

National Structural Steelwork Specification for Building Construction

Corrigenda

First Revision National Structural Steelwork Specification 7th edition



BCSA Publication No. 67/23

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First Revision National Structural Steelwork Specification 7th ed.

The following list represents corrections to the first printing of the 7th edition (BCSA Pub. 62/20), dated September 2020, and its Annex J – Sustainability Specification (BCSA Pub. 65/22), dated January 2022. These corrections are incorporated in the first revision dated 3rd April 2023, and will come into force on 2nd October 2023.

These corrigenda will be issued with the following references:

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Amendment	Date	Item
AM-NSSS7-2021-01	July 2021	Change to the negative camber tolerance in Sections 7.2.6, 7.4.9 and 7.5.8
AM-NSSS7-2022-01	January 2022	Section 2.4.2 for (i) certification to NHSS3 and (ii) compliance with the <i>Model Specification for the purchase of structural bolting assemblies and holding down bolts</i>
AM-NSSS7-2022-02	February 2022	Section 7.2.2: upper limit to the tolerance on squareness of ends not prepared for bearing
AM-NSSS7-2022-03	June 2022	Annex J — Sustainability Specification: change to the wording in Section J.3.4.1
AM-NSSS7-2022-04	June 2022	Section 11.1.1 to certification to the “Register of Qualified Steelwork Contractors Scheme for Buildings” becoming a mandatory requirement, in line with the Building Safety Act
AM-NSSS7-2022-05	June 2022	Revision of Table 2.8 in Section 2.4.8 in line with issue 13.1 of the <i>Model Specification for the purchase of structural bolting assemblies and holding down bolts</i>
AM-NSSS7-2022-06	June 2022	Revision of Section 7.6.1
AM-NSSS7-2022-07	June 2022	Revision of Section 9.6.17, to reinstate a relative limitation at floor and roof levels
AM-NSSS7-2022-08	June 2022	Revision of section 5.5.2, to remove reference to Annex C of BS EN ISO 17635:2010, which is only applicable during production not initial type testing

AM-NSSS7-2022-09	June 2022	Revision of Table B in Annex B, and Table B in Annex E in line with BS EN 1090-2
AM-NSSS7-2022-10	October 2022	Section 11.2.2 to make it clear the FPC assessment to BS EN 1090-1 shall be carried out every year
AM-NSSS7-2022-11	October 2022	Section 7.2.4: upper limit to the tolerance on straightness on both axes
AM-NSSS7-2023-01	February 2023	Annex I — List of BCSA Steelwork Contractor Members updated

Section(s) Item

2.4.2 (i) Re-write first paragraph as follows:

A quality management system shall be used for the supply and distribution of structural fasteners. For projects in the UK suppliers and distributors of structural fasteners shall be certified to the National Highways Sector Scheme 3 (NHSS3) (or equivalent) quality management system.

(ii) Delete note and add:

Structural fasteners from a supplier shall only be accepted if the supplier complies with the full requirements of the *Model Specification for the purchase of structural bolting assemblies and holding down bolts* published by the BCSA.

2.4.8 Add property class 10.9 cup and countersunk bolts.
Table 2.8

5.5.2 Re-write third paragraph as follows:

If initial type testing gives nonconforming results, a further set of five joints shall be tested. In addition, an investigation shall be carried out by the RWC, or delegated Welding Coordinator, to (i) determine the cause of failure and prevent recurrence, and (ii) review the WPS as necessary.

Note: Such investigation can involve checking joint types and configurations, material carbon equivalent values, welder skills, etc. to establish a potential cause of failure.

