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MAXI-TUBE® - STRUCTURAL SPECIFICATION

1.0 Tube and Pipe Specification

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The structural tube and pipe supplied must be manufactured as ZM 275 MAXI-TUBE®. The structural tube or pipe shall be manufactured from pre-coated steel conforming to the ZM 275 coating class specified in AS1397. The structural tube and pipe must be manufactured in accordance with AS/NZS 1163. The coated steel shall be cold formed and welded into the desired section size using Electric Resistance Welding (ERW). The ERW zone shall be coated by Metal Spray utilising the MAXI-TUBE® Wire alloy material.

Comment [s1]: Can be inserted into Drawing Notes for Structural Steel.

1.1 Coating mass

The ZM coating on the steel sheet shall conform to AS1397 coating class ZM 275. The exterior and interior surface shall have a combined ZM alloy coating weight of 275g/m². The coating mass of 275 g/m² is the total amount for both sides measured by the triple spot test in accordance with AS 1397.

2.0 Fabrication Welding of MAXI-TUBE®

Welding to be done in accordance with AS/NZS 1554.1 Category SP Welding of Steel Structures.

Reference must be made to the WTIA document TGN-BC-03 Welding of Mill applied galvanised sections.

Reference to the BOC (Weld Procedure Specification) WPS MAXI-TUBE® ZM275 GMAW Fillet, FCAW Fillet, and MMAW Fillet must be followed located at <http://www.orrconsteel.com.au/products/maxi-tube>

3.0 Paint Coating Specification at Weld Zones

When welding MAXI-TUBE® the welding process damages the ZM 275 coating. Using the appropriate fabrication technique, surface preparation, and repair coating it is possible to replace the MAXI-TUBE® coating at the damaged weld zones and plate attachments with an equivalent durability. This includes using Stainless Steel plate attachments, or coating black plate with zinc rich epoxy and MAXI-TUBE® Grey colour match paint. Contact Orrcon Steel for the paint manufacturers detailed technical notes for this solution or refer to the solutions on the website. <http://www.orrconsteel.com.au/products/maxi-tube>

4.0 Paint Coating Specification over MAXI-TUBE®

Contact Orrcon Steel for the paint manufacturers detailed technical notes for this solution. A variety of architectural and marine grade paint specifications are available. MAXI-TUBE® is suited to be powder coated or coated with a 2 or 3 coat epoxy paint system. The consistent surface provides a high quality adhesion and finish.



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