

SECTION 05500

METAL FABRICATIONS

PART 1 - GENERAL

1.1 SUMMARY

- A. This Section includes the following:
1. Alternating Tread Stair.
 2. Loose steel lintels.
 3. Steel framing and supports for mechanical and electrical equipment.
 4. Handrails and railings attached to concrete stairs.
 5. Handrails and railings attached to steel balconies.
 6. Handrails attached to walls adjacent to stairs and ramps.
 7. Pipe bollards.

1.2 PERFORMANCE REQUIREMENTS

- A. Structural Performance of Railings: Provide railings capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
1. Handrails:
 - a. Uniform load of 50 lbf/ ft. (0.73 kN/ m) applied in any direction.
 - b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 2. Top Rails of Guards:
 - a. Uniform load of 50 lbf/ ft. (0.73 kN/m) applied in any direction.
 - b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 3. Infill of Guards:
 - a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
 - b. Uniform load of 25 lbf/sq. ft. (1.2 kN/sq. m) applied horizontally.
 - c. Infill load and other loads need not be assumed to act concurrently.

1.3 SUBMITTALS

- A. Product Data: For metal stairs and the following:
1. Alternating tread stair.
- B. Shop Drawings: Detail fabrication and erection of each metal fabrication indicated. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
1. Provide templates for anchors and bolts specified for installation under other Sections.
- C. Welding Certificates: Copies of certificates for welding procedures and personnel.

1.4 QUALITY ASSURANCE

- A. Fabricator Qualifications: A firm experienced in producing metal fabrications similar to those indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.
- B. Welding: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1, "Structural Welding Code--Steel."
 - 2. AWS D1.3, "Structural Welding Code--Sheet Steel."
 - 3. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.
- C. Regulatory Requirements: Comply with the Americans with Disabilities Act (ADA) and with code provisions as adopted by authorities having jurisdiction.
 - 1. Handrails: Provide handrails as required by accessibility regulations and requirements of authorities having jurisdiction. These include, but are not limited to, the following:
 - a. Size and Spacing of Handrails:
 - 1) Handrail Diameter: 1-1/4 to 1-1/2 inches (32 to 38 mm).
 - 2) Either round ends of handrails or return ends of handrails smoothly to floor, wall or post.
 - 3) Handrails shall not rotate within their fittings.
 - b. Locations of Handrails:
 - 1) Provide handrails at both sides of stairs.
 - 2) Provide continuous inside handrail on switchback or dogleg stairs.
 - 3) Provide continuous handrails on both sides of the stair. When handrails are not continuous, extend handrails at least 12 inches (300 mm) beyond the top riser and at least 12 inches (300 mm) plus the width of one tread beyond the bottom riser. At the top, the extension shall be parallel with the floor or ground surface. At the bottom, continue the handrail to slope for a distance of the width of one tread from the bottom riser; the remainder of the extension shall be horizontal.
 - 4) Mount the top of handrail gripping surface between 34 and 38 inches (865 and 965 mm) above stair nosing or ramp surface.
 - c. Structural Strength of Handrails: Refer to article in this section "Performance Requirements".
 - 2. Notify Architect of details or specifications not conforming to code.

1.5 PROJECT CONDITIONS

- A. Field Measurements: Where metal fabrications are indicated to fit walls and other construction, verify dimensions by field measurements before fabrication and indicate measurements on Shop Drawings. Coordinate fabrication schedule with construction progress to avoid delaying the Work.
 - 1. Established Dimensions: Where field measurements cannot be made without delaying the Work, establish dimensions and proceed with fabricating metal fabrications without field measurements. Coordinate construction to ensure that actual dimensions correspond to established dimensions. Allow for trimming and fitting.

1.6 COORDINATION

- A. Coordinate installation of anchorages for metal fabrications. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

PART 2 - PRODUCTS

2.1 MANUFACTURED UNITS

- A. Alternating Tread Stair: Provide ships ladders where shown on the drawings. Stairs shall conform to layout and dimensions indicated in drawings.
- B. Available Manufacturer: Lapeyre Stair, 220 Laitram Lane, LA 70123 (800 535-7631).
 - 1. Stair units shall be a complete assembly including stair, hand rails, platforms, supports, mounting and fastening devices.
 - 2. Treads: Capable of withstanding a concentrated load of 1000 lbs. Without deformation.
 - 3. Handrails: Capable of withstanding a concentrated load of 200 lbs. Applied in any direction and at any point on the rail.
 - 4. Finish: Safety yellow powder coat.

