions, deletions or *revisions* are *released for construction*. The *fabricator* and the *erector* shall promptly notify the *owner's designated representative for construction* when any direction or notation in responses to RFIs or on the *shop* or *erection drawings* or other information will result in an additional cost and/or a delay. See Sections 3.5 and 9.3.

Commentary:

When the *fabricator* notifies the *owner's designated representative for construction* that a direction or notation in responses to RFIs or on the *shop* or *erection drawings* will result in an additional cost or a delay, it is then normally the responsibility of the *owner's designated representative for construction* to subsequently notify the *owner's designated representative for design*.

4.5. Shop and/or Erection Drawings Not Furnished by the Fabricator

When the *shop* and *erection drawings* are not prepared by the *fabricator*, but are furnished by others, they shall be delivered to the *fabricator* in a timely manner. These *shop* and *erection drawings* shall be prepared, insofar as is practical, in accordance with the shop fabrication and detailing standards of the *fabricator*. The *fabricator* shall neither be responsible for the completeness or accuracy of *shop* and *erection drawings* so furnished, nor for the general fit-up of the members that are fabricated from them.

4.6. The RFI Process

When *requests for information* (RFIs) are issued, the process shall include the maintenance of a written record of inquiries and responses related to interpretation and implementation of the *contract documents*, including the *clarifications* and/or *revisions* to the *contract documents* that result, if any. RFIs shall not be used for the incremental *release for construction* of *design drawings*. When RFIs involve discrepancies or *revisions*, see Sections 3.3, 3.5, and 4.4.2.

Commentary:

The RFI process is most commonly used during the detailing process, but can also be used to forward inquiries by the *erector* or to inform the *owner's*

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designated representative for design in the event of a *fabricator* or *erector* error and to develop corrective measures to resolve such errors.

The RFI process is intended to provide a written record of inquiries and associated responses but not to replace all verbal communication between the parties on the project. RFIs should be prepared and responded to in a timely fashion so as not to delay the work of the *steel detailer*, *fabricator*, and *erector*. Discussion of the RFI issues and possible solutions between the *fabricator*, *erector*, and *owner's designated representatives for design and construction* often can facilitate timely and practical resolution. Unlike *shop* and *erection drawing* submittals in Section 4.2, RFI response time can vary depending on the urgency of the issue, the amount of work required by the *owner's designated representatives for design and construction* to develop a complete response, and other circumstances such as building official approval.

RFIs should be prepared in a standardized format, including RFI number and date, identity of the author, reference to a specific *design drawing* number (and specific detail as applicable) or *specification* section, the needed response date, a description of a suggested solution (graphic depictions are recommended for more complex issues), and an indication of possible schedule and cost impacts. RFIs should be limited to one question each (unless multiple questions are interrelated to the same issue) to facilitate the resolution and minimize response time. Questions and proposed solutions presented in RFIs should be clear and complete. RFI responses should be equally clear and complete in the depictions of the solutions, and signed and dated by the responding party.

Unless otherwise noted, the *fabricator* and *erector* can assume that a response to an RFI constitutes a *release for construction*. However, if the response will result in an increase in cost or a delay in schedule, Section 4.4.2 requires that the *fabricator* and/or *erector* promptly inform the *owner's designated representatives for design and construction*.

4.7 Erection Drawings

Erection drawings shall be provided to the *erector* in a timely manner so as to allow the *erector* to properly plan and perform the work.

Commentary:

For planning purposes, this may include release of preliminary *erection drawings*, if requested by the *erector*.

SECTION 5. MATERIALS

5.1. Mill Materials

Unless otherwise noted in the *contract documents*, the *fabricator* is permitted to order the materials that are necessary for fabrication when the *fabricator* receives *contract documents* that have been *released for construction*.

Commentary:

The *fabricator* may purchase materials in stock lengths, exact lengths or multiples of exact lengths to suit the dimensions shown in the structural *design drawings*. Such purchases will normally be job-specific in nature and may not be suitable for use on other projects or returned for full credit if subsequent design changes make these materials unsuitable for their originally intended use. The *fabricator* should be paid for these materials upon delivery from the mill, subject to appropriate additional payment or credit if subsequent unanticipated modification or reorder is required. Purchasing materials to exact lengths is not considered fabrication.

- 5.1.1. Unless otherwise specified by means of special testing requirements in the *contract documents*, mill testing shall be limited to those tests that are required for the material in the ASTM specifications indicated in the *contract documents*. Materials ordered to special material requirements shall be marked by the supplier as specified in ASTM A6/A6M Section 12 prior to delivery to the *fabricator's* shop or other point of use. Such material not so marked by the supplier, shall not be used until:
- (a) Its identification is established by means of testing in accordance with the applicable ASTM specifications; and,
 - (b) A *fabricator's* identification mark, as described in Section 6.1.2 and 6.1.3, has been applied.
- 5.1.2. When *mill material* does not satisfy ASTM A6/A6M tolerances for camber, profile, flatness or sweep, the *fabricator* shall be permitted to perform corrective procedures, including the use of controlled heating and/or mechanical straightening, subject to the limitations in the AISC Specification.

Commentary:

Mill dimensional tolerances are completely set forth in ASTM A6/A6M. Normal variations in the cross-sectional geometry of *standard structural shapes* must be recognized by the designer, the *fabricator*, the *steel detailer*, and the *erector* (for example, see Figure C-5.1). Such tolerances are mandatory because roll wear, thermal distortions of the hot cross-section immediately after leaving the forming rolls and differential cooling distortions that take place on the cooling beds are all unavoidable. Geometric perfection of the cross-section is

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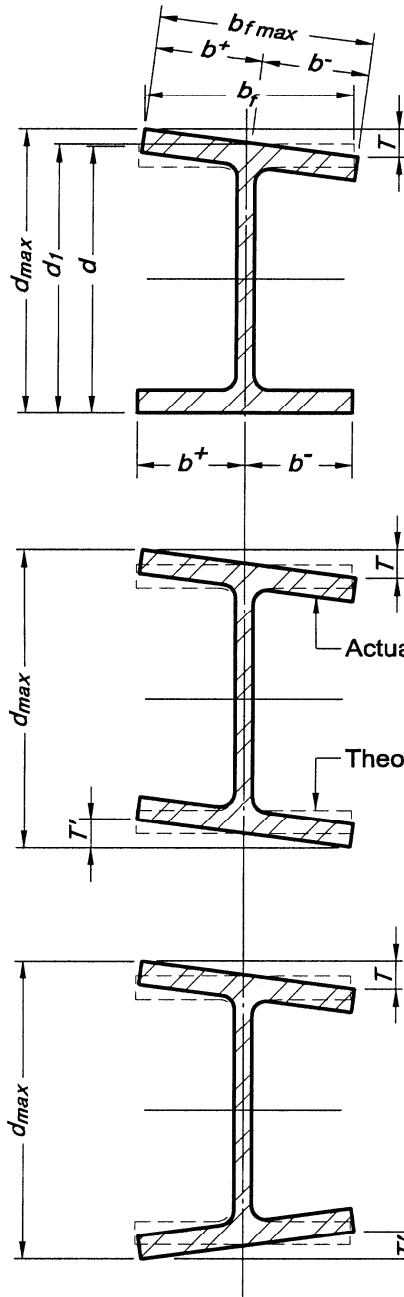
not necessary for either structural or architectural reasons, if the tolerances are recognized and provided for.

ASTM A6/A6M also stipulates tolerances for straightness that are adequate for typical construction. However, these characteristics may be controlled or corrected to closer tolerances during the fabrication process when the added cost is justified by the special requirements for an atypical project.

- 5.1.3. When variations that exceed ASTM A6/A6M tolerances are discovered or occur after the receipt of *mill material* the *fabricator* shall, at the *fabricator's* option, be permitted to perform the ASTM A6/A6M corrective procedures for mill reconditioning of the surface of *structural steel* shapes and plates.
- 5.1.4. When special tolerances that are more restrictive than those in ASTM A6/A6M are required for *mill materials*, such special tolerances shall be specified in the *contract documents*. The *fabricator* shall, at the *fabricator's* option, be permitted to order material to ASTM A6/A6M tolerances and subsequently perform the corrective procedures described in Sections 5.1.2 and 5.1.3.

5.2. Stock Materials

- 5.2.1. If used for structural purposes, materials that are taken from stock by the *fabricator* shall be of a quality that is at least equal to that required in the ASTM specifications indicated in the *contract documents*.
- 5.2.2. Material test reports shall be accepted as sufficient record of the quality of materials taken from stock by the *fabricator*. The *fabricator* shall review and retain the material test reports that cover such stock materials. However, the *fabricator* need not maintain records that identify individual pieces of stock material against individual material test reports, provided the *fabricator* purchases stock materials that meet the requirements for material grade and quality in the applicable ASTM specifications.
- 5.2.3. Stock materials that are purchased under no particular specification, under a specification that is less rigorous than the applicable ASTM specifications or without material test reports or other recognized test reports shall not be used without the approval of the *owner's designated representative for design*.



U.S. customary units:

Flange-tilt tolerances:

$T + T' = 1/4"$ in. for $d \leq 12$ in.
 $= 5/16"$ in. for $d > 12$ in.

Actual depth with tolerances:

$d_1 = d$ plus or minus $1/8$ in. (typ.)
 $d_{max} = d + T + T'$

Actual flange width with tolerances:

$b^+ = 1/2 b_f$ plus or minus $3/16$ in.
 $b^- = 1/2 b_f$ minus or plus $3/16$ in.
 $b_{max} = b_f$ plus $1/4$ in. or minus $3/16$ in.

Metric units:

Flange-tilt tolerances:

$T + T' = 6$ mm for $d \leq 300$ mm
 $= 8$ mm for $d > 300$ mm

Actual depth with tolerances:

$d_1 = d$ plus or minus 3 mm
 $d_{max} = d + T + T'$

Actual flange width with tolerances:

$b^+ = 1/2 b_f$ plus or minus 5 mm
 $b^- = 1/2 b_f$ minus or plus 5 mm
 $b_{max} = b_f$ plus 6 mm or minus 5 mm

Figure C-5.1. Mill tolerances on the cross-section of a W-shape.

SECTION 6. SHOP FABRICATION AND DELIVERY**6.1. Identification of Material**

6.1.1. The *fabricator* shall be able to demonstrate by written procedure and actual practice a method of material identification, visible up to the point of assembling members as follows:

- (a) For shop-standard material, identification capability shall include shape designation. Representative material test reports shall be furnished by the *fabricator* if requested to do so by the *owner's designated representative for design*, either in the *contract documents* or in separate written instructions given to the *fabricator* prior to ordering *mill materials*.
- (b) For material of grade other than shop-standard material, identification capability shall include shape designation and material grade. Representative material test reports shall be furnished by the *fabricator* if requested to do so by the *owner's designated representative for design*, either in the *contract documents* or in separate written instructions given to the *fabricator* prior to ordering *mill materials*.
- (c) For material ordered in accordance with an ASTM supplement or other special material requirements in the *contract documents*, identification capability shall include shape designation, material grade, and heat number. The corresponding material test reports shall be furnished by the *fabricator* if requested to do so by the *owner's designated representative for design*, either in the *contract documents* or in separate written instructions given to the *fabricator* prior to ordering *mill materials*.

Unless an alternative system is established in the *fabricator's* written procedures, shop-standard material shall be as follows:

Material	Shop-standard material grade
W and WT	ASTM A992
M, S, MT and ST	ASTM A36
HP	ASTM A36
L	ASTM A36
C and MC	ASTM A36
HSS	ASTM A500 grade B
Steel Pipe	ASTM A53 grade B
Plates and Bars	ASTM A36

Commentary:

The requirements in Section 6.1.1(a) will suffice for most projects. When material is of a strength level that differs from the shop-standard grade, the requirements in Section 6.1.1(b) apply. When special material requirements

apply, such as ASTM A6/A6M supplement S5 or S30 for CVN testing, ASTM A6/A6M supplement S8 for ultrasonic testing, or ASTM A588/A588M for atmospheric corrosion resistance, the requirements in Section 6.1.1(c) are applicable.