7.2.2 Amend as follows:

$\Delta = \pm D/100$ up to a maximum of 10mm

7.2.4 Amend as follows:

$\Delta = \pm L/1000$ or 3mm whichever is greater

-
- 7.2.6 Amend negative camber tolerance as follows:
7.4.9 $-\Delta = L/1000$ or 4mm, whichever is greater
7.5.8
- 7.6.1 Amend as follows:
Deviation Δ at mid-span relative to a straight line or to the intended camber when measured after welding, or bolting, with the component lying flat on its side.
For straight two-dimensional lattice components:
 $\Delta = \pm L/1000$ or 3mm whichever is greater
For cambered, curved and all other lattice components:
 $\Delta = \pm L/500$ or 12mm whichever is greater
- 9.6.17 Amend as follows:
Location Δ of the outer face ① of a perimeter column at base, and at each floor and roof levels relative to the line joining the faces of adjacent columns.
- 11.1.1 Re-write second paragraph as follows:
The Steelwork Contractor shall demonstrate that they have the necessary personnel, organisation, experience, knowledge, equipment, competence, financial capability and commitment to carry out The Works. These requirements will be satisfied by a Steelwork Contractor holding a valid certificate of registration on “The Register of Qualified Steelwork Contractors Scheme for buildings” (RQSC – Buildings) to the levels appropriate for the value and technical complexity of The Works.
Note: All Steelwork Contractors who are members of BCSA are registered on the RQSC (buildings and/or bridges). A full list of BCSA members is given in Annex I. A full list of Steelwork Contractors registered on the RQSC (Buildings) can be found on www.bcsa.org.uk/rqsc-buildings
- 11.2.2 Re-write first paragraph as follows:
The Factory Production Control (FPC) system for controlling the conformity of manufactured components shall be certified as complying with the requirements of BS EN 1090-1. The intervals between surveillance inspections of a Steelwork Contractors’ FPC, as required by Clause B.4.2 of BS EN 1090-1:2009+A1:2011, shall be at least yearly.
- Annex B Table B Row 4 of the Table, Fillet welds, change *maximum nominal thickness* to 30mm
- Annex E Table B Rows 4 and 5 of the Table, Fillet welds, change *maximum nominal thickness* to 30mm
- J.3.4.1 Re-write first paragraph as follows:
-

Where possible, the Steelwork Contractor should consider ordering sections “cut to length” to minimise off-cuts either by the mill, the stockholder or the Steelwork Contractor. Alternatively, if stock lengths are ordered, these should be used efficiently by the Steelwork Contractor to minimise waste. Splice locations in steel members, where possible, should be coordinated to fall within standard stock length sizes.

AM-NSSS7-2021-01	
Subject	Negative tolerances on cambers
Section No./ Annex	7.2.6, 7.4.9 and 7.5.8
Reason for amendment	<p>The current requirement is more onerous than criterion No. 4 in Table B.6 of BS EN 1090-2:2018, which stipulates the following functional tolerances:</p> <ul style="list-style-type: none"> — For Class 1, $-\Delta = L/500$ or 6 mm whichever is greater — For Class 2, $-\Delta = L/1000$ or 4 mm whichever is greater <p>Steelwork Contractors are finding that in many cases the zero negative tolerance is difficult to achieve and requires more expensive cambering techniques. For long-span beams the Class 1 negative tolerances given in BS EN 1090-2 may not be appropriate because as explained above it can result in the beam cambering in the wrong direction. To avoid this situation the more stringent class 2 tolerances from Table B.6 of BS EN 1090-2:2018 for the negative tolerance limit should be adopted in Sections 7.2.6, 7.4.9, and 7.5.8 of the 7th Edition of the NSSS.</p>
Existing wording	$-\Delta = 0$
Proposed change	$-\Delta = L/1000$ or 4mm, whichever is greater
Background information	AD 465

