

D906.07 CONSTRUCTION

D906.07.01 Fabrication

Subsection 906.07.01 of OPSS 906 is amended by the addition of the following clause:

D906.07.01.08 Fabrication Outside of Canada and USA

For fabrication in a facility outside of Canada and USA, the following additional requirements shall apply:

- a) All structural steel shall be shipped to a facility in Canada certified according to CSA W47.1, Division 1 or 2 for quality verification.
- b) Shipped structural steel shall be accompanied by reports containing the results of all inspections and testing performed according to the Quality Control subsection at the fabrication facility outside of Canada and USA.
- c) Shipped structural steel shall not be galvanized or coated and shall be in a condition that permits re-inspection and testing.
- d) An independent welding inspection company shall be hired to perform quality verification of shipped structural steel according to the Quality Control subsection.. All costs incurred to perform re-inspection and testing at a Canadian facility shall be at no additional cost to the Owner.
- e) Acceptance of structural steel shall be based on satisfactory re-inspection and testing of all components according to the Quality Control subsection. The reports accompanying the shipment shall also be reviewed by the welding inspector. Inspection, testing, and reporting shall be done on each shipment received.
- f) The welding inspector shall ensure that traceability of all structural steel has been maintained by:
 - i. Correlation of heat numbers on structural steel to the mill test certificates.
 - ii. Review of mill test certificates, verifying that materials used is as specified in the Contract Documents.
- g) If the re-inspection or testing performed on structural steel is not as specified in the Contract Documents, all structural steel is rejectable.
- h) A Request to Proceed shall be submitted to the Contract Administrator upon completion of the re-inspection and testing prior to shipping from the Canadian facility. The structural steel shall not be delivered from the facility until the Contract Administrator has received the Request to Proceed and issued a Notice to Proceed.

D906.07.02 Delivery

Subsection 906.07.02 of OPSS 906 is removed in its entirety and replaced with the following:

D906.07.02 Delivery, Handling and Storage

A delivery schedule shall be provided to the Contract Administrator not less than five Days prior to shipping.

Delivery shall include loading of the members, transportation, unloading, storage at the storage site and temporary works for access.

Structural steel shall be loaded for shipping in such a manner that it can be transported and unloaded at its destination without being excessively stressed, deformed, or otherwise damaged.

Plate girders shall be transported with their webs in a vertical plane. When girders cannot be shipped with their webs in the vertical plane, static and dynamic forces during handling, transportation, and storage shall be determined using a dynamic load allowance of 100%. Computed stresses shall be according to CSA-S6, Clause 10.10 and the maximum cyclic stress range shall not exceed the constant amplitude fatigue threshold for the appropriate fatigue categories specified in CSA-S6, Table 10.4. All the calculations and associated sketches, including reasons why the girders cannot be shipped with the webs in the vertical plane, shall be submitted by the Contractor to the Contract Administrator for approval seven Days prior to shipping. The calculations and sketches shall be sealed and signed by an Engineer.

Structural steel, when stored, shall be stored in a manner to avoid excessive stress deformation or other damage. Plates and sections shall be stored in a way that steel surfaces are prevented from entrapping moisture or dirt or being continually wet. Structural steel shall be protected from contaminants in a way that still permits alternate wetting and drying cycles. Storage shall be such to enable free drainage and avoid moisture pockets or condensation accumulation.

Advertising by means of removable signing is permitted on elements only while in transit to the specified site. Any permanent markings on a surface that would be visible after installation shall not be permitted.

D906.07.03 Erection

Subsection 906.07.03 of OPSS 906 is amended by the addition of the following clause:

D906.07.03.07 Atmospheric Corrosion Resistant Steel Erection

Special care shall be used when unloading, handling and erecting ACR steel to avoid marking or distorting the steelwork. All slings shall be nylon strap or chains with softeners. Care shall be taken to minimize damage to the developing patina.

Plates and fasteners shall be checked for proper fit-up. If crevices occur in uncoated areas and when required by the Contract Administrator, at least three coats of a compatible sealant shall be brush applied, or more coats according to the sealant manufacturer's instructions.

D906.07.08 Inspection after Installation of the Structural Steel

Subsection 906.07.08 of OPSS 906 is amended by the addition of the following:

D906.07.08.01 Inspection after Installation of Atmospheric Corrosion Resistant Steel

All installed Atmospheric Corrosion Resistant (ACR) steel components shall be completely free of mill scale, rust, coating, oxides, corrosion products, oil, grease, dust, dirt, wax-based crayon marks and other foreign matter.

The appearance of components shall be generally uniform in colour and texture, except for slight streaks or discolourations, when viewed from a distance of 15 m.

D906.10 BASIS OF PAYMENT

D906.10.01 Fabrication of Structural Steel - Item

Payment at the Contract price for the above tender item shall be full compensation for all labour, Equipment, and Material to do the work.

Structural steel that requires no further fabrication and that is stored at the fabricator's premises in Ontario or some other location in Ontario away from the Working Area shall be eligible to be paid for when the Contractor obtains a lease from the property owner that names the Owner as the tenant. The Owner shall provide the form of lease for this purpose that specifies payment of \$1.00 for the term of the lease. The Contractor shall retain full responsibility for the Work.

WARRANT: Always with OPSS 906, Structural Steel for Bridges.