- 6.1.2. During fabrication, up to the point of assembling members, each piece of material that is ordered to special material requirements shall carry a *fabricator's* identification mark or an original supplier's identification mark. The *fabricator's* identification mark shall be in accordance with the *fabricator's* established material identification system, which shall be on record and available prior to the start of fabrication for the information of the *owner's designated representative for construction*, the building-code authority and the *inspector*.
- 6.1.3. Members that are made of material that is ordered to special material requirements shall not be given the same assembling or erection mark as members made of other material, even if they are of identical dimensions and detail.

6.2. Preparation of Material

- 6.2.1. The thermal cutting of *structural steel* by hand-guided or mechanically guided means is permitted.
- 6.2.2. Surfaces that are specified as "finished" in the *contract documents* shall have a roughness height value measured in accordance with ASME B46.1 that is equal to or less than 500 μin . The use of any fabricating technique that produces such a finish is permitted.

Commentary:

Most cutting processes, including friction sawing and cold sawing, and milling processes meet a surface roughness limitation of 500 μin per ASME B46.1.

6.3. Fitting and Fastening

- 6.3.1. Projecting elements of *connection* materials need not be straightened in the connecting plane, subject to the limitations in the AISC Specification.
- 6.3.2. Backing bars and runoff tabs shall be used in accordance with AWS D1.1 as required to produce sound welds. The *fabricator* or *erector* need not remove backing bars or runoff tabs unless such removal is specified in the *contract documents*. When the removal of backing bars is specified in the *contract documents*, such removal shall meet the requirements in AWS D1.1. When the removal of runoff tabs is specified in the *contract documents*, hand flame-

cutting close to the edge of the finished member with no further finishing is permitted, unless other finishing is specified in the *contract documents*.

Commentary:

In most cases, the treatment of backing bars and runoff tabs is left to the discretion of the *owner's designated representative for design*. In some cases, treatment beyond the basic cases described in this Section may be required. As one example, special treatment is required for backing bars and runoff tabs in beam-to-column moment *connections* when the requirements in the AISC Seismic Provisions must be met. In all cases, the *owner's designated representative for design* should specify the required treatments in the *contract documents*.

- 6.3.3. Unless otherwise noted in the *shop drawings*, high-strength bolts for shop-attached *connection* material shall be installed in the shop in accordance with the requirements in the AISC Specification.

6.4. Fabrication Tolerances

The tolerances on *structural steel* fabrication shall be in accordance with the requirements in Section 6.4.1 through 6.4.6.

Commentary:

Fabrication tolerances are stipulated in several specifications and codes, each applicable to a specialized area of construction. Basic fabrication tolerances are stipulated in this Section. For *architecturally exposed structural steel*, see Section 10. Other specifications and codes are also commonly incorporated by reference in the *contract documents*, such as the AISC Specification, the RCSC Specification, AWS D1.1, and the AASHTO Specification.

- 6.4.1. For members that have both ends finished (see Section 6.2.2) for contact bearing, the variation in the overall length shall be equal to or less than $\frac{1}{32}$ in. [1 mm]. For other members that frame to other *structural steel* elements, the variation in the detailed length shall be as follows:
- (a) For members that are equal to or less than 30 ft [9 000 mm] in length, the variation shall be equal to or less than $\frac{1}{16}$ in. [2 mm].
 - (b) For members that are greater than 30 ft [9 000 mm] in length, the variation shall be equal to or less than $\frac{1}{8}$ in. [3 mm].
- 6.4.2. For straight structural members other than compression members, whether of a single *standard structural shape* or built-up, the variation in straightness shall be equal to or less than that specified for wide-flange shapes in ASTM A6/A6M, except when a smaller variation in straightness is specified in the *contract documents*. For straight compression members, whether of a *standard*

structural shape or built-up, the variation in straightness shall be equal to or less than 1/1000 of the axial length between points that are to be laterally supported. For curved structural members, the variation from the theoretical curvature shall be equal to or less than the variation in sweep that is specified for an equivalent straight member of the same straight length in ASTM A6/A6M.

In all cases, completed members shall be free of twists, bends and open joints. Sharp kinks or bends shall be cause for rejection.

- 6.4.3. For beams that are detailed without specified camber, the member shall be fabricated so that, after erection, any incidental camber due to rolling or shop fabrication is upward. For trusses that are detailed without specified camber, the components shall be fabricated so that, after erection, any incidental camber in the truss due to rolling or shop fabrication is upward.
- 6.4.4. For beams that are specified in the *contract documents* with camber, beams received by the *fabricator* with 75% of the specified camber shall require no further cambering. Otherwise, the variation in camber shall be as follows:
- (a) For beams that are equal to or less than 50 ft [15 000 mm] in length, the variation shall be equal to or less than minus zero / plus ½ in. [13 mm].
 - (b) For beams that are greater than 50 ft [15 000 mm] in length, the variation shall be equal to or less than minus zero / plus ½ in. plus ⅛ in. for each 10 ft or fraction thereof [13 mm plus 3 mm for each 3 000 mm or fraction thereof] in excess of 50 ft [15 000 mm] in length.

For the purpose of inspection, camber shall be measured in the *fabricator's* shop in the unstressed condition.

Commentary:

There is no known way to inspect beam camber after the beam is received in the field because of factors that include:

- (a) The release of stresses in members over time and in varying applications;
- (b) The effects of the dead weight of the member;
- (c) The restraint caused by the end *connections* in the erected state; and,
- (d) The effects of additional dead load that may ultimately be intended to be applied, if any.

Therefore, inspection of the *fabricator's* work on beam camber must be done in the fabrication shop in the unstressed condition.

- 6.4.5. For fabricated trusses that are specified in the *contract documents* with camber, the variation in camber at each specified camber point shall be equal to or less than plus or minus 1/800 of the distance to that point from the nearest point of

support. For the purpose of inspection, camber shall be measured in the *fabricator's* shop in the unstressed condition. For fabricated trusses that are specified in the *contract documents* without indication of camber, the foregoing requirements shall be applied at each panel point of the truss with a zero camber ordinate.

Commentary:

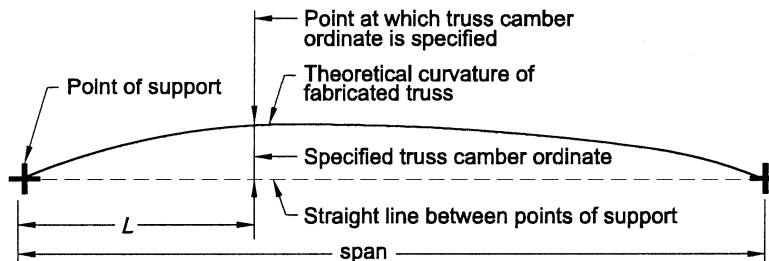
There is no known way to inspect truss camber after the truss is received in the field because of factors that include:

- (a) The effects of the dead weight of the member;
- (b) The restraint caused by the truss *connections* in the erected state; and,
- (c) The effects of additional dead load that may ultimately be intended to be applied, if any.

Therefore, inspection of the *fabricator's* work on truss camber must be done in the fabrication shop in the unstressed condition. See Figure C-6.1.

6.4.6. When permissible variations in the depths of beams and girders result in abrupt changes in depth at splices, such deviations shall be accounted for as follows:

- (a) For splices with bolted joints, the variations in depth shall be taken up with filler plates; and,
- (b) For splices with welded joints, the weld profile shall be adjusted to conform to the variations in depth, the required cross-section of weld shall be provided and the slope of the weld surface shall meet the requirements in AWS D1.1.



Taking L as the distance from the point at which truss camber is specified to the closer point of support, in. [mm], the tolerance on truss camber at that point is calculated as $L/800$. L must be equal to or less than one-half the span.

Figure C-6.1. Illustration of the tolerance on camber for fabricated trusses with specified camber.

6.5. Shop Cleaning and Painting (see also Section 3.1.6)

Structural steel that does not require shop paint shall be cleaned of oil and grease with solvent cleaners, and of dirt and other foreign material by sweeping with a fiber brush or other suitable means. For *structural steel* that is required to be shop painted, the requirements in Sections 6.5.1 through 6.5.4 shall apply.

Commentary:

Extended exposure of unpainted *structural steel* that has been cleaned for the subsequent application of fire protection materials can be detrimental to the fabricated product. Most levels of cleaning require the removal of all loose mill scale, but permit some amount of tightly adhering mill scale. When a piece of *structural steel* that has been cleaned to an acceptable level is left exposed to a normal environment, moisture can penetrate behind the scale, and some “lifting” of the scale by the oxidation process is to be expected. Cleanup of “lifted” mill scale is not the responsibility of the *fabricator*, but is to be assigned by contract requirement to an appropriate contractor.

Section 6.5.4 of this Code is not applicable to weathering steel, for which special cleaning specifications are always required in the *contract documents*.

- 6.5.1. The *fabricator* is not responsible for deterioration of the shop coat that may result from exposure to ordinary atmospheric conditions or corrosive conditions that are more severe than ordinary atmospheric conditions.

Commentary:

The shop coat of paint is the prime coat of the protective system. It is intended as protection for only a short period of exposure in ordinary atmospheric conditions, and is considered a temporary and provisional coating.

- 6.5.2. Unless otherwise specified in the *contract documents*, the *fabricator* shall, as a minimum, hand clean the *structural steel* of loose rust, loose mill scale, dirt and other foreign matter, prior to painting, by means of wire brushing or by other methods elected by the *fabricator*, to meet the requirements of SSPC-SP2. If the *fabricator's* workmanship on surface preparation is to be inspected by the *inspector*, such inspection shall be performed in a timely manner prior to the application of the shop coat.

Commentary:

The selection of a paint system is a design decision involving many factors including:

- (a) The *owner's* preference;
- (b) The service life of the structure;
- (c) The severity of environmental exposure;

- (d) The cost of both initial application and future renewals; and,
- (e) The compatibility of the various components that comprise the paint system (surface preparation, shop coat and subsequent coats).

Because the inspection of shop painting must be concerned with workmanship at each stage of the operation, the *fabricator* provides notice of the schedule of operations and affords the *inspector* access to the work site. Inspection must then be coordinated with that schedule so as to avoid delay of the scheduled operations.

Acceptance of the prepared surface must be made prior to the application of the shop coat because the degree of surface preparation cannot be readily verified after painting. Time delay between surface preparation and the application of the shop coat can result in unacceptable deterioration of a properly prepared surface, necessitating a repetition of surface preparation. This is especially true with blast-cleaned surfaces. Therefore, to avoid potential deterioration of the surface, it is assumed that surface preparation is accepted unless it is inspected and rejected prior to the scheduled application of the shop coat.

The shop coat in any paint system is designed to maximize the wetting and adherence characteristics of the paint, usually at the expense of its weathering capabilities. Deterioration of the shop coat normally begins immediately after exposure to the elements and worsens as the duration of exposure is extended. Consequently, extended exposure of the shop coat will likely lead to its deterioration and may necessitate repair, possibly including the repetition of surface preparation and shop coat application in limited areas. With the introduction of high-performance paint systems, avoiding delay in the application of the shop coat has become more critical. High-performance paint systems generally require a greater degree of surface preparation, as well as early application of weathering protection for the shop coat.

Since the *fabricator* does not control the selection of the paint system, the compatibility of the various components of the total paint system, or the length of exposure of the shop coat, the *fabricator* cannot guarantee the performance of the shop coat or any other part of the system. Instead, the *fabricator* is responsible only for accomplishing the specified surface preparation and for applying the shop coat (or coats) in accordance with the *contract documents*.

This Section stipulates that the *structural steel* is to be cleaned to meet the requirements in SSPC-SP2. This stipulation is not intended to represent an exclusive cleaning level, but rather the level of surface preparation that will be furnished unless otherwise specified in the *contract documents* if the *structural steel* is to be painted.

- 6.5.3. Unless otherwise specified in the *contract documents*, paint shall be applied by brushing, spraying, rolling, flow coating, dipping or other suitable means, at the

election of the *fabricator*. When the term “shop coat”, “shop paint” or other equivalent term is used with no paint system specified, the *fabricator’s* standard shop paint shall be applied to a minimum dry-film thickness of one mil [25 μm].

