Ergon Energy Corporation Limited

Specification for Fabrication of Steelwork for Pole Structures

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# Specification for Fabrication of Steelwork for Pole Structures

## Contents

1. Purpose and Scope........................................................................................................... 1
2. References....................................................................................................................... 1
   2.1 Ergon Energy controlled documents ..................................................................... 1
   2.2 Other sources ....................................................................................................... 1
3. Acronyms, and Abbreviations.......................................................................................... 1
   3.1 Acronyms and Abbreviations .............................................................................. 1
4. Security.......................................................................................................................... 1
5. Safety, Environmental and Ergonomic Considerations.................................................... 1
6. General.......................................................................................................................... 2
7. Materials and Standards............................................................................................... 2
8. Fabrication...................................................................................................................... 3
   8.1 Cutting, Drilling, Deformation and Punching of Members ................................... 3
   8.2 Erection Marks .................................................................................................... 3
   8.3 Repairs................................................................................................................ 3
9. Welding.......................................................................................................................... 3
   9.1 Welding Personnel .............................................................................................. 3
   9.2 Welding and Welding Procedures ....................................................................... 3
   9.3 Finishing.............................................................................................................. 4
10. Galvanising .................................................................................................................... 4
11. Tests and Inspections at Contractor’s Works ................................................................. 5
   11.1 Inspection............................................................................................................ 5
   11.2 Material Tests .................................................................................................. 5
   11.3 Galvanising Tests ............................................................................................ 5
   11.4 Welding Tests .................................................................................................. 6
   11.5 Delivery and Unloading...................................................................................... 6
1. Purpose and Scope

This specification covers the supply of materials, including fasteners and accessories, fabrication, galvanising, assembly as required and delivery to the site of all steelwork.

The Contractor shall fabricate, galvanise and deliver all steelwork in accordance with AS 4100 and associated Standards.

All costs related to this Section of the Specification including any costs of testing and inspection shall be included in the Schedule of Rates Items for Structure Supply and Delivery.

2. References

2.1 Ergon Energy controlled documents

Nil

2.2 Other sources

AS 1110 – ISO metric hexagon bolts and screws – Product grades A and B
AS 1111 - ISO metric hexagon bolts and screws – Product grade C
AS 1112 - ISO metric hexagon nuts
AS 1214 – Hot-dip galvanised coatings on threaded fasteners (ISO metric coarse thread series)
AS 1252 – High strength steel bolts with associated nuts and washers for structural engineering
AS 1554 – Structural steel welding
AS 1559 - Hot-dip galvanised steel bolts with associated nuts and washers for tower construction
AS 3678 – Structural steel - Hot-rolled plates, floorplates and slabs
AS 3679.1 – Structural steel – Hot-rolled bars and sections
AS 4100 – Steel structures
AS/NZS 4680 – Hot-dip galvanised (zinc) coatings on fabricated ferrous articles

3. Acronyms, and Abbreviations

3.1 Acronyms and Abbreviations

The following acronyms appear in this standard:

AS Australian Standard
AS/NZS Australian/New Zealand Standard
GP General Purpose weld
SP Structural Purpose weld
ILAC International Laboratory Accreditation Co-operation

4. Security

Nil

5. Safety, Environmental and Ergonomic Considerations

As per Ergon Energy’s Safety, Environmental & Ergonomic Policies.
6. General

All fabricated components shall be supplied in pieces to be bolt assembled.

All components shall be fabricated using jigs and machines such that close tolerances are maintained and burred and sharp edges are avoided. Components shall be free from weld spatter, weld slag and galvanising drips.

If particular steelwork member sizes specified in the superstructure of the Principal’s typical designs prove to be inadequate under load testing or are unavailable for any reason beyond the Contractor’s control, the Superintendent may approve the substitution of an alternative section. In this case, the Principal will compensate the Contractor for any steelwork cost increase that may result, at the appropriate rates in the “Schedule of Rates”.