AM-NSSS7-2022-01	
Subject	Supply and distribution of structural fasteners
Section No./ Annex	2.4.2
Reason for amendment	<p>Making certification to NHSS3 a mandatory requirement.</p> <p>Making compliance to the Model Specification for the Purchase of Structural Bolting Assemblies and Holding Down Bolts a mandatory requirement.</p>
Existing wording	<p>A quality management system shall be used for the supply and distribution of structural fasteners. For projects in the UK suppliers and distributors of structural fasteners shall comply with National Highways Section Scheme 3 (NHSS3) (or an equivalent) quality management system.</p> <p><i>Note: The BCSA publishes a Model Specification for the Purchase of Structural Bolting Assemblies and Holding Down Bolts.</i></p>
Proposed change	<p>A quality management system shall be used for the supply and distribution of structural fasteners. For projects in the UK suppliers and distributors of structural fasteners shall be certified to the National Highways Sector Scheme 3 (NHSS3) (or equivalent) quality management system.</p> <p>Structural fasteners from a supplier shall only be accepted if the supplier complies with the full requirements of the <i>Model Specification for the purchase of structural bolting assemblies and holding down bolts</i> published by the BCSA.</p>
Background information	Alignment with NHSS3 requirements

AM-NSSS7-2022-02	
Subject	Squareness of ends not prepared for bearing
Section No./ Annex	7.2.2
Reason for amendment	Upper limit to the tolerance
Existing wording	$\Delta = \pm D/100$
Proposed change	$\Delta = \pm D/100$ up to a maximum of 10mm
Background information	Table B.6 (No. 6) of BS EN 1090-2:2018

AM-NSSS7-2022-03	
Subject	Fabrication waste management
Section No./ Annex	Annex J, J.3.4.1, 1 st paragraph
Reason for amendment	Clarification of paragraph. The intention is to not preferentially source sections via a particular route, rather to encourage suppliers and Steelwork Contractors to optimise section lengths and to minimise off-cuts, for example using section nesting software.
Existing wording	Where possible, the Steelwork Contractor should consider ordering directly from mills to minimise offcuts. Alternatively, if stock lengths are ordered, these should be used efficiently to minimise waste. Splice locations in steel members, where possible, should be coordinated to fall within standard stock length sizes.
Proposed change	Where possible, the Steelwork Contractor should consider ordering sections “cut to length” to minimise off-cuts either by the mill, the stockholder or the Steelwork Contractor. Alternatively, if stock lengths are ordered, these should be used efficiently by the Steelwork Contractor to minimise waste. Splice locations in steel members, where possible, should be coordinated to fall within standard stock length sizes.
Background information	AD 486

AM-NSSS7-2022-04	
Subject	Competence of Steelwork Contractor – General
Section No./ Annex	11.1.1, 2 nd paragraph
Reason for amendment	To make certification to the “Register of Qualified Steelwork Contractors Scheme for Buildings” a mandatory requirement to comply with the Building Safety Act.
Existing wording	It is recommended that the Steelwork Contractor be specified from the members of BCSA Steelwork Contractors. All BCSA Steelwork Contractor members are independently assessed and their competence measured against the requirements in this Specification, and, if required, can provide a certificate. A full list of BCSA members is given at the end of this Specification, and up-to-date lists can be found in www.steelconstruction.org .
Proposed change	<p>The Steelwork Contractor shall demonstrate that they have the necessary personnel, organisation, experience, knowledge, equipment, competence, financial capability and commitment to carry out The Works. These requirements will be satisfied by a Steelwork Contractor holding a valid certificate of registration on “The Register of Qualified Steelwork Contractors Scheme for buildings” (RQSC – Buildings) to the levels appropriate for the value and technical complexity of The Works.</p> <p><i>Note: All Steelwork Contractors who are members of BCSA are registered on the RQSC (buildings and/or bridges). A full list of BCSA members is given in Annex I. A full list of Steelwork Contractors registered on the RQSC (Buildings) can be found on www.bcsa.org.uk/rqsc-buildings</i></p>
Background information	The alternative wording is in line 1800 Series.