- 6.5.4. Touch-up of abrasions caused by handling after painting shall be the responsibility of the contractor that performs touch-up in the field or field painting.

Commentary:

Touch-up in the field and field painting are not normally part of the *fabricator’s* or the *erector’s* contract.

6.6. Marking and Shipping of Materials

- 6.6.1. Unless otherwise specified in the *contract documents*, erection marks shall be applied to the *structural steel* members by painting or other suitable means.
- 6.6.2. Bolt assemblies and loose bolts, nuts and washers shall be shipped in separate closed containers according to length and diameter, as applicable. Pins and other small parts and packages of bolts, nuts and washers shall be shipped in boxes, crates, kegs or barrels. A list and description of the material shall appear on the outside of each closed container.

Commentary:

In most cases bolts, nuts and other components in a fastener assembly can be shipped loose in separate containers. However, ASTM F1852/F1852M twist-off-type tension-control bolt assemblies and galvanized ASTM A325, A325M and F1852/F1852M bolt assemblies must be assembled and shipped in the same container according to length and diameter.

6.7. Delivery of Materials

- 6.7.1. Fabricated *structural steel* shall be delivered in a sequence that will permit efficient and economical fabrication and erection, and that is consistent with requirements in the *contract documents*. If the *owner* or *owner’s designated representative for construction* wishes to prescribe or control the sequence of delivery of materials, that entity shall specify the required sequence in the *contract documents*. If the *owner’s designated representative for construction* contracts separately for delivery and for erection, the *owner’s designated representative for construction* shall coordinate planning between contractors.
- 6.7.2. *Anchor rods*, washers, nuts and other anchorage or grillage materials that are to be built into concrete or masonry shall be shipped so that they will be available when needed. The *owner’s designated representative for construction* shall

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allow the *fabricator* sufficient time to fabricate and ship such materials before they are needed.

- 6.7.3. If any shortage is claimed relative to the quantities of materials that are shown in the shipping statements, the *owner's designated representative for construction* or the *erector* shall promptly notify the *fabricator* so that the claim can be investigated.

Commentary:

The quantities of material that are shown in the shipping statement are customarily accepted as correct by the *owner's designated representative for construction*, the *fabricator* and the *erector*.

- 6.7.4. Unless otherwise specified in the *contract documents*, and subject to the approved *shop* and *erection drawings*, the *fabricator* shall limit the number of field splices to that consistent with minimum project cost.

Commentary:

This Section recognizes that the size and weight of *structural steel* assemblies may be limited by shop capabilities, the permissible weight and clearance dimensions of available transportation or job-site conditions.

- 6.7.5. If material arrives at its destination in damaged condition, the receiving entity shall promptly notify the *fabricator* and carrier prior to unloading the material, or promptly upon discovery prior to erection.

SECTION 7. ERECTION

7.1. Method of Erection

Fabricated *structural steel* shall be erected using methods and a sequence that will permit efficient and economical performance of erection, and that is consistent with the requirements in the *contract documents*. If the *owner* or *owner's designated representative for construction* wishes to prescribe or control the method and/or sequence of erection, or specifies that certain members cannot be erected in their normal sequence, that entity shall specify the required method and sequence in the *contract documents*. If the *owner's designated representative for construction* contracts separately for fabrication services and for erection services, the *owner's designated representative for construction* shall coordinate planning between contractors.

Commentary:

Design modifications are sometimes requested by the *erector* to allow or facilitate the erection of the *structural steel* frame. When this is the case, the *erector* should notify the *fabricator* prior to the preparation of *shop and erection drawings* so that the *fabricator* may refer the *erector's* request to the *owner's designated representatives for design and construction* for resolution.

7.2. Job-Site Conditions

The *owner's designated representative for construction* shall provide and maintain the following for the *fabricator* and the *erector*:

- (a) Adequate access roads into and through the job site for the safe delivery and movement of the material to be erected and of derricks, cranes, trucks and other necessary equipment under their own power;
- (b) A firm, properly graded, drained, convenient and adequate space at the job site for the operation of the *erector's* equipment, free from overhead obstructions, such as power lines, telephone lines or similar conditions; and,
- (c) Adequate storage space, when the structure does not occupy the full available job site, to enable the *fabricator* and the *erector* to operate at maximum practical speed.

Otherwise, the *owner's designated representative for construction* shall inform the *fabricator* and the *erector* of the actual job-site conditions and/or special delivery requirements prior to bidding.

7.3. Foundations, Piers and Abutments

The accurate location, strength and suitability of, and access to, all foundations, piers and abutments shall be the responsibility of the *owner's designated representative for construction*.

7.4. Lines and Bench Marks

The *owner's designated representative for construction* shall be responsible for the accurate location of lines and benchmarks at the job site and shall furnish the *erector* with a plan that contains all such information. The *owner's designated representative for construction* shall establish offset lines and reference elevations at each level for the *erector's* use in the positioning of *adjustable items* (see Section 7.13.1.3), if any.

7.5. Installation of Anchor Rods, Foundation Bolts and Other Embedded Items

7.5.1. *Anchor rods*, foundation bolts and other embedded items shall be set by the *owner's designated representative for construction* in accordance with *embedment drawings* that have been approved by the *owner's designated representatives for design and construction*. The variation in location of these items from the dimensions shown in the *embedment drawings* shall be as follows:

- (a) The variation in dimension between the centers of any two *anchor rods* within an *anchor-rod group* shall be equal to or less than $\frac{1}{8}$ in. [3 mm].
- (b) The variation in dimension between the centers of adjacent *anchor-rod groups* shall be equal to or less than $\frac{1}{4}$ in. [6 mm].
- (c) The variation in elevation of the tops of *anchor rods* shall be equal to or less than plus or minus $\frac{1}{2}$ in. [13 mm].
- (d) The accumulated variation in dimension between centers of *anchor-rod groups* along the *column line* through multiple *anchor-rod groups* shall be equal to or less than $\frac{1}{4}$ in. per 100 ft [2 mm per 10 000 mm], but not to exceed a total of 1 in. [25 mm].
- (e) The variation in dimension from the center of any *anchor-rod group* to the *column line* through that group shall be equal to or less than $\frac{1}{4}$ in. [6 mm].

The tolerances that are specified in (b), (c) and (d) shall apply to offset dimensions shown in the structural *design drawings*, measured parallel and perpendicular to the nearest *column line*, for individual columns that are shown in the structural *design drawings* as offset from *column lines*.

Commentary:

The tolerances established in this Section have been selected for compatibility with the holes sizes that are recommended for base plates in the AISC *Steel Construction Manual*. If special conditions require more restrictive tolerances, the contractor responsible for setting the *anchor rods* should be so informed in the *contract documents*. When the *anchor rods* are set in sleeves, the adjustment provided may be used to satisfy the required *anchor-rod* setting tolerances.

- 7.5.2. Unless otherwise specified in the *contract documents*, *anchor rods* shall be set with their longitudinal axis perpendicular to the theoretical bearing surface.
- 7.5.3. Embedded items and *connection* materials that are part of the work of other trades, but that will receive *structural steel*, shall be located and set by the *owner's designated representative for construction* in accordance with an approved *embedment drawing*. The variation in location of these items shall be limited to a magnitude that is consistent with the tolerances that are specified in Section 7.13 for the erection of the *structural steel*.
- 7.5.4. All work that is performed by the *owner's designated representative for construction* shall be completed so as not to delay or interfere with the work of the *fabricator* and the *erector*. The *owner's designated representative for construction* shall conduct a survey of the as-built locations of *anchor rods*, foundation bolts and other embedded items, and shall verify that all items covered in Section 7.5 meet the corresponding tolerances. When corrective action is necessary, the *owner's designated representative for construction* shall obtain the guidance and approval of the *owner's designated representative for design*.

Commentary:

Few *fabricators* or *erectors* have the capability to provide this survey. Under standard practice, it is the responsibility of others.

7.6. Installation of Bearing Devices

All leveling plates, leveling nuts and washers and loose base and bearing plates that can be handled without a derrick or crane are set to line and grade by the *owner's designated representative for construction*. Loose base and bearing plates that require handling with a derrick or crane shall be set by the *erector* to lines and grades established by the *owner's designated representative for construction*. The *fabricator* shall clearly scribe loose base and bearing plates with lines or other suitable marks to facilitate proper alignment.

Promptly after the setting of *bearing devices*, the *owner's designated representative for construction* shall check them for line and grade. The variation in elevation relative to the established grade for all *bearing devices* shall be equal to or less than plus or minus $\frac{1}{8}$ in. [3 mm]. The final location of *bearing devices* shall be the responsibility of the *owner's designated representative for construction*.

Commentary:

The $\frac{1}{8}$ in. [3 mm] tolerance on elevation of *bearing devices* relative to established grades is provided to permit some variation in setting *bearing devices*, and to account for the accuracy that is attainable with standard surveying instruments. The use of leveling plates larger than 22 in. by 22 in.

[550 mm by 550 mm] is discouraged and grouting is recommended with larger sizes. For the purposes of erection stability, the use of leveling nuts and washers is discouraged when base plates have less than four *anchor rods*.

7.7. Grouting

Grouting shall be the responsibility of the *owner's designated representative for construction*. Leveling plates and loose base and bearing plates shall be promptly grouted after they are set and checked for line and grade. Columns with attached base plates, beams with attached bearing plates and other similar members with attached *bearing devices* that are temporarily supported on leveling nuts and washers, shims or other similar leveling devices, shall be promptly grouted after the *structural steel* frame or portion thereof has been plumbed.

Commentary:

In the majority of structures the vertical load from the column bases is transmitted to the foundations through structural grout. In general, there are three methods by which support is provided for column bases during erection:

- (a) Pre-grouted leveling plates or loose base plates;
- (b) Shims; and,
- (c) Leveling nuts and washers on the *anchor rods* beneath the column base.

Standard practice provides that loose base plates and leveling plates are to be grouted as they are set. *Bearing devices* that are set on shims or leveling nuts are grouted after plumbing, which means that the weight of the erected *structural steel* frame is supported on the shims or washers, nuts and *anchor rods*. The *erector* must take care to ensure that the load that is transmitted in this temporary condition does not exceed the strength of the shims or washers, nuts and *anchor rods*. These considerations are presented in greater detail in AISC Design Guides No. 1 and 10.

7.8. Field Connection Material

- 7.8.1. The *fabricator* shall provide field *connection* details that are consistent with the requirements in the *contract documents* and that will, in the *fabricator's* opinion, result in economical fabrication and erection.
- 7.8.2. When the *fabricator* is responsible for erecting the *structural steel*, the *fabricator* shall furnish all materials that are required for both temporary and permanent *connection* of the component parts of the *structural steel* frame.
- 7.8.3. When the erection of the *structural steel* is not performed by the *fabricator*, the *fabricator* shall furnish the following field *connection* material:

- (a) Bolts, nuts and washers of the required grade, type and size and in sufficient quantity for all *structural steel-to-structural steel* field *connections* that are to be permanently bolted, including an extra 2 percent of each bolt size (diameter and length);
 - (b) Shims that are shown as necessary for make-up of permanent *structural steel-to-structural steel* field *connections*; and,
 - (c) Backing bars and run-off tabs that are required for field welding.
- 7.8.4. The *erector* shall furnish all welding electrodes, fit-up bolts and drift pins used for the erection of the *structural steel*.

Commentary:

See the Commentary for Section 2.2.

7.9. Loose Material

Unless otherwise specified in the *contract documents*, loose *structural steel* items that are not connected to the *structural steel* frame shall be set by the *owner's designated representative for construction* without assistance from the *erector*.

7.10. Temporary Support of Structural Steel Frames

- 7.10.1. The *owner's designated representative for design* shall identify the following in the *contract documents*:
- (a) The lateral-load-resisting system and connecting diaphragm elements that provide for lateral strength and stability in the completed structure; and,
 - (b) Any special erection conditions or other considerations that are required by the design concept, such as the use of shores, jacks or loads that must be adjusted as erection progresses to set or maintain camber, position within specified tolerances or prestress.

Commentary:

The intent of Section 7.10.1 of the Code is to alert the *owner's designated representative for construction* and the *erector* of the means for lateral load resistance in the completed structure so that appropriate planning can occur for construction of the building. Examples of a description of the lateral load resisting system as required by 7.10.1(a) are shown below.

