

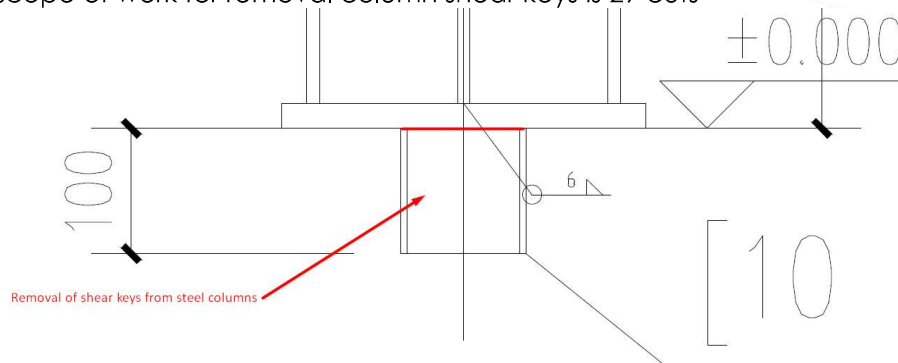
Scope of Work

This Scope of Work outlines the requirements for provision of the removal of fabricated shear keys from steel columns and the subsequent welding of the column baseplates to a 25mm thick anchorage plates. All work must comply with AWS D1.1 – Structural Welding Code – Steel.

1. Scope of Work

1.1. Removal of fabricated shear keys

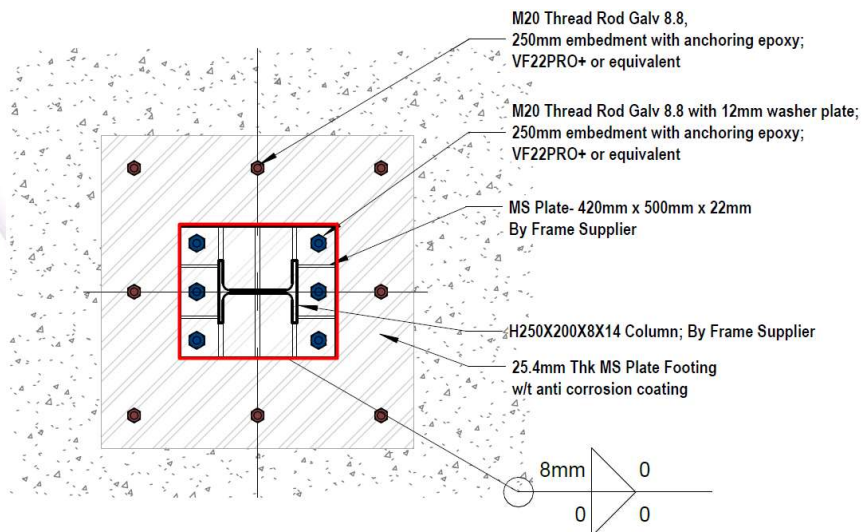
- Use mechanical cutting methods to remove shear keys without damaging the main column structure.
- Ensure surface preparation by grinding and apply anti-corrosion coating to the exposed areas
- The scope of work for removal column shear keys is 29 cuts



Picture 1. Column shear key

1.2. Welding of column baseplate to anchorage plate

- Position and align the column baseplate on the 25mm anchorage plate as per design drawings and survey marking ups.
- Perform welding as per design drawing with using welding procedure (WPS), ensuring proper fillet weld size and penetration.
- Apply post-weld anti-corrosion protection after acceptance weld joints by the client
- 29ea. 8mm fillet weld joints with a length of each weld joint of 1840mm.



Picture 2. Typical 8mm fillet weld joint

1.3. Acceptance of weld joints

The work will be accepted upon successful weld quality verification that includes the following:

| Inspection Method | Frequency of Inspection | Reference (AWS D1.1) |
|--------------------------------|-------------------------|-----------------------|
| Visual Inspection (VT) | 100% of all joints | AWS D1.1 Table 6.1 |
| Magnetic Particle Testing (MT) | 10% - 25% of all welds | AWS D1.1 Clause 6.9.3 |

Note: AWS D1.1: Structural Welding Code-Steel