



AS BUILT
26-06-2015



- 1) ALL STEELWORK SECTIONS TO BE GRADE 350MA.
- 2) ALL STEELWORK AND WORKMANSHIP TO BE I.A.W. SABS 0162 1200H & 1200HA AND ESKOM DOCUMENT No: 203-720. AND SA STEEL CONSTRUCTION HANDBOOK. (THE RED BOOK)
- 3) STEELWORK IS TO BE OF SHOP WELDED AND SITE BOLTED CONSTRUCTION (U.O.S.)
- 4) ALL HOLES TO BE Ø22 FOR M20 GRADE 8.8 BOLTS. (U.O.S.)
- 5) MINIMUM CONNECTION OF BOLTS, 2xM20 GRADE 8.8 BLOTS
- 6) ALL SETTING OUT POINTS ON THE DRAWING MUST ADHERED TO AT ALL TIMES WHILE SHOP DETAILING.
- 7) ALL BRACINGS MUST HAVE A MINIMUM OF TWO BOLT END CONNECTION.
- 8) FABRICATOR TO SUPPLY ALL BOLT, NUTS AND WASHERS AS REQUIRED FOR ERECTION, WITH 5% EXTRA, BAGGED PER DRAWING AND LABELLED WITH THE DRAWING NUMBER.
- 9) TAPERED WASHER TO BE USED WHERE REQUIRED.
- 10) ALL WELDS TO BE 6mm (MIN) CONTINUOUS FILLET WELDS AND I.A.W SABS 044. (U.O.S.)
- 11) ALL ITEMS RO BE CLEARLY HAND MARKED WITH DRAWING AND ITEM NUMBER IN 10mm LETTERING ±500mm FROM END.
- 12) ALL GUSSETS AND END PLATES TO BE 10mm THICK. (U.O.S.)
- 13) PAINTING MUST BE I.A.W. SPECIFICATION ON THE ORDER. (U.O.S.)
- 14) ALL SHOP DETAILS MUST BE COMPLIED BY FABRICATOR AND SUBMITTED TO CLYDE BERGEMANN AFRICA FOR APPROVAL PRIOR TO MANUFACTURING.
 - 15 FABRICATOR MUST ISSUE ONE COPY OF ALL STEELWORK DRAWINGS INDICATING ERECTION MARKS FOR ERECTING PURPOSES.
 - 16 STANDARD BACK MARKS & CROSS CENTRES TO BE USED.
 - 17 NO DEVIATION FROM MEMBER SIZE, DIMENSIONS OR SETTING OUT POINTS, UNLESS PERMISSION GRANTED FROM ENGINEER IN WRITING.
 - 18 AFTER SURFACE PROTECTION IS COMPLETED, CRAWL BEAMS MUST BE CLEARLY MARKED WITH S.W.L. AS PER SPECIFICATION IN 150mm HIGH BLACK LETTERS, ON BOTH SIDES OF WEB. (U.O.S.)
- 9 FABRICATOR TO SUPPLY SUITABLE PACKS UNDER COLUMN BASE PLATES FOR SITE LEVELLING PRIOR TO GROUTING.
- 20) SHOP DETAILER IS TO ENSURE ADEQUATE DRAINAGE HOLES AT AREAS THAT MAY TRAP WATER.
- 21) REMOVE ALL BURRS AND SHARP EDGES.

ITEM	APPROX MASS(Kg)	No.Off	TOTAL
SILO 4 EDGE CRAWL STRUCTURE	7093Kg	1	7093Kg

[illegible]