Example 1 is an all-steel building with a composite metal deck and concrete floor system. All lateral load resistance is provided by welded moment frames in each orthogonal building direction. One suitable description of this lateral load resisting system is:

All lateral load resistance and stability of the building in the completed structure is provided by moment frames with welded beam to column connections framed in each orthogonal direction (see plan sheets for locations). The composite metal deck and concrete floors serve as horizontal diaphragms that distribute the lateral wind and seismic forces horizontally to the vertical moment frames. The vertical moment frames carry the applied lateral loads to the building foundation.

Example 2 is a steel-framed building with a composite metal deck and concrete floor system. All beam-to-column connections are simple connections and all lateral load resistance is provided by reinforced concrete shear walls in the building core and in the stair wells. One suitable description of this lateral load resisting system is:

All lateral load resistance and stability of the building in the completed structure is provided exclusively by cast-in-place reinforced concrete shear walls in the building core and stair wells (see plan sheets for locations). These walls provide all lateral load resistance in each orthogonal building direction. The composite metal deck and concrete floors serve as horizontal diaphragms that distribute the lateral wind and seismic forces horizontally to the concrete shear walls. The concrete shear walls carry the applied lateral loads to the building foundation.

See also Commentary Section 7.10.3.

Section 7.10.1(b) is intended to apply to special requirements inherent in the design concept that could not otherwise be known by the *erector*. Such conditions might include designs that require the use of shores or jacks to impart a load or to obtain a specific elevation or position in a subsequent step of the erection process in a sequentially erected structure or member. These requirements would not be apparent to an *erector*, and must be identified so the *erector* can properly bid, plan and perform the erection.

The *erector* is responsible for installation of all members (including cantilevered members) to the specified plumbness, elevation, and alignment within the erection tolerances specified in this Code. The *erector* must provide all temporary supports and devices to maintain elevation or position within these tolerances. These works are part of the means and methods of the *erector* and the *owner's designated representative for design* need not specify these methods or related equipment.

- 7.10.2. The *owner's designated representative for construction* shall indicate to the *erector* prior to bidding, the installation schedule for non-structural steel elements of the lateral-load-resisting system and connecting diaphragm elements identified by the *owner's designated representative for design* in the contract documents.

Commentary:

See Commentary Section 7.10.3.

- 7.10.3. Based upon the information provided in accordance with Sections 7.10.1 and 7.10.2, the *erector* shall determine, furnish and install all temporary supports, such as temporary guys, beams, falsework, cribbing or other elements required for the erection operation. These temporary supports shall be sufficient to secure the bare *structural steel* framing or any portion thereof against loads that are likely to be encountered during erection, including those due to wind and those that result from erection operations.

The *erector* need not consider loads during erection that result from the performance of work by, or the acts of, others, except as specifically identified by the *owner's designated representatives for design and construction*, nor those that are unpredictable, such as loads due to hurricane, tornado, earthquake, explosion or collision.

Temporary supports that are required during or after the erection of the *structural steel* frame for the support of loads caused by non-*structural steel* elements, including cladding, interior partitions and other such elements that will induce or transmit loads to the *structural steel* frame during or after erection, shall be the responsibility of others.

Commentary:

Many *structural steel* frames have lateral-load-resisting systems that are activated during the erection process. Such lateral-load-resisting systems may consist of welded moment frames, braced frames or, in some instances, columns that cantilever from fixed-base foundations. Such frames are normally braced with temporary guys that, together with the steel deck floor and roof diaphragms, or other diaphragm bracing that may be included as part of the design, provide stability during the erection process. The guy cables are also commonly used to plumb the *structural steel* frame. The *erector* normally furnishes and installs the required temporary supports and bracing to secure the bare *structural steel* frame, or portion thereof, during the erection process. When *erection bracing drawings* are required in the *contract documents*, those drawings show this information.

If the *owner's designated representative for construction* determines that steel decking is not installed by the *erector*, temporary diaphragm bracing may be required if a horizontal diaphragm is not available to distribute loads to the vertical and lateral load resisting system. If the steel deck will not be available as a diaphragm during *structural steel* erection, the *owner's designated representative for construction* must communicate this condition to the *erector* prior to bidding. If such diaphragm bracing is required, it must be furnished and installed by the *erector*.

Sometimes structural systems that are employed by the *owner's designated representative for design* rely upon other elements besides the *structural steel* frame for lateral-load resistance. For instance, concrete or masonry shear walls or precast spandrels may be used to provide resistance to vertical and lateral loads in the completed structure. Because these situations may not be obvious to the contractor or the *erector*, it is required in this Code that the *owner's designated representative for design* must identify such situations in the *contract documents*. Similarly, if a structure is designed so that special erection techniques are required, such as jacking to impose certain loads or position during erection, it is required in this Code that such requirements be specifically identified in the *contract documents*.

In some instances, the *owner's designated representative for design* may elect to show erection bracing in the structural *design drawings*. When this is the case, the *owner's designated representative for design* should then confirm that the bracing requirements were understood by review and approval of the *erection drawings* during the submittal process.

Sometimes during construction of a building, collateral building elements, such as exterior cladding, may be required to be installed on the bare *structural steel* frame prior to completion of the lateral-load-resisting system. These elements may increase the potential for lateral loads on the temporary supports. Such temporary supports may also be required to be left in place after the *structural steel* frame has been erected. Special provisions should be made by the *owner's designated representative for construction* for these conditions.

- 7.10.4. All temporary supports that are required for the erection operation and furnished and installed by the *erector* shall remain the property of the *erector* and shall not be modified, moved or removed without the consent of the *erector*. Temporary supports provided by the *erector* shall remain in place until the portion of the *structural steel* frame that they brace is complete and the lateral-load-resisting system and connecting diaphragm elements identified by the *owner's designated representative for design* in accordance with Section 7.10.1 are installed. Temporary supports that are required to be left in place after the completion of *structural steel* erection shall be removed when no longer needed by the *owner's designated representative for construction* and returned to the *erector* in good condition.

7.11. Safety Protection

- 7.11.1. The *erector* shall provide floor coverings, handrails, walkways and other safety protection for the *erector's* personnel as required by law and the applicable safety regulations. Unless otherwise specified in the *contract documents*, the *erector* is permitted to remove such safety protection from areas where the erection operations are completed.

- 7.11.2. When safety protection provided by the *erector* is left in an area for the use of other trades after the *structural steel* erection activity is completed, the *owner's designated representative for construction* shall:
- (a) Accept responsibility for and maintain this protection;
 - (b) Indemnify the *fabricator* and the *erector* from damages that may be incurred from the use of this protection by other trades;
 - (c) Ensure that this protection is adequate for use by other affected trades;
 - (d) Ensure that this protection complies with applicable safety regulations when being used by other trades; and,
 - (e) Remove this protection when it is no longer required and return it to the *erector* in the same condition as it was received.
- 7.11.3. Safety protection for other trades that are not under the direct employment of the *erector* shall be the responsibility of the *owner's designated representative for construction*.
- 7.11.4. When permanent steel decking is used for protective flooring and is installed by the *owner's designated representative for construction*, all such work shall be scheduled and performed in a timely manner so as not to interfere with or delay the work of the *fabricator* or the *erector*. The sequence of installation that is used shall meet all safety regulations.
- 7.11.5. Unless the interaction and safety of activities of others, such as construction by others or the storage of materials that belong to others, are coordinated with the work of the *erector* by the *owner's designated representative for construction*, such activities shall not be permitted until the erection of the *structural steel* frame or portion thereof is completed by the *erector* and accepted by the *owner's designated representative for construction*.
- 7.12. Structural Steel Frame Tolerances**
The accumulation of the mill tolerances and fabrication tolerances shall not cause the erection tolerances to be exceeded.

Commentary:

In editions of this Code previous to the 2005 edition, it was stated that "...variations are deemed to be within the limits of good practice when they do not exceed the cumulative effect of rolling tolerances, fabricating tolerances and erection tolerances." It is recognized in the current provision in this Section that accumulations of mill tolerances and fabrication tolerances generally occur between the locations at which erection tolerances are applied, and not at the same locations.

7.13. Erection Tolerances

Erection tolerances shall be defined relative to member working points and working lines, which shall be defined as follows:

- (a) For members other than horizontal members, the member work point shall be the actual center of the member at each end of the shipping piece.
- (b) For horizontal members, the working point shall be the actual centerline of the top flange or top surface at each end.
- (c) The member working line shall be the straight line that connects the member working points.

The substitution of other working points is permitted for ease of reference, provided they are based upon the above definitions.

The tolerances on *structural steel* erection shall be in accordance with the requirements in Sections 7.13.1 through 7.13.3.

Commentary:

The erection tolerances defined in this Section have been developed through long-standing usage as practical criteria for the erection of *structural steel*. Erection tolerances were first defined in the 1924 edition of this Code in Section 7(f), "Plumbing Up." With the changes that took place in the types and use of materials in building construction after World War II, and the increasing demand by *architects* and *owners* for more specific tolerances, AISC adopted new standards for erection tolerances in Section 7(h) of the March 15, 1959 edition of this Code. Experience has proven that those tolerances can be economically obtained.

Differential column shortening may be a consideration in design and construction. In some cases, it may occur due to variability in the accumulation of dead load among different columns (see Figure C-7.1). In other cases, it may be characteristic of the structural system that is employed in the design. Consideration of the effects of differential column shortening may be very important, such as when the slab thickness is reduced, when electrical and other similar fittings mounted on the *structural steel* are intended to be flush with the finished floor and when there is little clearance between bottoms of beams and the tops of door frames or ductwork.

The effects of the deflection of transfer girders and trusses on the position of columns and hangers supported from them may be a consideration in design and construction. As in the case of differential column shortening, the deflection of these supporting members during and after construction will affect the position and alignment of the framing tributary to these transfer members.

(Commentary continues after figures)

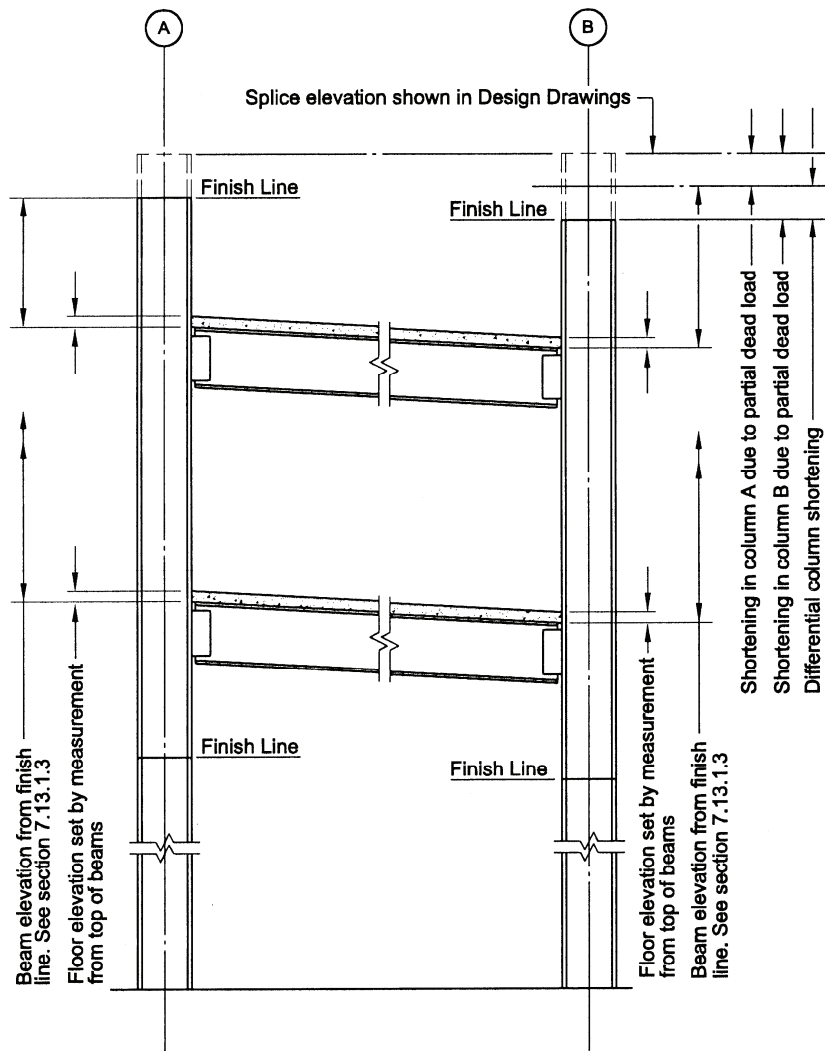


Figure C-7.1. Effects of differential column shortening.