If the Contractor desires to use substitute members or steel sections held in stock rather than those nominated in his own design, or desires to utilise steel sections held in stock rather than those specified or required by load testing in the Principal’s design, then upon request the Superintendent may approve the substitution. In these cases however, the Principal will not compensate the Contractor for any steelwork cost increase that may result.

7. Materials and Standards

Unless otherwise nominated on the drawings, components shall be fabricated from mild steel (Grade 300 or 350). Steel shall be of a quality not inferior to that specified in the relevant Australian Standards. The steel shall be in all cases free from blisters, scale, laminations or any other defects.

All Ergon designs are produced in accordance with AS 4100, as such it is a requirement that where the use of imported steel is proposed, the supplier shall obtain test certificates from the mill, certifying that the steel being used complies with all the requirements of the relevant standard (from the list below). The test certificates shall be verified by an independent laboratory accredited by ILAC.

Bolts shall be supplied in accordance with AS 1111 for grade 4.6, AS 1559 for grade 5.8 and AS 1110 for grade 8.8 bolts. Grade 8.8 crossarm splice bolts shall be to AS 1252. They shall be fitted with heavy duty galvanised spring washers.

The latest editions of the following Australian Standards shall apply to the fabrication, galvanising, repair and alteration, where applicable, of all steelwork:

<table>
<thead>
<tr>
<th>Standard</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>AS 1110</td>
<td>ISO Metric Hexagon Bolts and Screws – Product Grades A &amp; B</td>
</tr>
<tr>
<td>AS 1111</td>
<td>ISO Metric Hexagon Commercial Bolts &amp; Screws</td>
</tr>
<tr>
<td>AS 1112</td>
<td>ISO Metric Hexagon Nuts</td>
</tr>
<tr>
<td>AS 1214</td>
<td>Hot Dip Galvanised Coatings on Threaded Fasteners</td>
</tr>
<tr>
<td>AS/NZS 1252</td>
<td>High Strength Steel Bolts with Associated Nuts and Washers for Structural Engineering</td>
</tr>
<tr>
<td>AS/NZS 1554</td>
<td>Welding of Steel Structures</td>
</tr>
<tr>
<td>AS/NZS 1559</td>
<td>Fasteners - Bolts, Nuts and Washers for Tower Construction</td>
</tr>
<tr>
<td>AS/NZS1594</td>
<td>Hot Rolled Steel Flat Products</td>
</tr>
<tr>
<td>AS 1968</td>
<td>Helical Spring Lock Washers (Metric Series)</td>
</tr>
<tr>
<td>AS/NZS 3678</td>
<td>Hot Rolled Structural Steel Plates, Floorplates and Slabs</td>
</tr>
<tr>
<td>AS/NZS 3679.1</td>
<td>Hot Rolled Structural Steel Bars and Sections</td>
</tr>
<tr>
<td>AS 4100</td>
<td>Steel Structures</td>
</tr>
<tr>
<td>AS/NZ 4680</td>
<td>Hot Dipped Galvanised (zinc) Coatings on Fabricated Ferrous Articles</td>
</tr>
</tbody>
</table>
8. Fabrication

8.1 Cutting, Drilling, Deformation and Punching of Members
All members shall be carefully cut and holes accurately located so that when members are in position the holes will be truly opposite each other before being bolted.

Plate items shall not be sheared or hand flame cut.

Holes in material having a thickness exceeding 15 mm or exceeding the diameter of the holes shall be drilled, other holes may be punched.

The diameter of the hole, measured before galvanising, shall not exceed that of the bolt by more than 2.0 mm except where otherwise specified. In addition, the diameter of the die used in the punching machine shall exceed the diameter of the punch by the minimum practical amount so as to avoid excessive hole taper and consequent heavy bearing stress on the bolt shank. In no case shall the punch die exceed the punch diameter by more than 12.5%.

Deforming of members by swaging, or by opening or closing angle legs shall only be permitted where this detail has no detrimental effect on the performance of the structural element.

