

The use of acid for cleaning will not be permitted.

The QCPS shall provide a cover letter and specified check point data documenting QCPS acceptance that shop cleaning has been performed per specification.

863.31 Method of Measurement. Structural steel shall be measured by either lump sum or the plan weight of steel, whichever is stipulated in the contract.

If the quantity of structural steel to be paid is the plan weight of steel, the actual number of kilograms (pounds) shall be computed from the accepted shop drawing by using a unit weight of 7850 kg/m³ (490 pounds per cubic foot). Waste material, such as is removed by burning, cutting, machining, etc., shall not be considered as pay weight except for that material removed in the edge preparation for groove welds. Material removed to form bolt holes shall be included in the pay quantity provided that only those portions of the bolts projecting beyond the holes are included for payment. Only bolts and materials that remain in place shall be included. Any thickness and weight of members in excess of that called for on the plans (due to overweight or other cause) shall not be included in determining the weight to be paid for, unless an increase in size of a member has been requested by the OSE.

Pay weight for steel castings shall be based on scale weights of the finished pieces prior to painting. Castings shall be weighed by the Fabricator, in the presence of the inspector, and weights recorded on shop bills.

The weight of paint coat, galvanized coat, run-off bars, and weld metal in all field or shop butt welds shall not be included. Fillet welds may be included if completely itemized.

The weight of other metals and preformed bearing pads not separately itemized are to be included with the structural steel. The following unit weights in kg/m³ (pounds per cubic foot) shall be used: Cast steel and deposited weld metal 7850 (490), cast iron 7210 (450), phosphor or leaded bronze 8810 (550), lead 11370 (710). The weight of preformed bearing pads shall be calculated as an equivalent volume of lead.

The number of welded stud shear connectors to be paid for shall be the actual number installed and accepted.

863.32 Basis of Payment. Payment will be made at contract prices for:

863	Kilogram (pound)	Structural steel members, level two fabrication
863	Kilogram (pound)	Structural steel members, level three fabrication
863	Kilogram (pound)	Structural Steel Members, level four fabrication
863	Kilogram (pound)	Structural steel members, level five fabrication
863	Kilogram (pound)	Structural steel members, fracture critical, level six fabrication
863	Each	Welded stud shear connectors

Item	Unit	Description
863	Lump sum	Structural steel members, miscellaneous level fabrication
863	Lump sum	Structural steel members, level one fabrication
863	Lump sum	Structural steel members, level two fabrication
863	Lump sum	Structural steel members, level three fabrication
863	Lump sum	Structural steel members, level four fabrication
863	Lump sum	Structural steel members, level five fabrication
863	Lump sum	Structural steel members, fracture critical, level six fabrication
863	Kilogram (pound)	Structural steel members, miscellaneous level fabrication
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