When plumbing columns, apply a temperature adjustment at a rate of 1/8 in. per 100 ft. for each change of 15°F [2 mm per 10 000 mm for each change of 15°C] between the temperature at the time of erection and the working temperature.

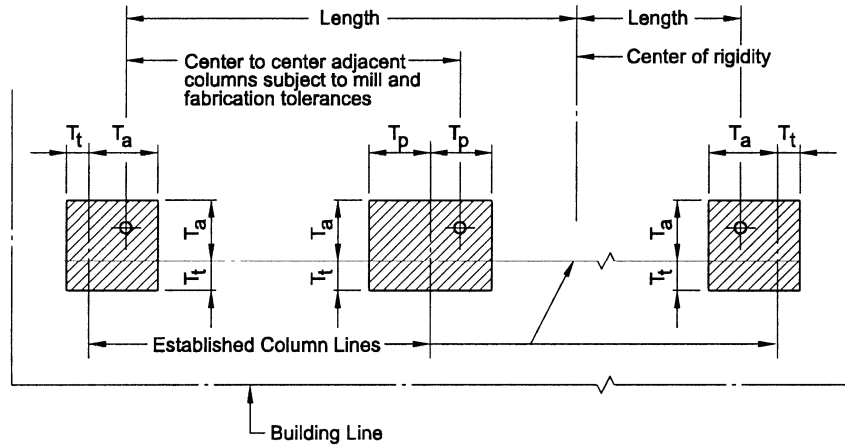
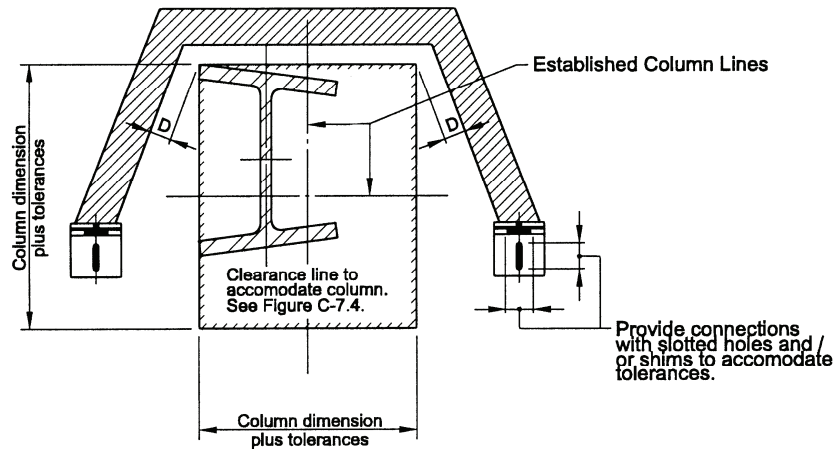


Figure C-7.2. Tolerances in plan location of column.



If fascia joints are set from nearest column finish line, allow $\pm 5/8$ in. [16mm] for vertical adjustment. The entity responsible for the fascia details must allow for progressive shortening of steel columns.

D= Tolerances required by manufacturer of wall units plus survey tolerances.

Figure C-7.3. Clearance required to accommodate fascia.

Expansion and contraction in a *structural steel* frame may be a consideration in design and construction. Steel will expand or contract approximately $\frac{1}{8}$ in. per 100 ft for each change of 15°F [2 mm per 10 000 mm for each change of 15°C] in temperature. This change in length can be assumed to act about the center of rigidity. When anchored to their foundations, end columns will be plumb only when the steel is at normal temperature (see Figure C-7.2). It is therefore necessary to correct field measurements of offsets to the structure from established baselines for the expansion or contraction of the exposed *structural steel* frame. For example, a 200-ft-long [60 000-m-long] building that is plumbed up at 100°F [38°C] should have working points at the tops of the end columns positioned $\frac{1}{2}$ in. [14 mm] further apart than the working points at the corresponding bases in order for the columns to be plumb at 70°F [21°C]. Differential temperature effects on column length should also be taken into account in plumbing surveys when tall *structural steel* frames are subjected to sun exposure on one side.

The alignment of lintels, spandrels, wall supports and similar members that are used to connect other building construction units to the *structural steel* frame should have an adjustment of sufficient magnitude to allow for the accumulation of mill tolerances and fabrication tolerances, as well as the erection tolerances. See Figure C-7.3.

- 7.13.1. The tolerances on position and alignment of member working points and working lines shall be as described in Sections 7.13.1.1 through 7.13.1.3.
- 7.13.1.1. For an individual column shipping piece, the angular variation of the working line from a plumb line shall be equal to or less than 1/500 of the distance between working points, subject to the following additional limitations:
 - (a) For an individual column shipping piece that is adjacent to an elevator shaft, the displacement of member working points shall be equal to or less than 1 in. [25 mm] from the *established column line* in the first 20 stories. Above this level, an increase in the displacement of $\frac{1}{32}$ in. [1 mm] is permitted for each additional story up to a maximum displacement of 2 in. [50 mm] from the *established column line*.
 - (b) For an exterior individual column shipping piece, the displacement of member working points from the *established column line* in the first 20 stories shall be equal to or less than 1 in. [25 mm] toward and 2 in. [50 mm] away from the building line. Above this level, an increase in the displacement of $\frac{1}{16}$ in. [2 mm] is permitted for each additional story up to a maximum displacement of 2 in. [50 mm] toward and 3 in. [75 mm] away from the building line.

Commentary:

The limitations that are described in this Section and illustrated in Figures C-7.4 and C-7.5 make it possible to maintain built-in-place or

prefabricated facades in a true vertical plane up to the 20th story, if *connections* that provide for 3 in. [75 mm] of adjustment are used. Above the 20th story, the facade may be maintained within $\frac{1}{16}$ in. [2 mm] per story with a maximum total deviation of 1 in. [25 mm] from a true vertical plane, if *connections* that provide for 3 in. [75 mm] of adjustment are used. *Connections* that permit adjustments of plus 2 in. [50 mm] to minus 3 in. [75 mm] (5 in. [125 mm] total) will be necessary in cases where it is desired to construct the facade to a true vertical plane above the 20th story.

- (c) For an exterior individual column shipping piece, the member working points at any splice level for multi-*tier* buildings and at the tops of columns for single-*tier* buildings shall fall within a horizontal envelope, parallel to the building line, that is equal to or less than $1\frac{1}{2}$ in. [38 mm] wide for buildings up to 300 ft [90 000 mm] in length. An increase in the width of this horizontal envelope of $\frac{1}{2}$ in. [13 mm] is permitted for each additional 100 ft [30 000 m] in length up to a maximum width of 3 in. [75 mm].

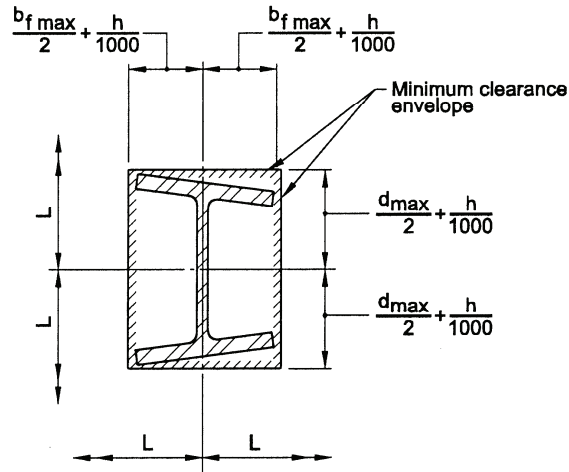
Commentary:

This Section limits the position of exterior column working points at any given splice elevation to a narrow horizontal envelope parallel to the building line (see Figure C-7.6). This envelope is limited to a width of $1\frac{1}{2}$ in. [38 mm], normal to the building line, in up to 300 ft [90 000 mm] of building length. The horizontal location of this envelope is not necessarily directly above or below the corresponding envelope at the adjacent splice elevations, but should be within the limitation of the 1 in 500 plumbness tolerance specified for the controlling columns (see Figure C-7.5).

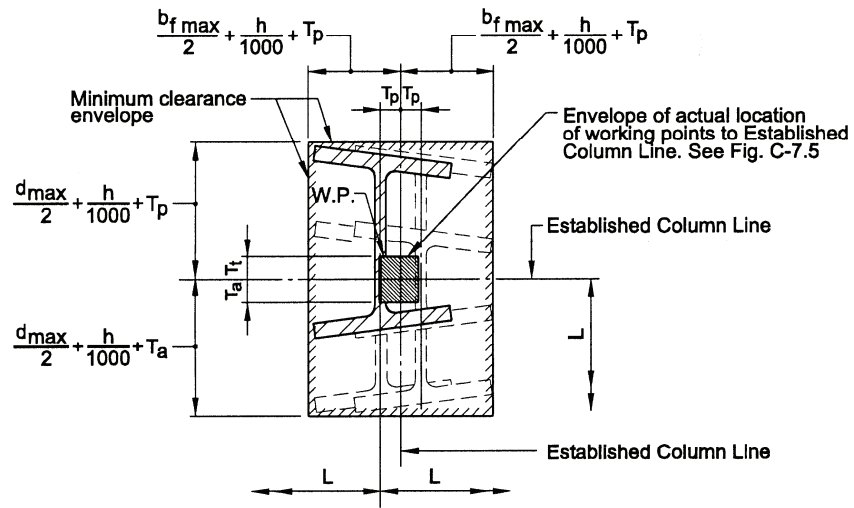
- (d) For an exterior column shipping piece, the displacement of member working points from the *established column line*, parallel to the building line, shall be equal to or less than 2 in. [50 mm] in the first 20 stories. Above this level, an increase in the displacement of $\frac{1}{16}$ in. [2 mm] is permitted for each additional story up to a maximum displacement of 3 in. [75 mm] parallel to the building line.

7.13.1.2. For members other than column shipping pieces, the following limitations shall apply:

- (a) For a member that consists of an individual, straight shipping piece without field splices, other than a cantilevered member, the variation in alignment shall be acceptable if it is caused solely by variations in column alignment and/or primary supporting member alignment that are within the permissible variations for the fabrication and erection of such members.
- (b) For a member that consists of an individual, straight shipping piece that connects to a column, the variation in the distance from the member working point to the upper finished splice line of the column shall be equal to or less than plus $\frac{3}{16}$ in. [5 mm] and minus $\frac{5}{16}$ in. [8 mm].