All plates up to 12 mm in thickness may be bent cold. Plates greater than 12 mm may be bent cold provided the angle of set does not exceed 15°.

8.2 Erection Marks
Before galvanising all members shall be stamped with an alphanumeric mark number to identify the member. This marking shall be carried out in such a manner as to enable it to be clearly read after galvanising.

8.3 Repairs
Repair of out of tolerance fabricated members or where members do not comply with this Specification or AS 4100 shall only be permitted if in the opinion of the Superintendent

- the member, after such repairs, is equivalent in terms of strength, corrosion resistance and appearance to that which it would have been if fabricated as new in accordance with the Specification, and
- the repaired member does not impair the Principal’s maintenance procedures.

9. Welding

9.1 Welding Personnel
All welding shall be carried out by qualified welders experienced in the type of work covered by this Specification and under the supervision of the Contractor’s Welding Supervisors satisfying the requirements of AS 1554 Part 1.

The Superintendent reserves the right to request welder qualification tests at any time or withdraw approval of any welder whose work, in the opinion of the Superintendent, is unsatisfactory. All costs of welder qualification tests and re-tests shall be at the Contractor’s expense.

9.2 Welding and Welding Procedures
Welding procedure shall be in accordance with AS 1554 Part 1.
The Contractor shall if requested submit to the Superintendent for approval at least 14 days prior to
the commencement of welding, full details of the position, edge preparation, welding procedure
and welding consumables which he proposes to use for any welds to be adopted.

The Superintendent reserves the right to withdraw approval of any welding procedure which, in the
opinion of the Superintendent, does not provide satisfactory welds in practice. The Contractor shall
submit alternative welding procedures for approval. All costs of delays and testing shall be at the
Contractor’s expense.

The Contractor shall carry out all welding in accordance with Section 14.3.4 of AS 4100 and
AS 1554 Part 1. All welds shall be continuous unless otherwise shown on the drawings.

Butt welds shall be full section, complete penetration welds unless otherwise shown on the
drawings. All welds shall be of a configuration which allows full coverage by radiography and/or
ultrasonic testing. Where joints are welded from both sides, the second side to be welded shall be
chipped, ground or flame or arc gouged to sound metal and of a shape which will ensure proper
fusion and penetration.

The Contractor shall use a suitable welding sequence on seam welds to minimise heat inputs and
shall take suitable measures to keep torsional and other distortions of welded box section
members and other steelwork within specified limits.

The Contractor shall not butt weld members to produce longer lengths except where specified on
the drawings or approved by the Superintendent.

Repair of welds shall be carried out in accordance with Section 5.8 of AS 1554 Part 1.

9.3 Finishing
The surface of all welds shall be smooth and free from sharp contour changes.

The Contractor shall remove all burrs and sharp edges from all steelwork before galvanising.

Welded end plates and contacting surfaces of parts to be bolted shall be free from distortion which
would prevent the connecting faces from being in full contact when bolted.

10. Galvanising

All ferrous items shall be hot dip galvanised in accordance with AS/NZS 4680 after all fabrication is
completed. Bolts and nuts shall be hot dip galvanised in accordance with AS 1214.

The zinc coating shall be adherent, smooth, continuous and thorough, free from lumps, blisters,
gritty areas, uncoated spots, acid and black spots, dross and flux or other defects. The members
shall not be supported whilst in the galvanising process through the conductor and earthwire fitting
attachment holes.

Particular care shall be taken in the handling and storage of galvanised steelwork to minimise
damage and avoid the occurrence of “white rust”. Reference should be made to the provisions of
Appendix F of AS/NZS 4680.

Galvanised sections shall be passivated in a 0.2% sodium dichromate solution or its equivalent
applied by the galvaniser.