AM-NSSS7-2022-05													
Subject	Cup and countersunk bolts												
Section No./ Annex	2.4.8, Table 2.8												
Reason for amendment	Revision of Table 2.8 in Section 2.4.8 in line with issue 13.1 of the <i>Model Specification for the purchase of structural bolting assemblies and holding down bolts</i> .												
Existing wording	Table 2.8 Cup and countersunk non-preloaded assemblies ⁽¹⁾												
	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 15%;">Property class</th> <th style="width: 15%;">Bolt</th> <th style="width: 25%;">Nut ⁽²⁾</th> <th style="width: 45%;">Washer</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">4.6</td> <td style="text-align: center;">BS 4933</td> <td style="text-align: center;">BS EN ISO 4032 ⁽³⁾ (property class 5) ⁽⁴⁾</td> <td style="text-align: center;">BS EN ISO 7091 (100HV)</td> </tr> <tr> <td style="text-align: center;">8.8</td> <td style="text-align: center;">BS 4933</td> <td style="text-align: center;">BS EN ISO 4032 ⁽³⁾ (property class 8) ⁽⁴⁾</td> <td style="text-align: center;">BS EN ISO 7091 (100HV)</td> </tr> </tbody> </table>	Property class	Bolt	Nut ⁽²⁾	Washer	4.6	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 5) ⁽⁴⁾	BS EN ISO 7091 (100HV)	8.8	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 8) ⁽⁴⁾	BS EN ISO 7091 (100HV)
	Property class	Bolt	Nut ⁽²⁾	Washer									
4.6	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 5) ⁽⁴⁾	BS EN ISO 7091 (100HV)										
8.8	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 8) ⁽⁴⁾	BS EN ISO 7091 (100HV)										
<ol style="list-style-type: none"> 1. Countersunk bolts subject to tensile loads, e.g. direct tension or prying, should only be supplied with a screwdriver slot head unless the alternative can be demonstrated to not adversely affect the bolt loadability to BS EN ISO 898-1 or BS EN 15048-2. 2. Nuts of a higher property class may also be used. 3. Nuts of property classes to BS EN ISO 4032 with dimensions and tolerances of BS EN ISO 4034 may also be used. 4. Nuts for galvanised or sherardised bolts shall be tapped over-size to tolerance 6AZ to accommodate the thickness of galvanising/sherardising. This over-tapping reduces the strength of the nut and therefore a nut that has a proof load higher than the minimum ultimate tensile load of the assembly shall be used. Nuts for galvanised or sherardised 4.6 bolts shall be property class 8 and nuts for galvanised or sherardised 8.8 bolts shall be property class 10. 													

AM-NSSS7-2022-05

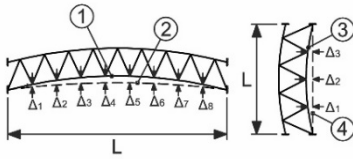
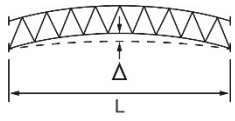
Proposed change

Table 2.8 Cup and countersunk non-preloaded assemblies ⁽¹⁾

Property class	Bolt	Nut ⁽²⁾	Washer
4.6 ⁽⁵⁾	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 5) ⁽⁴⁾	BS EN ISO 7091 (100HV)
8.8 ⁽⁵⁾	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 8) ⁽⁴⁾	BS EN ISO 7091 (100HV)
10.9	BS 4933	BS EN ISO 4032 ⁽³⁾ (property class 10) ⁽⁴⁾	BS EN ISO 7091 (100HV)

- Countersunk bolts subject to tensile loads, e.g. direct tension or prying, should only be supplied with a screwdriver slot head unless the alternative can be demonstrated to not adversely affect the bolt loadability to BS EN ISO 898-1 or BS EN 15048-2.
- Nuts of a higher property class may also be used.
- Nuts of property classes to BS EN ISO 4032 with dimensions and tolerances of BS EN ISO 4034 may also be used.
- Nuts for galvanised or sherardised bolts shall be tapped over-size to tolerance 6AZ to accommodate the thickness of galvanising/sherardising. This over-tapping reduces the strength of the nut and therefore a nut that has a proof load higher than the minimum ultimate tensile load of the assembly shall be used. Nuts for galvanised or sherardised 4.6 bolts shall be property class 8 and nuts for galvanised or sherardised 8.8 bolts shall be property class 10.
- The availability of countersunk fasteners property class 4.6 and 8.8 is limited and therefore the use of property class 10.9 should be considered prior to specification.