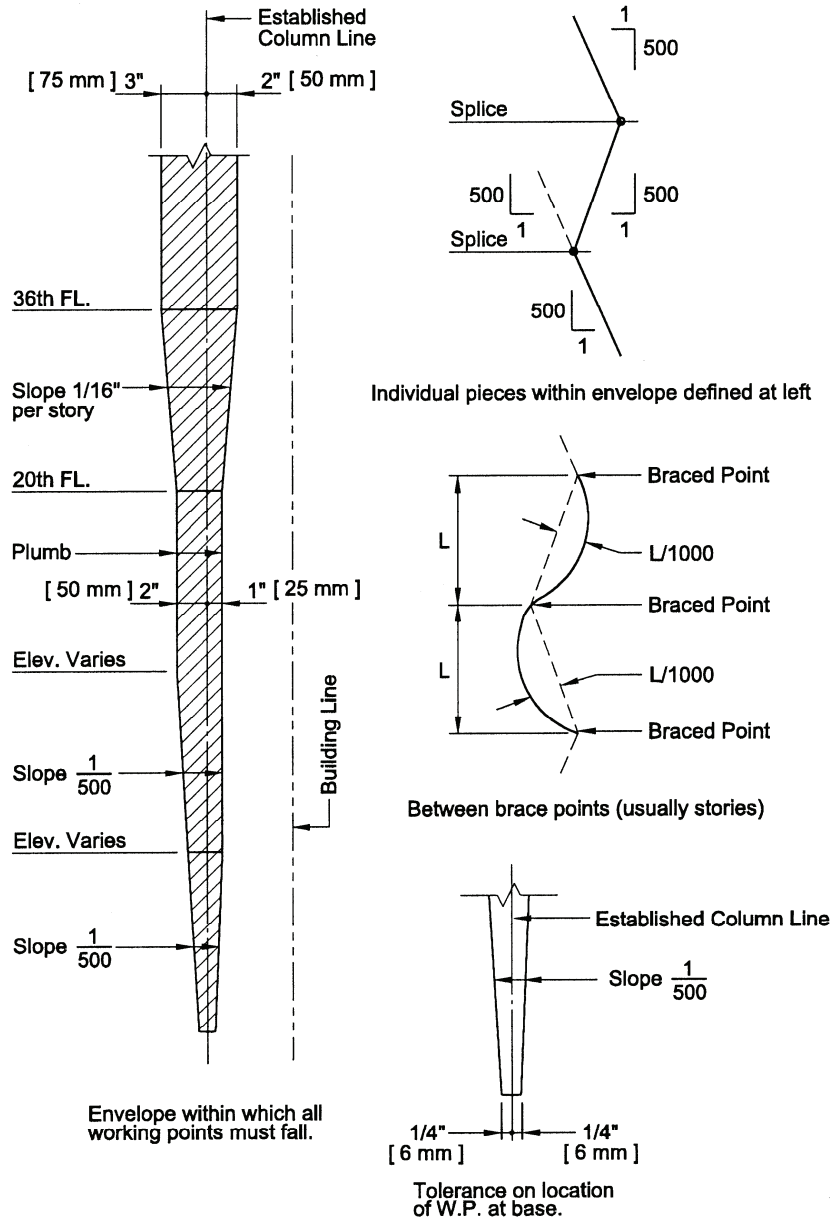
For enclosures or attachments that may follow column alignment.



For enclosures or attachments that must be held to precise plan location.

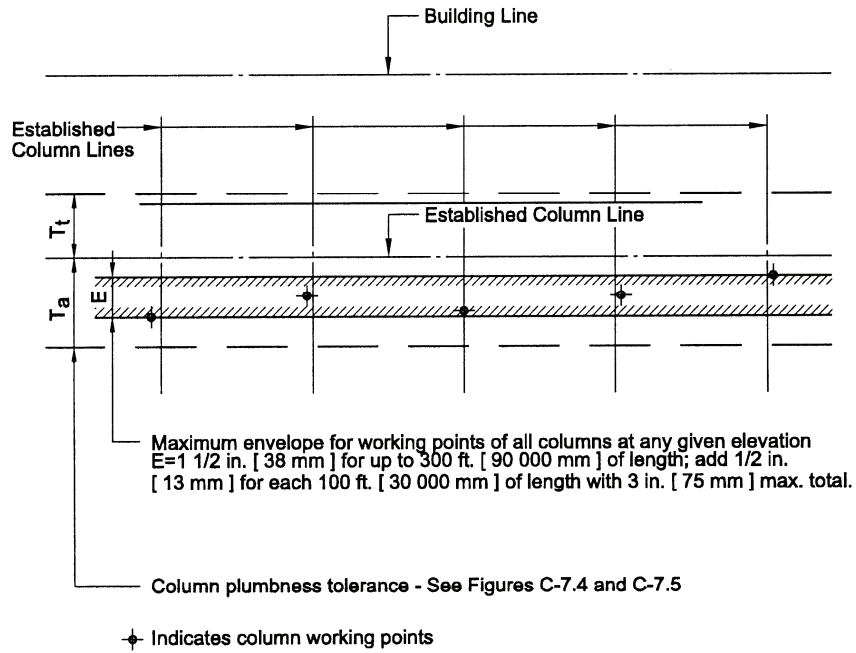
- L = Actual center to center of columns = plan dimensions ± column cross section tolerance of columns ± beam length tolerance.
- T_a = Plumbness tolerance away from building line (varies, see Fig. C-7.5)
- T_t = Plumbness tolerance toward building line (varies, see Fig. C-7.5)
- T_p = Plumbness tolerance parallel to building line (=T_a)

Figure C-7.4. Clearance required to accommodate accumulated column tolerance.



Note: The plumb line through the base working point for an individual column is not necessarily the precise plan location because Sect. 7.13.1.1 deals only with plumbness tolerances and does not include inaccuracies in location of the Established Column Line, foundations and anchor rods beyond the Erector's control

Figure C-7.5. Exterior column plumbness tolerances normal to building line.



At any splice elevation, envelope "E" is located within the limits T_a and T_t
 At any splice elevation, envelope "E" may be located offset from the corresponding envelope at the adjacent splice elevations, above and below, by an amount not greater than $\frac{1}{500}$ of the column length.

Figure C-7.6. Tolerances in plan at any splice elevation of exterior columns.

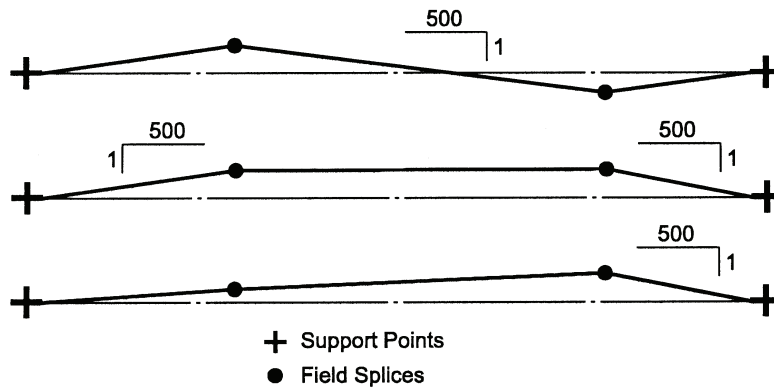


Figure C-7.7. Alignment tolerances for members with field splices.

- (c) For a member that consists of an individual shipping piece that does not connect to a column, the variation in elevation shall be acceptable if it is caused solely by the variations in the elevations of the supporting members within the permissible variations for the fabrication and erection of those members.
- (d) For a member that consists of an individual, straight shipping piece and that is a segment of a field assembled unit containing field splices between points of support, the plumbness, elevation and alignment shall be acceptable if the angular variation, vertically and horizontally, of the working line from a straight line between points of support is equal to or less than 1/500 of the distance between working points.

Commentary:

The angular misalignment of the working line of all fabricated shipping pieces relative to the line between support points of the member as a whole in erected position must not exceed 1 in 500. Note that the tolerance is not stated in terms of a linear displacement at any point and is not to be taken as the overall length between supports divided by 500. Typical examples are shown in Figure C-7.7. Numerous conditions within tolerance for these and other cases are possible. The condition described in (d) applies to both plan and elevation tolerances.

- (e) For a cantilevered member that consists of an individual, straight shipping piece, the plumbness, elevation and alignment shall be acceptable if the angular variation of the working line from a straight line that is extended in the plan direction from the working point at its supported end is equal to or less than 1/500 of the distance from the working point at the free end.
- (f) For a member of irregular shape, the plumbness, elevation and alignment shall be acceptable if the fabricated member is within its tolerances and the members that support it are within the tolerances specified in this Code.
- (g) For a member that is fully assembled in the field in an unstressed condition, the same tolerances shall apply as if fully assembled in the shop.
- (h) For a member that is field-assembled, element-by-element in place, temporary support shall be used or an alternative erection plan shall be submitted to the *owner's designated representatives for design and construction*. The tolerance in Section 7.13.1.2(d) shall be met in the supported condition with working points taken at the point(s) of temporary support.

Commentary:

Trusses fabricated and erected as a unit or as an assembly of truss segments normally have excellent controls on vertical position regardless of fabrication and erection techniques. However, a truss fabricated and erected by assembling individual components in place in the field is potentially

more sensitive to deflections of the individual truss components and the partially completed work during erection, particularly the chord members. In such a case, the erection process should follow an erection plan that addresses this issue.

7.13.1.3. For members that are identified as *adjustable items* by the *owner's designated representative for design* in the *contract documents*, the *fabricator* shall provide adjustable *connections* for these members to the supporting *structural steel* frame. Otherwise, the *fabricator* is permitted to provide non-adjustable *connections*. When *adjustable items* are specified, the *owner's designated representative for design* shall indicate the total adjustability that is required for the proper alignment of these supports for other trades. The variation in the position and alignment of *adjustable items* shall be as follows:

- (a) The variation in the vertical distance from the upper finished splice line of the nearest column to the support location specified in the structural *design drawings* shall be equal to or less than plus or minus $\frac{3}{8}$ in. [10 mm].
- (b) The variation in the horizontal distance from the established finish line at the particular floor shall be equal to or less than plus or minus $\frac{3}{8}$ in. [10 mm].
- (c) The variation in vertical and horizontal alignment at the abutting ends of *adjustable items* shall be equal to or less than plus or minus $\frac{3}{16}$ in. [5 mm].

Commentary:

When the alignment of lintels, wall supports, curb angles, mullions and similar supporting members for the use of other trades is required to be closer than that permitted by the foregoing tolerances for *structural steel*, the *owner's designated representative for design* must identify such items in the *contract documents* as *adjustable items*.

7.13.2. In the design of steel structures, the *owner's designated representative for design* shall provide for the necessary clearances and adjustments for material furnished by other trades to accommodate the mill tolerances, fabrication tolerances and erection tolerances in this Code for the *structural steel* frame.

Commentary:

In spite of all efforts to minimize inaccuracies, deviations will still exist; therefore, in addition, the designs of prefabricated wall panels, partition panels, fenestrations, floor-to-ceiling door frames and similar elements must provide for clearance and details for adjustment as described in Section 7.13.2. Designs must provide for adjustment in the vertical dimension of prefabricated facade panels that are supported by the *structural steel* frame because the accumulation of shortening of loaded steel columns will result in the unstressed facade supported at each floor level being higher than the *structural steel* framing to

which it must be attached. Observations in the field have shown that where a heavy facade is erected to a greater height on one side of a multistory building than on the other, the *structural steel* framing will be pulled out of alignment. Facades should be erected at a relatively uniform rate around the perimeter of the structure.

- 7.13.3. Prior to placing or applying any other materials, the *owner's designated representative for construction* shall determine that the location of the *structural steel* is acceptable for plumbness, elevation and alignment. The *erector* shall be given either timely notice of acceptance by the *owner's designated representative for construction*, or a listing of specific items that are to be corrected in order to obtain acceptance. Such notice shall be rendered promptly upon completion of any part of the work and prior to the start of work by other trades that may be supported, attached or applied to the *structural steel* frame.

7.14. Correction of Errors

The correction of minor misfits by moderate amounts of reaming, grinding, welding or cutting, and the drawing of elements into line with drift pins, shall be considered to be normal erection operations. Errors that cannot be corrected using the foregoing means, or that require major changes in member or *connection* configuration, shall be promptly reported to the *owner's designated representatives for design and construction* and the *fabricator* by the *erector*, to enable the responsible entity to either correct the error or approve the most efficient and economical method of correction to be used by others.

Commentary:

As used in this Section, the term “moderate” refers to the amount of reaming, grinding, welding or cutting that must be done on the project as a whole, not the amount that is required at an individual location. It is not intended to address limitations on the amount of material that is removed by reaming at an individual bolt hole, for example, which is limited by the bolt-hole size and tolerance requirements in the AISC and RCSC Specifications.

7.15. Cuts, Alterations and Holes for Other Trades

Neither the *fabricator* nor the *erector* shall cut, drill or otherwise alter their work, nor the work of other trades, to accommodate other trades, unless such work is clearly specified in the *contract documents*. When such work is so specified, the *owner's designated representatives for design and construction* shall furnish complete information as to materials, size, location and number of alterations in a timely manner so as not to delay the preparation of *shop* and *erection drawings*.

