

711-B-305 SHOP CLEANING AND STORAGE OF WEATHERING STEEL

(Adopted 07-19-17)

The Standard Specifications are revised as follows:

SECTION 711, BEGIN LINE 766, DELETE AND INSERT AS FOLLOWS:

711.48 Shop Cleaning and Storage of Weathering Steel

The fabricator shall protect bare steel sections and sub-assemblies so as not to damage or stain them. The use of paints, crayons, or other materials used for identification purposes shall be avoided on bare steel sections. Storage shall be such to enable free drainage to avoid moisture pockets.

A sound uniform surface for the formation of a protective oxide coating on *all* surfaces shall be prepared as follows.

(a) Hot Rolled Products

~~These products shall include structural shapes, plates, hot rolled sheets, and hot rolled strip.~~ The entire length and perimeter of each fascia beam or girder shall be cleaned in accordance with 619.08(c). The entire length and perimeter of each interior beam or girder shall be cleaned in accordance with 619.08(d). *Unless otherwise indicated, all components such as, but not limited to, diaphragms, cross frames, stiffeners, bearing assemblies, and sway bracing that are permanently incorporated into the structure shall be cleaned in accordance with 619.08(d).* Contamination from grease, oil, or shop marking shall be avoided. If such contamination is unavoidable, such surfaces shall be cleaned in accordance with 619.08(b).

(b) Welded Area

All exposed welds on fascia surfaces shall be prepared by means of power grinding *in accordance with 619.08(h)* or blast cleaning in accordance with 619.08(d) to remove welding flux, slag, scale, or spatter.
