3rd ANGLE PROJECTION | DO NOT SCALE THIS DRAWING IF IN DOUBT ASK

DRAWING No.
McB Standard Drawing Sheet

WELDING SPECIFICATION:-
ALL WELDS TO BE AS SPECIFIED ON RELEVANT WPS SHEETS

WELD FINISH:-
1: STRUCTURAL, AS LAID
2: CLEANED UP
3: GROUND SMOOTH.

WELD TESTING:-
VISUAL INSPECTION TO BE CARRIED OUT IN ACCORDANCE WITH BS EN ISO 17637:2011 - ALL 100%.
MPI OF FILLET WELDS TO BE CARRIED OUT IN ACCORDANCE WITH BS EN ISO 17638:2009 - TYP 10-15%
ULTRASONIC INSPECTION OF BUTT WELDS TO BE CARRIED OUT IN ACCORDANCE WITH BS EN ISO 17640:2010 - ALL 100%

FIXINGS:-
ALL BOLTS AND STUDDING AS PER BOLT LIST
ALL PRELOADED BOLTS AND STUDDING TO BE GRADE **???????????** TO BS EN 14399
ALL NON-PRELOADED BOLTS TO BE GRADE **???????????** TO BS EN 15048-1.
ALL EXTERNALLY EXPOSED BOLTS, NUTS AND WASHERS TO BE SPUN GALVANISED.
GALVANISED FIXINGS TO BE EN ISO 10684.

MATERIAL:-
STEELWORK GRADES ARE AS FOLLOWS:

STEEL SECTIONS TO BS EN 10025-1 S275 JR
STEEL SECTIONS TO BS EN 10025-1 S275 JO
STEEL SECTIONS TO BS EN 10025-1 S275 J2

STEEL SECTIONS TO BS EN 10025-1 S355 JR
STEEL SECTIONS TO BS EN 10025-1 S355 JO
STEEL SECTIONS TO BS EN 10025-1 S355 J2

HOT FINISHED HOLLOW SECTIONS TO BS EN 10210-1 - S355 JRH
HOT FINISHED HOLLOW SECTIONS TO BS EN 10210-1 - S355 J2H
COLD FORMED HOLLOW SECTIONS TO BS EN 10219-1 - S235 JRH
COLD FORMED HOLLOW SECTIONS TO BS EN 10219-1 - S355 J2H

MILD STEEL PLATES TO BS EN 10025-1 S275 JR
MILD STEEL PLATES TO BS EN 10025-1 S275 JO
MILD STEEL PLATES TO BS EN 10025-1 S275 J2

MILD STEEL PLATES TO BS EN 10025-1 S355 JR
MILD STEEL PLATES TO BS EN 10025-1 S355 J2+N

STAINLESS STEEL TO BS EN 10088-1 - 304
STAINLESS STEEL TO BS EN 10088-1 - 316

ALUMINIUM TO BS EN 485-1 - [VARIOUS GRADES DEPENDING ON THE SECTION]

FINISHES:-
SHOT BLAST TO SA 2.5 AS PER BS EN ISO8503
SHOT BLAST TO SA 3.0 AS PER BS EN ISO8503 (N1 ONLY)

PAINT TO N1 PAINT SPECIFICATION AS PER BS EN ISO12944
THERMAL SPRAYING (ZINC PRIMER) TO BS EN ISO 2063
ALUMINIUM OR ZINC PRIMER 100µm / BLAST PRIMER 25µm / INTERMEDIATE 150µm / TOP 50µm

PAINT TO N2 PAINT SPECIFICATION AS PER BS EN ISO12944
BLAST PRIMER 25µm / INTERMEDIATE 400µm / TOP 50µm

PAINT TO N3 PAINT SPECIFICATION AS PER BS EN ISO12944
THERMAL SPRAYING (ZINC PRIMER) TO BS EN ISO 2063
BLAST PRIMER 25µm / INTERMEDIATE 400µm / TOP 50µm