7.16. Handling and Storage

The *erector* shall take reasonable care in the proper handling and storage of the *structural steel* during erection operations to avoid the accumulation of excess dirt and foreign matter. The *erector* shall not be responsible for the removal from the *structural steel* of dust, dirt or other foreign matter that may

accumulate during erection as the result of job-site conditions or exposure to the elements. The *erector* shall handle and store all bolts, nuts, washers and related fastening products in accordance with the requirements of the RCSC Specification.

Commentary:

During storage, loading, transport, unloading and erection, blemish marks caused by slings, chains, blocking, tie-downs, etc., occur in varying degrees. Abrasions caused by handling or cartage after painting are to be expected. It must be recognized that any shop-applied coating, no matter how carefully protected, will require touching-up in the field. Touching-up of these blemished areas is the responsibility of the contractor performing the field touch-up or field painting.

The *erector* is responsible for the proper storage and handling of fabricated *structural steel* at the job site during erection. Shop-painted *structural steel* that is stored in the field pending erection should be kept free of the ground and positioned so as to minimize the potential for water retention. The *owner* or *owner's designated representative for construction* is responsible for providing suitable job-site conditions and proper access so that the *fabricator* and the *erector* may perform their work.

Job-site conditions are frequently muddy, sandy, dusty or a combination thereof during the erection period. Under such conditions it may be impossible to store and handle the *structural steel* in such a way as to completely avoid any accumulation of mud, dirt or sand on the surface of the *structural steel*, even though the *fabricator* and the *erector* manages to proceed with their work.

Repairs of damage to painted surfaces and/or removal of foreign materials due to adverse job-site conditions are outside the scope of responsibility of the *fabricator* and the *erector* when reasonable attempts at proper handling and storage have been made.

7.17. Field Painting

Neither the *fabricator* nor the *erector* is responsible to paint field bolt heads and nuts or field welds, nor to touch up abrasions of the shop coat, nor to perform any other field painting.

7.18. Final Cleaning Up

Upon the completion of erection and before final acceptance, the *erector* shall remove all of the *erector's* falsework, rubbish and temporary buildings.

SECTION 8. QUALITY CONTROL**8.1. General**

- 8.1.1. The *fabricator* shall maintain a quality control program to ensure that the work is performed in accordance with the requirements in this Code, the AISC Specification and the *contract documents*. The *fabricator* shall have the option to use the AISC Quality Certification Program to establish and administer the quality control program.

Commentary:

The AISC Quality Certification Program confirms to the construction industry that a certified *structural steel* fabrication shop has the capability by reason of commitment, personnel, organization, experience, procedures, knowledge and equipment to produce fabricated *structural steel* of the required quality for a given category of work. The AISC Quality Certification Program is not intended to involve inspection and/or judgment of product quality on individual projects. Neither is it intended to guarantee the quality of specific fabricated *structural steel* products.

- 8.1.2. The *erector* shall maintain a quality control program to ensure that the work is performed in accordance with the requirements in this Code, the AISC Specification and the *contract documents*. The *erector* shall be capable of performing the erection of the *structural steel*, and shall provide the equipment, personnel and management for the scope, magnitude and required quality of each project. The *erector* shall have the option to use the AISC Erector Certification Program to establish and administer the quality control program.

Commentary:

The AISC Erector Certification Program confirms to the construction industry that a certified *structural steel erector* has the capability by reason of commitment, personnel, organization, experience, procedures, knowledge and equipment to erect fabricated *structural steel* to the required quality for a given category of work. The AISC Erector Certification Program is not intended to involve inspection and/or judgment of product quality on individual projects. Neither is it intended to guarantee the quality of specific erected *structural steel* products.

- 8.1.3. When the *owner* requires more extensive quality control procedures, or independent inspection by qualified personnel, or requires that the *fabricator* must be certified under the AISC Quality Certification Program and/or requires that the *erector* must be certified under the AISC Erector Certification Program, this shall be clearly stated in the *contract documents*, including a definition of the scope of such inspection.

8.2. Inspection of Mill Material

Material test reports shall constitute sufficient evidence that the mill product satisfies material order requirements. The *fabricator* shall make a visual inspection of material that is received from the mill, but need not perform any material tests unless the *owner's designated representative for design* specifies in the *contract documents* that additional testing is to be performed at the *owner's* expense.

8.3. Non-Destructive Testing

When non-destructive testing is required, the process, extent, technique and standards of acceptance shall be clearly specified in the *contract documents*.

8.4. Surface Preparation and Shop Painting Inspection

Inspection of surface preparation and shop painting shall be planned for the acceptance of each operation as the *fabricator* completes it. Inspection of the paint system, including material and thickness, shall be made promptly upon completion of the paint application. When wet-film thickness is to be inspected, it shall be measured during the application.

8.5. Independent Inspection

When inspection by personnel other than those of the *fabricator* and/or *erector* is specified in the *contract documents*, the requirements in Sections 8.5.1 through 8.5.6 shall be met.

8.5.1. The *fabricator* and the *erector* shall provide the *inspector* with access to all places where the work is being performed. A minimum of 24 hours notification shall be given prior to the commencement of work.

8.5.2. Inspection of shop work by the *inspector* shall be performed in the *fabricator's* shop to the fullest extent possible. Such inspections shall be timely, in-sequence and performed in such a manner as will not disrupt fabrication operations and will permit the repair of non-conforming work prior to any required painting while the material is still in-process in the fabrication shop.

8.5.3. Inspection of field work shall be promptly completed without delaying the progress or correction of the work.

8.5.4. Rejection of material or workmanship that is not in conformance with the *contract documents* shall be permitted at any time during the progress of the work. However, this provision shall not relieve the *owner* or the *inspector* of the obligation for timely, in-sequence inspections.

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- 8.5.5. The *fabricator, erector, and owner's designated representatives for design and construction* shall be informed of deficiencies that are noted by the *inspector* promptly after the inspection. Copies of all reports prepared by the *inspector* shall be promptly given to the *fabricator, erector, and owner's designated representatives for design and construction*. The necessary corrective work shall be performed in a timely manner.
- 8.5.6. The *inspector* shall not suggest, direct, or approve the *fabricator* or *erector* to deviate from the *contract documents* or the approved *shop and erection drawings*, or approve such deviation, without the written approval of the *owner's designated representatives for design and construction*.

SECTION 9. CONTRACTS

9.1. Types of Contracts

- 9.1.1. For contracts that stipulate a lump sum price, the work that is required to be performed by the *fabricator* and the *erector* shall be completely defined in the *contract documents*.
- 9.1.2. For contracts that stipulate a price per pound, the scope of work that is required to be performed by the *fabricator* and the *erector*, the type of materials, the character of fabrication and the conditions of erection shall be based upon the *contract documents*, which shall be representative of the work to be performed.
- 9.1.3. For contracts that stipulate a price per item, the work that is required to be performed by the *fabricator* and the *erector* shall be based upon the quantity and the character of the items that are described in the *contract documents*.
- 9.1.4. For contracts that stipulate unit prices for various categories of *structural steel*, the scope of work that is required to be performed by the *fabricator* and the *erector* shall be based upon the quantity, character and complexity of the items in each category as described in the *contract documents*, and shall also be representative of the work to be performed in each category.

9.2. Calculation of Weights

Unless otherwise specified in the contract, for contracts stipulating a price per pound for fabricated *structural steel* that is delivered and/or erected, the quantities of materials for payment shall be determined by the calculation of the gross weight of materials as shown in the *shop drawings*.

Commentary:

The standard procedure for calculation of weights that is described in this Code meets the need for a universally acceptable system for defining “pay weights” in contracts based upon the weight of delivered and/or erected materials. These procedures permits the *owner* to easily and accurately evaluate price-per-pound proposals from potential suppliers and enables all parties to a contract to have a clear and common understanding of the basis for payment.

The procedure in this Code affords a simple, readily understood method of calculation that will produce pay weights that are consistent throughout the industry and that may be easily verified by the *owner*. While this procedure does not produce actual weights, it can be used by purchasers and suppliers to define a widely accepted basis for bidding and contracting for *structural steel*. However, any other system can be used as the basis for a contractual agreement. When other systems are used, both the supplier and the purchaser should clearly understand how the alternative procedure is handled.

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- 9.2.1. The unit weight of steel shall be taken as 490 lb/ft³ [7 850 kg/m³]. The unit weight of other materials shall be in accordance with the manufacturer's published data for the specific product.
- 9.2.2. The weights of *standard structural shapes*, plates and bars shall be calculated on the basis of *shop drawings* that show the actual quantities and dimensions of material to be fabricated, as follows:
- (a) The weights of all *standard structural shapes* shall be calculated using the nominal weight per ft [mass per m] and the detailed overall length.
 - (b) The weights of plates and bars shall be calculated using the detailed overall rectangular dimensions.
 - (c) When parts can be economically cut in multiples from material of larger dimensions, the weight shall be calculated on the basis of the theoretical rectangular dimensions of the material from which the parts are cut.
 - (d) When parts are cut from *standard structural shapes*, leaving a non-standard section that is not useable on the same contract, the weight shall be calculated using the nominal weight per ft [mass per m] and the overall length of the *standard structural shapes* from which the parts are cut.
 - (e) Deductions shall not be made for material that is removed for cuts, copes, clips, blocks, drilling, punching, boring, slot milling, planing or weld joint preparation.
- 9.2.3. The items for which weights are shown in tables in the *AISC Steel Construction Manual* shall be calculated on the basis of the tabulated weights shown therein.
- 9.2.4. The weights of items that are not shown in tables in the *AISC Steel Construction Manual* shall be taken from the manufacturer's catalog and the manufacturer's shipping weight shall be used.

Commentary:

Many items that are weighed for payment purposes are not tabulated with weights in the *AISC Steel Construction Manual*. These include, but are not limited to, *anchor rods*, clevises, turnbuckles, sleeve nuts, recessed-pin nuts, cotter pins and similar devices.

- 9.2.5. The weights of shop or field weld metal and protective coatings shall not be included in the calculated weight for the purposes of payment.

9.3. Revisions to the Contract Documents

Revisions to the *contract documents* shall be confirmed by change order or extra work order. Unless otherwise noted, the issuance of a *revision* to the *contract documents* shall constitute authorization by the *owner* that the *revision* is

released for construction. The contract price and schedule shall be adjusted in accordance with Sections 9.4 and 9.5.

9.4. Contract Price Adjustment

- 9.4.1. When the scope of work and responsibilities of the *fabricator* and the *erector* are changed from those previously established in the *contract documents*, an appropriate modification of the contract price shall be made. In computing the contract price adjustment, the *fabricator* and the *erector* shall consider the quantity of work that is added or deleted, the modifications in the character of the work and the timeliness of the change with respect to the status of material ordering, detailing, fabrication and erection operations.

Commentary:

The fabrication and erection of *structural steel* is a dynamic process. Typically, material is being acquired at the same time that the *shop* and *erection drawings* are being prepared. Additionally, the fabrication shop will normally fabricate pieces in the order that the *structural steel* is being shipped and erected.

Items that are revised or placed on hold generally upset these relationships and can be very disruptive to the detailing, fabricating and erecting processes. The provisions in Sections 3.5, 4.4.2 and 9.3 are intended to minimize these disruptions so as to allow work to continue. Accordingly, it is required in this Code that the reviewer of requests for contract price adjustments recognize this and allow compensation to the *fabricator* and the *erector* for these inefficiencies and for the materials that are purchased and the detailing, fabrication and erection that has been performed, when affected by the change.

- 9.4.2. Requests for contract price adjustments shall be presented by the *fabricator* and/or the *erector* in a timely manner and shall be accompanied by a description of the change that is sufficient to permit evaluation and timely approval by the *owner*.
- 9.4.3. Price-per-pound and price-per-item contracts shall provide for additions or deletions to the quantity of work that are made prior to the time the work is *released for construction*. When changes are made to the character of the work at any time, or when additions and/or deletions are made to the quantity of the work after it is released for detailing, fabrication or erection, the contract price shall be equitably adjusted.

9.5. Scheduling

- 9.5.1. The contract schedule shall state when the *design drawings* will be *released for construction*, if the *design drawings* are not available at the time of bidding, and when the job site, foundations, piers and abutments will be ready, free from

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obstructions and accessible to the *erector*, so that erection can start at the designated time and continue without interference or delay caused by the *owner's designated representative for construction* or other trades.