Background information

AM-NSSS7-2022-06	
Subject	Permitted deviations for “straightness and camber E” for lattice components
Section No./ Annex	7.6.1
Reason for amendment	Length <i>L</i> is incorrect in the diagram.
Existing wording	<p>7.6.1 Straightness and camber E</p> <p>Deviations Δ_i of the actual positions ③ or ① at each panel point relative to a straight line ④ or to the intended camber ② when measured after welding with the component lying flat on its side.</p> <p>$\Delta = \pm L/500$ or 12mm whichever is greater</p>  <p>The diagram shows a lattice component of length <i>L</i>. A dashed line represents the intended camber (2). A solid line represents the actual position (1). A horizontal line represents a straight line (4). Vertical arrows indicate deviations Δ_1 through Δ_8 at each panel point. A vertical section on the right shows the component's profile with deviations Δ_1, Δ_2, and Δ_3 relative to a straight line (4) and the intended camber (2).</p>
Proposed change	<p>7.6.1 Straightness and camber E</p> <p>Deviation Δ at mid-span relative to a straight line or to the intended camber when measured after welding, or bolting, with the component lying flat on its side.</p> <p>For straight two-dimensional lattice components:</p> <p>$\Delta = \pm L/1000$ or 3mm whichever is greater</p> <p>For cambered, curved and all other lattice components:</p> <p>$\Delta = \pm L/500$ or 12mm whichever is greater</p>  <p>The diagram shows a lattice component of length <i>L</i>. A dashed line represents the intended camber. A solid line represents the actual position. A vertical arrow at mid-span indicates the deviation Δ relative to a straight line.</p>

AM-NSS7-2022-06Background
information

BCSA-P&TC-2022-071

BCSA-P&TC-2022-073

Decisions made by the Process and Technical Committee:

1. Specify a single tolerance at mid-span of the lattice girder.
2. For straight lattice components adopt: $\Delta = \pm L/1000$ at mid-span or 3 mm whichever is greater.
3. For cambered lattice components adopt: $\Delta = \pm L/500$ at mid-span or 12 mm whichever is greater.

AM-NSSS7-2022-07	
Subject	Perimeter column alignment
Section No./ Annex	9.6.17
Reason for amendment	To reinstate a relative limitation at floor and roof levels.
Existing wording	Location Δ of the outer face ① of a perimeter column at base level relative to the line joining the faces of adjacent columns.
Proposed change	Location Δ of the outer face ① of a perimeter column at base, and at each floor and roof levels relative to the line joining the faces of adjacent columns.
Background information	NSSS 5 th edition

AM-NSSS7-2022-08	
Subject	Initial type testing
Section No./ Annex	5.5.2, 3 rd paragraph
Reason for amendment	To remove reference to Annex C of BS EN ISO 17635:2010, which applies to production and not initial type testing.
Existing wording	If initial type testing gives nonconforming results, investigation shall be carried out in order to find the reason and a further set of five joints shall be tested. The guidance in Annex C of BS EN ISO 17635:2010 should be followed, and further investigation should be carried out by the RWC, as required.
Proposed change	If initial type testing gives nonconforming results, a further set of five joints shall be tested. In addition, an investigation shall be carried out by the RWC, or delegated Welding Coordinator, to (i) determine the cause of failure and prevent recurrence, and (ii) review the WPS as necessary. <i>Note: Such investigation can involve checking joint types and configurations, material carbon equivalent values, welder skills, etc. to establish a potential cause of failure.</i>
Background information	