2.2 METALS, GENERAL

- A. Metal Surfaces, General: For metal fabrications exposed to view in the completed Work, provide materials with smooth, flat surfaces without blemishes. Do not use materials with exposed pitting, seam marks, roller marks, rolled trade names, or roughness.

2.3 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Steel Tubing: Cold-formed steel tubing complying with ASTM A 500.
- C. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- D. Steel Bars for Gratings: ASTM A 36/A 36M.
- E. Wire Rod for Grating Crossbars: ASTM A 510 (ASTM A 510M).
- F. Wire Cloth: Galvanized steel, 3/16 inch diameter wire, 1-1/2 inch opening, woven plain weave by McNichols Co. or approved substitute. Provide knuckled edges where indicated.
- G. Cast-in-Place Anchors in Concrete: Anchors of type indicated below, fabricated from corrosion-resistant materials capable of sustaining, without failure, the load imposed within a safety factor of 4, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.

1. Threaded or wedge type; galvanized ferrous castings, either ASTM A 47 (ASTM A 47M) malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, hot-dip galvanized per ASTM A 153/A 153M.
- H. Galvanized Steel Sheet: ASTM A 653/A 653M, G90 (Z275) coating, either commercial quality or structural quality, Grade 33 (Grade 230), unless another grade is required for design loads.
- I. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

2.4 PAINT

- A. Shop Primer for Ferrous Metal: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with performance requirements in FS TT-P-664; selected for good resistance to normal atmospheric corrosion, compatibility with finish paint systems indicated, and capability to provide a sound foundation for field-applied topcoats despite prolonged exposure.
- B. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- C. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12, except containing no asbestos fibers, or cold-applied asphalt emulsion complying with ASTM D 1187.

2.5 GROUT

- A. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.
 1. Available Products: Subject to compliance with requirements, products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Five Star Grout by Five Star Products, Inc.
 - b. Masterflow 928 Grout by Master Builders Technologies.
 - c. SonogROUT 10K by Sonneborn.
 - d. 14K Hy Flow by Sonneborn.

2.6 FASTENERS

- A. General: Provide Type 304 or 316 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 5, where built into exterior walls. Select fasteners for type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A (ASTM F 568M, Property Class 4.6); with hex nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.
- C. Anchor Bolts: ASTM F 1554, Grade 36.
- D. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).
- E. Lag Bolts: ASME B18.2.1 (ASME B18.2.3.8M).

- F. Wood Screws: Flat head, carbon steel, ASME B18.6.1.
- G. Plain Washers: Round, carbon steel, ASME B18.22.1 (ASME B18.22M).
- H. Lock Washers: Helical, spring type, carbon steel, ASME B18.21.1 (ASME B18.21.2M).
- I. Expansion Anchors: Anchor bolt and sleeve assembly of material indicated below with capability to sustain, without failure, a load equal to six times the load imposed when installed in unit masonry and equal to four times the load imposed when installed in concrete, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.
 - 1. Material: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.
 - 2. Available Products: Subject to compliance with requirements, products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Hilti Kwik-Bolt Stud Anchors
 - b. Red Head Wedge Anchors
 - c. Rawl Power-Fast Anchors
 - d. Fastenal Stud Anchors
- J. Toggle Bolts: FS FF-B-588, tumble-wing type, class and style as needed.
- K. Adhesive Anchors: Threaded anchors with a chemical capsule containing prepared amounts of liquid polyester resin, quartz aggregate, and a catalyst. Size and embedment depth shall be as noted on the drawings, or if not noted, as required to withstand required loading. Acceptable products include, but are not limited to:
 - 1. Available Products: Subject to compliance with requirements, products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Hilti HVA Adhesive Anchors
 - b. Red Head Redi-Chem Anchors
 - c. Rawl Needle-Capsule Anchors System
 - d. Fastenal Chemical Capsule Anchors
- L. Sleeve Anchors: Hilti with Hex Nut (HX). Provide tamperproof nut as indicated.
- M. Renovation Anchors: Hilti, HIT C-20 system, female type.

2.7 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
- B. Shear and punch metals cleanly and accurately. Remove burrs.
- C. Ease exposed edges to a radius of approximately 1/32 inch (1 mm), unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.