9.5.2. The *fabricator* and the *erector* shall advise the *owner's designated representatives for design and construction*, in a timely manner, of the effect any *revision* has on the contract schedule.

9.5.3. If the fabrication or erection is significantly delayed due to *revisions* to the requirements of the contract, or for other reasons that are the responsibility of others, the *fabricator* and/or *erector* shall be compensated for the additional costs incurred.

9.6. Terms of Payment

The *fabricator* shall be paid for *mill materials* and fabricated product that is stored off the job site. Other terms of payment for the contract shall be outlined in the *contract documents*.

Commentary:

These terms include such items as progress payments for material, fabrication, erection, retainage, performance and payment bonds and final payment. If a performance or payment bond, paid for by the *owner*, is required by contract, no retainage shall be required.

SECTION 10. ARCHITECTURALLY EXPOSED STRUCTURAL STEEL

10.1. General Requirements

When members are specifically designated as *architecturally exposed structural steel* or AESS in the *contract documents*, the requirements in Sections 1 through 9 shall apply as modified in Section 10. AESS members or components shall be fabricated and erected with the care and dimensional tolerances that are stipulated in Sections 10.2 through 10.4. The following additional information shall be provided in the *contract documents* when AESS is specified:

- (a) Specific identification of members or components that are AESS;
- (b) Fabrication and/or erection tolerances that are to be more restrictive than provided for in this Section, if any; and,
- (c) Requirements, if any, of a mock-up panel or components for inspection and acceptance standards prior to the start of fabrication.

Commentary:

This Section of this Code defines additional requirements that apply only to members that are specifically designated by the *contract documents* as *architecturally exposed structural steel* (AESS). The common use of exposed *structural steel* as a medium of architectural expression has given rise to a demand for closer dimensional tolerances and smoother finished surfaces than required for ordinary *structural steel* framing.

This Section of this Code establishes standards for these requirements that take into account both the desired finished appearance and the abilities of the fabrication shop to produce the desired product. It should be pointed out that the term *architecturally exposed structural steel*, as covered in this Section, must be specified in the *contract documents* if the *fabricator* is required to meet the fabricating standards in this Section, and applies only to that portion of the *structural steel* so identified.

AESS requirements usually involve significant cost in excess of that for *structural steel* that is fabricated in the absence of an AESS requirement. Therefore, the designation AESS should be applied rationally, with visual acceptance criteria that are appropriate for the distance at which the exposed element will be viewed in the completed structure. In order to avoid misunderstandings and to hold costs to a minimum, only those *structural steel* surfaces and *connections* that will remain exposed and subject to normal view by pedestrians or occupants of the completed structure should be designated as AESS.

10.2. Fabrication

- 10.2.1. The permissible tolerances for out-of-square or out-of-parallel, depth, width and symmetry of rolled shapes shall be as specified in ASTM A6/A6M. Unless otherwise specified in the *contract documents*, the exact matching of abutting

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cross-sectional configurations shall not be necessary. The as-fabricated straightness tolerances of members shall be one-half of the standard camber and sweep tolerances in ASTM A6/A6M.

- 10.2.2. The tolerances on overall profile dimensions of members that are built-up from a series of *standard structural shapes*, plates and/or bars by welding shall be taken as the accumulation of the variations that are permitted for the component parts in ASTM A6/A6M. The as-fabricated straightness tolerances for the member as a whole shall be one-half the standard camber and sweep tolerances for rolled shapes in ASTM A6/A6M.
- 10.2.3. Unless specific visual acceptance criteria for *weld show-through* are specified in the *contract documents*, the members or components shall be acceptable as produced.

Commentary:

Weld show-through generally is a function of weld size and material thickness.

- 10.2.4. All copes, miters and cuts in surfaces that are exposed to view shall be made with uniform gaps of $\frac{1}{8}$ in. [3 mm] if shown as open joints, or in reasonable contact if shown without gap.
- 10.2.5. All welds that are exposed to view shall be visually acceptable if they meet the requirements in AWS D1.1, except all groove welds in butt joints and outside corner joints and plug welds that are exposed to view shall not project more than $\frac{1}{16}$ in. [2 mm] above the exposed surface. Finishing or grinding of welds shall not be necessary, unless such treatment is required to provide for clearances or fit of other components.
- 10.2.6. Erection marks or other painted marks shall not be made on those surfaces of weathering steel AESS members that are to be exposed in the completed structure. Unless otherwise specified in the *contract documents*, the *fabricator* shall clean weathering steel AESS members to meet the requirements of SSPC-SP6.
- 10.2.7. Stamped or raised manufacturer's identification marks shall not be filled, ground or otherwise removed.
- 10.2.8. Seams of hollow structural sections shall be acceptable as produced. Seams shall be oriented away from view or as directed in the *contract documents*.

10.3. Delivery of Materials

The *fabricator* shall use special care to avoid bending, twisting or otherwise distorting the *structural steel*.

10.4. Erection

- 10.4.1. The *erector* shall use special care in unloading, handling and erecting the *structural steel* to avoid marking or distorting the *structural steel*. Care shall also be taken to minimize damage to any shop paint. If temporary braces or erection clips are used, care shall be taken to avoid the creation of unsightly surfaces upon removal. Tack welds shall be ground smooth and holes shall be filled with weld metal or body solder and smoothed by grinding or filing. The *erector* shall plan and execute all operations in such a manner that the close fit and neat appearance of the structure will not be impaired.
- 10.4.2. Unless otherwise specified in the *contract documents*, AESS members and components shall be plumbed, leveled and aligned to a tolerance that is one-half that permitted for non-AESS members. To accommodate these erection tolerances for AESS, the *owner's designated representative for design* shall specify *connections* between AESS members and non-AESS members, masonry, concrete and other supports as *adjustable items*, in order to provide the *erector* with means for adjustment.
- 10.4.3. When AESS is backed with concrete, the *owner's designated representative for construction* shall provide sufficient shores, ties and strongbacks to prevent sagging, bulging or similar deformation of the AESS members due to the weight and pressure of the wet concrete.

APPENDIX A. DIGITAL BUILDING PRODUCT MODELS

The provisions in this Appendix shall apply when the *contract documents* indicate that a three-dimensional digital building product model replaces contract drawings and is to be used as the primary means of designing, representing, and exchanging *structural steel* data for the project. When this is the case, all references to the *design drawings* in this Code shall instead apply to the design model, and all references to the *shop and erection drawings* in the Code shall instead apply to the manufacturing model. The CIS/2 *Logical Product Model* shall be used as the building product model for *structural steel*.

If the primary means of project communication reverts from a model-based system to a paper-based system, the requirements in this Code other than in this Appendix shall apply.

Commentary:

Current technology permits the transfer of three-dimensional digital building product model data among the design and construction teams for a project. Over the last several years, designers and *fabricators* have used CIS/2 as a standard format in the exchange of building product models representing the steel structure. This Appendix facilitates the use of this technology in the design and construction of steel structures, and eliminates any interpretation of this Code that might be construed to prohibit or inhibit the use of this technology. While the technology is new and there is no long-established standard of practice, it is the intent in this Appendix to provide guidance for its use.

APPENDIX A. GLOSSARY

Add the following definitions to the Glossary:

Building Product Model. A digital information structure of the objects making up a building, capturing the form, function, behavior and relations of the parts and assemblies within one or more building systems. A building product model can be implemented in multiple ways, including as an ASCII file or as a database. The data in the model is created, manipulated, evaluated, reviewed and presented using computer-based design, engineering, and manufacturing applications. Traditional two-dimensional drawings may be one of many reports generated by the building product model (see Eastman, Charles M.: *Building Product Models: Computer Environments Supporting Design and Construction*; 1999 by CRC Press).

CIS/2 (CIMSteel Integration Standards/Version 2). The specification providing the building product model for *structural steel* and format for electronic data interchange (EDI) among software applications dealing with steel design, analysis, and manufacturing.

Data Management Conformance (DMC). The capability of the CIMSteel model to include optional data entities for managing and tracking additions, deletions and

modifications to a model, including who made the change and when the change was made for all data changes.

Logical Product Model (LPM). The CIS/2 building product model, which supports the engineering of low-, medium- and high-rise construction, in domestic, commercial and industrial contexts. All elements of the structure are covered, including main and secondary framing and *connections*. The components used can be of any variety of structural shape or element.

The LPM addresses the exchange of data between *structural steel* applications. It is meant to support a heterogeneous set of applications over a fairly broad portion of the steel lifecycle. It is organized around three different sub-models: the analysis model (data represented in structural analysis), the design model (data represented in frame design layout) and the manufacturing model (data represented in detailing for fabrication).

A1.2. Referenced Specifications, Codes and Standards

Add the following reference to Section 1.2:

CIMSteel Integration Standards Release 2: Second Edition P265: CIS/2.1: Volumes 1 through 4.

A3. DESIGN DRAWINGS AND SPECIFICATIONS

In addition to the requirements in Section 3, the following requirements shall apply to the design model:

A3.1. Design Model

The design model shall:

- (a) Consist of *data management conformance* classes.
- (b) Contain analysis model data so as to include load calculations as specified in the *contract documents*.
- (c) Include entities that fully define each steel element and the extent of detailing of each element, as would be recorded on equivalent set of *structural steel design drawings*.
- (d) Include all steel elements identified in the *contract documents*, as well as any other entities required for strength and stability of the completely erected structure.
- (e) Govern over all other forms of information, including drawings, sketches, etc.

A3.2. LPM Administration

The *owner* shall designate an administrator for the LPM, who shall:

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- (a) Control the LPM by providing appropriate access privileges (read, write, etc) to all relevant parties.
- (b) Maintain the security of the LPM.
- (c) Guard against data loss of the LPM.
- (d) Be responsible for updates and *revisions* to the LPM as they occur.
- (e) Inform all appropriate parties as to changes to the LPM.

Commentary:

When a project is designed and constructed using EDI, it is imperative that an individual entity on the team be responsible for maintaining the LPM. This is to assure protection of data through proper backup, storage and security and to provide coordination of the flow of information to all team members when information is added to the model. Team members exchange information to revise the model with this administrator. The administrator will validate all changes to the LPM. This is to assure proper tracking and control of *revisions*.

This administrator can be one of the design team members such as an *architect, structural engineer of record*, or a separate entity on the design team serving this purpose. The administrator can also be the *steel detailer* or a separate entity on the construction team serving this purpose.

A4.3. Fabricator Responsibility

In addition to the requirements in Section 4.3, the following requirements shall apply:

When the design model is used to develop the manufacturing model the *fabricator* shall accept the information under the following conditions:

- (a) When the design information is to be conveyed to the *fabricator* by way of the design model, in the event of a conflict between the model and the *design drawings*, the design model will control.
- (b) The ownership of the information added to the LPM in the manufacturing model should be defined in the *contract documents*. In the absence of terms for ownership regarding the information added by the *fabricator* to the LPM in the *contract documents*, the ownership will belong to the *fabricator*.
- (c) During the development of the manufacturing model, as member locations are adjusted to convert the modeled parts from a design model, these relocations will only be done with the approval of the *owner's designated representative for design*.
- (d) The *fabricator* and *erector* shall accept the use of the LPM and design model under the same conditions as set forth in Section 4.3 with regard to CAD files, except as modified in Section A4.3 above.

A4.4. Approval

In addition to the requirements in Section 4.4, the following requirements shall apply:

When the approval of the detailed material is to be done by the use of the manufacturing model the version of the submitted model shall be identified. The approver shall annotate the manufacturing model with approval comments attached to the individual elements as specified in the CIS/2 standard. As directed by the approval comment the *fabricator* will reissue the manufacturing model for re-review and the version of the model submitted will be tracked as previously defined.

Commentary:

Approval of the manufacturing model by the *owner's designated representative for design* can replace the approval of actual *shop and erection drawings*. For this method to be effective, a system must be in place to record review, approval, correction and final release of the manufacturing model for fabrication of *structural steel*. The versions of the model must be tracked, and review comments and approvals permanently attached to the versions of the model to the same extent as such data is maintained with conventional hard copy approvals. The CIS/2 standard provides this level of tracking.



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