AM-NSSS7-2022-09									
Subject	Welds – extent of routine supplementary non-destructive testing								
Section No./ Annex	Table B in Annex B (EXC2) – Row 4 Table B in Annex E (EXC3) – Rows 4 and 5								
Reason for amendment	To align with the requirements from BS EN 1090-2:2018.								
Existing wording	<ul style="list-style-type: none"> — in material being joined with a maximum nominal thickness > 20mm — in material being joined together with a maximum nominal thickness ≤ 20mm 								
Proposed change	<ul style="list-style-type: none"> — in material being joined with a maximum nominal thickness > 30mm — in material being joined together with a maximum nominal thickness ≤ 30mm <p>Annex B:</p> <p>Table B Extent of routine supplementary NDT ⁽⁵⁾</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 70%; text-align: center;">Weld Type ⁽¹⁾</th> <th style="width: 30%; text-align: center;">Extent ⁽²⁾</th> </tr> </thead> <tbody> <tr> <td>Full or partial penetration butt welds (other than welds to stiffeners or longitudinal welds)</td> <td style="text-align: center;">10% Magnetic Particle Testing (MT)</td> </tr> <tr> <td>Full or partial penetration butt welds in material being joined with a maximum nominal thickness > 10mm</td> <td style="text-align: center;">10% Ultrasonic Testing (UT)</td> </tr> <tr> <td> Fillet welds <ul style="list-style-type: none"> — with nominal throat thickness > 12mm (nominal leg length > 17mm), or — in material being joined with a maximum nominal thickness > 30mm </td> <td style="text-align: center; vertical-align: middle;">10% MT and 5% UT⁽³⁾</td> </tr> </tbody> </table>	Weld Type ⁽¹⁾	Extent ⁽²⁾	Full or partial penetration butt welds (other than welds to stiffeners or longitudinal welds)	10% Magnetic Particle Testing (MT)	Full or partial penetration butt welds in material being joined with a maximum nominal thickness > 10mm	10% Ultrasonic Testing (UT)	Fillet welds <ul style="list-style-type: none"> — with nominal throat thickness > 12mm (nominal leg length > 17mm), or — in material being joined with a maximum nominal thickness > 30mm 	10% MT and 5% UT ⁽³⁾
Weld Type ⁽¹⁾	Extent ⁽²⁾								
Full or partial penetration butt welds (other than welds to stiffeners or longitudinal welds)	10% Magnetic Particle Testing (MT)								
Full or partial penetration butt welds in material being joined with a maximum nominal thickness > 10mm	10% Ultrasonic Testing (UT)								
Fillet welds <ul style="list-style-type: none"> — with nominal throat thickness > 12mm (nominal leg length > 17mm), or — in material being joined with a maximum nominal thickness > 30mm 	10% MT and 5% UT ⁽³⁾								

AM-NSS7-2022-09

Welds in cruciform joints (butt or fillet welds) in material with a maximum nominal 'through' plate thickness > 30mm

10% UT⁽⁴⁾

1. Provided that site welding is under the control of a suitably competent on-site welding coordinator authorised by the RWC, these requirements make no distinction between shop and site welds. However, the extent of testing for the weld types above shall be 100% for site welds on a new project until the RWC is satisfied that suitable quality levels can be maintained.
Note: This applies the principles in 5.5.2 for initial type testing to the supplementary NDT for welds on the site of a new project.
2. The percentages are subject to a minimum length of 900mm in any inspection lot and apply to the cumulative amount of weld length in joints welded according to the same WPS treated as a single continuing inspection lot. An inspection lot is a group of welds expected to show a uniform quality.
3. Ultrasonic testing of fillet welds shall be carried out using 0° probes to determine the absence of defects in the parent material.
4. For cruciform joints, the NDT operator, see 5.5.6, shall select the probes and scanning patterns used to test the welded joint. The purpose of this test is to detect lamellar tearing in the parent material.
5. If a workshop is only producing work where no supplementary NDT is required, then a monthly programme of further NDT shall be instituted, see 5.5.1.

