

**G12****ISOLATED STRUCTURAL METAL MEMBERS**

To be read with Preliminaries/ General conditions.

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**FABRICATION OF MEMBERS**

- Steel sections: To BS 4-1, BS EN 10055, BS EN 10056 or BS EN 10210, as appropriate.

- Steel: To BS EN 10025, grade S275.  
- Surface condition: Free from heavy pitting and rust, burrs, sharp edges and flame cutting dross.

- Cuts and holes: Accurate and neat.  
- Welding: Metal arc method to BS EN 1011-2.  
- Welded joints: Fully fused, with mechanical properties not less than those of the parent metal.

- Site welding: Obtain approval.

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**SHOP PRIMING**

- Preparation: Loose scale and rust, burrs, fins, sharp edges and weld spatter removed; crevices cleaned out; surfaces thoroughly degreased, rinsed with clean water and allowed to dry.

- Primer: Zinc phosphate modified alkyd.

- Application: One full coat within 8 hours of cleaning surfaces.

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**INSTALLATION**

- Accuracy: Members positioned true to line and level using, if necessary, steel packs of sufficient area to allow full transfer of loads to bearing surfaces.

- Fixing: Use washers under bolt heads and nuts.  
- Tapered washers: Provide under bolt heads and nuts bearing on sloping surfaces. Match taper to slope angle and align correctly.