PAINT TO N4 PAINT SPECIFICATION AS PER BS EN ISO12944
BLAST PRIMER 50µm **OR** ALUM OR ZINC PRIMER 50µm / EPOXY PRIMER 125µm / INTERMEDIATE 125µm / TOP 50µm
PAINT TO N5 PAINT SPECIFICATION AS PER BS EN ISO12944
BUILDCOAT 125µm / TOP 50µm
TOPCOAT COLOUR IS **??????**

THERMAL SPRAYING (ZINC RICH PRIMER) TO BS EN ISO 2063

ZINC PHOSPHATE PRIMER - LEIGHS M600

ZINC RICH PRIMER - EPIGRIP J384

ZINC PHOSPHATE PRIMER / BUILDCOAT - EPIGRIP C402V2

ALL STEELWORK GALVANISED TO BS EN 1461

POWDER COAT TO ????µ - COLOUR ????? TO BS EN 13438

QUALITY CONTROL:-
ALL DIMENSIONS ARE IN MILLIMETRES UNLESS SPECIFIED OTHERWISE

ALL LEVELS ARE IN METRES AND RELATE TO ORDINANCE DATUM UNLESS NOTED OTHERWISE

ALL FABRICATION AND WELDING WORKS TO BE CARRIED OUT IN ACCORDANCE WITH BS EN 1090-1 and BS EN 1090-2
CHECK SPECIFICATIONS AND SPECIALISTS DRAWINGS FOR VERIFICATION OF ALL SETTING OUT DIMENSIONS AND LOCATION OF ANY SERVICES OR FIXINGS REQUIRED IN STEEL, BRICK OR CONCRETE WORKS.

ALL FABRICATION TOLERANCES AS PER BS EN 1090-2

ALL BURNT PROFILED PLATES TO HAVE TROUGHING REMOVED FROM ALL EDGES

ALL PLATES/CUT EDGES TO BE PAINTED TO HAVE ARRISED CORNERS TO APPROX. 1.5mm TO 2.5mm RADIUS

ALL WELD SPATTER TO BE REMOVED DURING THE FABRICATION PROCESS & CHECKED AGAIN AT FINAL COMPLETION

REMOVE ALL SHARP EDGES AND BURRS
DRILLED AND TAPPED CONNECTIONS INTO HOLLOW SECTIONS ARE TO BE AVOIDED

ALL CLOSED SECTIONS AND TROUGHS TO HAVE VENT & DRAIN HOLES

ALL GALVANISED STEEL TO BE FETTLED BEFORE FINAL DESPATCH

WORKSHOP NOTE:
MAKE IT TO THE DRAWING - IF YOU SUSPECT A DRAWING ERROR, STOP AND REPORT IT TO YOUR SUPERVISOR UNTIL CONFIRMATION RECEIVED DO NOT MAKE ASSUMPTIONS - ASK FOR DRAWING CHANGES TO BE MADE TO CONFIRM ANY CHANGES TO ORIGINAL DESIGNS

REFERENCE DRAWINGS:-

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NOTES.

McNealy Brown LIMITED
SPECIALIST FABRICATORS
ARCHITECTURAL METALWORKERS
DESIGN & INSTALLATION ENGINEERS
Units 14 -17 Craft Marsh Trading Estate
Gas Road, Sittingbourne, Kent ME10 2QB
Tel: 01795 470592 Email: info@mcnealybrown.co.uk
www.mcnealybrown.co.uk

UK CA 0513-CPR-5044-001/01

CLIENT.

PROJECT.

TITLE.

DATE.	AUTHOR.	CHECKED.
31/03/2021	tom.kennison	

ORIGINAL SCALE @ A1:-
0cm 5 10

DRAWING No. McB Standard Drawing Sheet 2022
REV. 1

EXECUTION CLASS.
SIZE. A1