Annex E:


Table B Extent of routine supplementary NDT for EXC3 (static)

Weld Type ⁽¹⁾	Extent ⁽²⁾
Full or partial penetration butt welds (other than welds to stiffeners or longitudinal welds)	20% Magnetic Particle Testing (MT)
Full or partial penetration butt welds in material being joined with a maximum nominal thickness > 10mm	20% Ultrasonic Testing (UT)

AM-NSSS7-2022-09		
	<p>Fillet welds</p> <ul style="list-style-type: none"> — with nominal throat thickness $\leq 12\text{mm}$ (nominal leg length $\leq 17\text{mm}$) in material being joined together with a maximum nominal thickness $\leq 30\text{mm}$ 	5% MT
	<p>Fillet welds</p> <ul style="list-style-type: none"> — with nominal throat thickness $> 12\text{mm}$ (nominal leg length $> 17\text{mm}$), or — in material being joined with a maximum nominal thickness $> 30\text{mm}$ 	10% MT and 5% UT ⁽³⁾
	<p>Welds in cruciform joints (butt or fillet welds) in material with a maximum nominal 'through' plate thickness $> 30\text{mm}$</p>	20% UT ⁽⁴⁾
	<p>Longitudinal welds, welds to stiffeners and welds specified in the execution specification as being in compression</p>	5% MT
	<ol style="list-style-type: none"> 1. Provided that site welding is under the control of a suitably competent on-site welding coordinator authorised by the RWC, these requirements make no distinction between shop and site welds. However, the extent of testing for the weld types above shall be 100% for site welds on a new project until the RWC is satisfied that suitable quality levels can be maintained. 2. The percentages are subject to a maximum length of 900mm in any inspection lot and apply to the cumulative amount of weld length in joints welded according to the same WPS treated as a single continuing inspection lot. An inspection lot is a group of welds expected to show a uniform quality. If the total length of all the welds in an inspection lot is less than 900mm, at least one weld shall be tested in its entire length. 3. Ultrasonic testing of fillet welds shall be carried out using 0° probes to determine the absence of defects in the parent material. 4. For cruciform joints, the NDT operator, see 5.5.6, shall select the probes and scanning patterns used to test the welded joint. The purpose of this test is to detect lamellar tearing in the parent material. 	
Background information	BS EN 1090-2:2018	

AM-NSSS7-2022-10	
Subject	Quality System (System acceptance)
Section No./ Annex	11.2.2, 1 st paragraph
Reason for amendment	To make it clear the FPC assessment to BS EN 1090-1 shall be carried out every year.
Existing wording	The Factory Production Control (FPC) system for controlling the conformity of manufactured components shall be certified as complying with the requirements of BS EN 1090-1.
Proposed change	The Factory Production Control (FPC) system for controlling the conformity of manufactured components shall be certified as complying with the requirements of BS EN 1090-1. The intervals between surveillance inspections of a Steelwork Contractors' FPC, as required by Clause B.4.2 of BS EN 1090-1:2009+A1:2011, shall be at least yearly.
Background information	BS EN 1090-1:2009+A1:2011 specifies intervals between inspections of FPC, however Certification Bodies undertaking conformity assessments in accordance with BS EN ISO/IEC 17021:2015 have been adopting the recommended interval given in Annex E of that standard of one year between surveillance audits. UKAS are requiring Certification Bodies that provide assessment of products, processes and services to be accredited to BS EN ISO/IEC 17065:2012. This standard does not provide a recommended interval between surveillance visits. Some certification bodies could therefore revert to the intervals specified in BS EN 1090-1:2009+A1:2011 which, under some circumstances, could extend to three years between surveillance visits. This would be a retrograde step compared to the current situation. To maintain the current level of surveillance of FPC and to ensure a consistent approach for all constructors it is necessary to specify the required interval of one year. This approach follows the approach being adopted elsewhere in the UK steelwork industry.

AM-NSSS7-2022-11	
Subject	Straightness on both axes
Section No./ Annex	7.2.4
Reason for amendment	Consistency with other tolerances.
Existing wording	$\Delta = \pm L/1000$
Proposed change	$\Delta = \pm L/1000$ or 3mm whichever is greater
Background information	Table B.6 (No. 3) of BS EN 1090-2:2018

AM-NSSS7-2023-01	
Subject	List of BCSA Steelwork Contractor members
Section No./ Annex	Annex I
Reason for amendment	Update
Existing wording	
Proposed change	
Background information	



BCSA

BCSA Publication No. 67/23