- D. Weld corners and seams continuously to comply with the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
 - E. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
 - F. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
 - G. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.
 - H. Allow for thermal movement resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening up of joints, overstressing of components, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
 - 1. Temperature Change (Range): 120 deg F (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.
 - I. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
 - J. Remove sharp or rough areas on exposed traffic surfaces.
 - K. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.
- 2.8 LOOSE STEEL LINTELS
- A. Fabricate loose structural-steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.
 - B. Weld adjoining members together to form a single unit where indicated.
 - C. Size loose lintels to provide bearing length at each side of openings equal to one-twelfth of clear span, but not less than 8 inches (200 mm), unless otherwise indicated.
 - D. Galvanize loose steel lintels located in exterior walls.
- 2.9 MISCELLANEOUS FRAMING AND SUPPORTS
- A. General: Provide steel framing and supports indicated and as necessary to complete the Work.

- B. Fabricate units from structural-steel shapes, plates, and bars of welded construction, unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction retained by framing and supports. Cut, drill, and tap units to receive hardware, hangers, and similar items.
 - 1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors 1-1/4 inches (32 mm) wide by 1/4 inch (6 mm) thick by 8 inches (200 mm) long at 24 inches (600 mm) o.c., unless otherwise indicated.
 - 2. Furnish inserts if units must be installed after concrete is placed.

2.10 STEEL TUBE HANDRAILS AND RAILINGS

- A. General: Fabricate handrails and railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.
 - 1. Configuration: As indicated on the drawings.
- B. Interconnect members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
 - 1. At tee and cross intersections, cope ends of intersecting members to fit contour of tube to which end is joined, and weld all around.
- C. Form changes in direction of handrails and rails as follows:
 - 1. As detailed.
 - 2. By bending.
 - 3. By flush-radius bends.
 - 4. By radius bends of radius indicated.
 - 5. By inserting prefabricated flush-elbow fittings.
 - 6. By any method indicated above, applicable to change of direction involved.
- D. Form simple and compound curves by bending members in jigs to produce uniform curvature for each repetitive configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- E. Close exposed ends of handrail and railing members with prefabricated end fittings.
- F. Brackets, Flanges, Fittings, and Anchors: Provide end closures, flanges, miscellaneous fittings, and anchors for interconnecting railings and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
- G. Fillers: Provide fillers made from steel plate, or other suitably crush-resistant material, where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses and to produce adequate bearing area to prevent bracket rotation and overstressing of substrate.
- H. For galvanized handrails and railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.

2.11 PIPE BOLLARDS

- A. Fabricate pipe bollards from Schedule 40 steel pipe.

2.12 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish metal fabrications after assembly.

2.13 STEEL AND IRON FINISHES

- A. Galvanizing: Provide coating for iron and steel fabrications applied by the hot-dipped process, Daltagalv by Duncan Galvanizing. The galvanizing bath shall contain high grade zinc and other earthly materials. Immediately before galvanizing, the steel shall be immersed in a bath of zinc ammonium chloride. The use of the wet kettle process is prohibited. Comply with ASTM A123 for fabricated products and ASTM A 153 for hardware. Provide thickness of galvanizing specified in referenced standards.
- B. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with minimum requirements indicated below for SSPC surface-preparation specifications and environmental exposure conditions of installed metal fabrications:
 - 1. Exteriors (SSPC Zone 1B): SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 2. Interiors (SSPC Zone 1A): SSPC-SP 3, "Power Tool Cleaning."
- C. Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finishes and those to be embedded in concrete, sprayed-on fireproofing, or masonry, unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1," for shop painting.
 - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal fabrications to in-place construction. Include threaded fasteners for concrete and masonry inserts, toggle bolts, through-bolts, lag bolts, wood screws, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.

- D. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- E. Field Welding: Comply with the following requirements:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with a heavy coat of bituminous paint.

3.2 INSTALLING ALTERNATING TREAD STAIR

- A. Install in strict accordance with stair manufacturers printed installation instructions.

3.3 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings, if any.

3.4 INSTALLING STEEL TUBE RAILINGS AND HANDRAILS

- A. Adjust handrails and railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and railing ends to building construction as follows:
 - 1. Anchor posts to concrete by core-drilling holes for posts and grouting posts to concrete base.
 - 2. Anchor posts to steel by welding directly to steel supporting members.
 - 3. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.

3.5 INSTALLING PIPE BOLLARDS

- A. Anchor bollards in place with concrete footings. Support and brace bollards in position in footing excavations until concrete has been placed and cured.
- B. Fill bollards solidly with concrete, mounding top surface.
 - 1. Do not fill removable bollards with concrete.

3.6 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 - 1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.
- B. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

3.7 WASTE MANAGEMENT

- A. Collect offcuts and scrap and place in designated areas for recycling.

END OF SECTION