After hot-dip galvanising, the maximum allowable bow in any of the main members shall not
exceed 1 in 500 measured in any plane. Approved steel gauges of the stub type or other gauges
approved by the Superintendent shall be provided by the Contractor to the extent required by the
Superintendent to enable him to carry out any checking of members considered necessary.
Grinding for removal of excess zinc shall not be carried out unless approval is granted by the Superintendent.

The “extent of repairable damaged or uncoated areas”, Clause 8.1 of AS/NZS 4680 – 2006 shall not apply. Objects where the total damaged or uncoated area exceeds 100 mm² shall be regalvanised (equivalent to 10mm by 10mm).

11. Tests and Inspections at Contractor’s Works

11.1 Inspection
The Contractor shall be responsible for quality control and inspection of all materials and processes of fabrication and galvanising to ensure that the materials and workmanship comply with the requirements of the relevant Australian Standards and this Specification. However, the Superintendent may independently inspect and test materials, fabrication and galvanising.

The Contractor shall give the Superintendent two weeks advance notice in writing of fabrication and testing and furnish the Superintendent with all test certificates for materials and fabrication processes.

The Contractor shall carry out any reasonable tests required by the Superintendent but not specifically nominated in the Australian Standards or this Specification, such tests being at the Principal’s expense except where results show defective materials or workmanship.

The Contractor shall repair or replace to the satisfaction of the Superintendent materials and workmanship which do not comply with the Specification.

11.2 Material Tests
All steelwork and material provided under this Specification shall be subject to such tests and inspections as are usual in the best practice and as may be necessary in the opinion of the Superintendent, to determine whether they comply in all respects with this Specification and to provide their safety and suitability for the use to which they will be applied. These tests shall include but not be limited to mill test certificates of steel production, compliance and test certificates of bolts; and ductility tests for spring washers.

Samples selected at random by the Superintendent or his duly authorised representative may be taken from this material after it has been allocated for fabrication of specific structure members and suitably identified. The samples shall then be subject to check tests. Should any specimen so tested fail to meet the requirements, the procedure set out under Clause “Additional Tests” in the Australian Standard Specifications shall be carried out.

Failure of the check tests, unless stated otherwise shall result in rejection of the steel. The Contractor shall give every assistance to the Superintendent’s representative to enable a check to be made of the accuracy of all instruments used during the tests either by the production of a recently certified calibration report for the instruments or by actual calibration of the instruments against accepted standard equipment.

The Contractor shall bear the costs of all tests and members used for the tests.

11.3 Galvanising Tests
One steel structural member shall be withdrawn from each batch after galvanising and test specimens shall be taken there from and submitted to testing for quality and weight of coating.

The selected structural member shall be suitably marked for identification with the batch it represents and should the specimens taken from it fail their tests, an additional structural member
or members sufficient to provide twice the original number of specimens shall be selected. Should the second series of tests fail, the batch represented shall be rejected.

In the event of rejection a batch may be stripped and regalvanised once only.

The tests shall be made in accordance with the appropriate Standards previously listed in this Specification for quality and for weight of coating by stripping. The Contractor shall bear the cost of all tests and members used for the galvanising tests.

11.4 Welding Tests
All welds shall be Categorised SP or GP as defined in AS 1554 Part 1.

Tests shall be carried out on 5% of Category SP welded joints using ultrasonic, x-ray or (if approved by the Superintendent) other methods. The Contractor shall bear all of the costs of the tests required by this sub-clause.

11.5 Delivery and Unloading
The Contractor shall deliver the steelwork including all necessary accessories, such as bolts, nuts, washers and timber packing to the Site.

The Contractor shall be responsible for the steelwork at all times during transport, loading and unloading and shall take appropriate measures to prevent loss of, or damage to the steelwork or galvanising.

The Contractor shall lift all galvanised steelwork using bow shackles attached to suitable lifting lugs or by approved slings. Under no circumstances will lifting of galvanised steelwork by unprotected chains placed around the galvanising be permitted.

All small, loose items which cannot be adequately stored on timber packing shall be placed in sealed durable containers.