

SECTION 05500
METAL FABRICATIONS

1 PART 1 GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to work of this Section.

1.2 SUMMARY

- A. This section includes the following metal fabrications:
1. Loose bearing and leveling plates.
 2. Miscellaneous framing and supports for the following:
 - a. Applications where framing and supports are not specified in other sections.
 3. Steel ladders.
 4. Steel pipe railings.
- B. Related Sections: The following sections contain requirements that relate to this section:
1. Division 5 Section "Structural Steel" for structural steel framing system components.

1.3 SYSTEM PERFORMANCE REQUIREMENTS

- A. Structural Performance: Design, engineer, fabricate, and install the following metal fabrications to withstand the following structural loads without exceeding the allowable design working stress of the materials involved, including anchors and connections. Apply each load to produce the maximum stress in each respective component of each metal fabrication.
- B. Top Rail of Guardrail Systems: Capable of withstanding the following loads applied as indicated:
1. Concentrated load of 200 lb applied at any point and in any direction.
 2. Uniform load of 50 lb per linear ft. applied horizontally and simultaneous uniform load of 100 lb per linear foot applied vertically downward at the top of the guard.
- D. Handrails Not Serving as Top Rails: Capable of withstanding the following loads applied as indicated:
1. Concentrated load of 200 lb applied at any point and in any direction.
 2. Uniform load of 50 lb per linear foot applied in any direction.

3. Concentrated and uniform loads above need not be assumed to act concurrently.
- E. Infill Area of Guardrail Systems: Capable of withstanding a horizontal normal load of 50 lb applied to one sq. ft. at any point in the system including panels, intermediate rails, balusters, or other elements composing the infill area.
1. Above load need not be assumed to act concurrently with loading conditions on guards or handrails.

1.4 SUBMITTALS

- A. General: Submit the following in accordance with Conditions of Contract and Division 1 Specification Sections.
- B. Product data for products used in miscellaneous metal fabrications, including paint products and grout.
- C. Shop drawings detailing 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. Provide templates for anchors and bolts specified for installation under other sections.
- D. Where installed metal fabrications are indicated to comply with certain design loadings, include structural computations, material properties, and other information needed for structural analysis that has been signed and sealed by the qualified professional engineer who was responsible for their preparation.
- E. Welder certificates signed by Contractor certifying that welders comply with requirements specified under "Quality Assurance" article.

1.5 QUALITY ASSURANCE

- A. Fabricator Qualifications: Firm experienced in successfully producing metal fabrications similar to that indicated for this Project, with sufficient production capacity to produce required units without causing delay in the Work.
- B. Qualify welding processes and welding operators in accordance with AWS D1.1 "Structural Welding Code - Steel," and D1.3 "Structural Welding Code - Sheet Steel."
- C. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.
- D. Engineer Qualifications: Professional engineer licensed to practice in jurisdiction where project is located and experienced in providing engineering services of the kind indicated that have resulted in the successful installation of metal fabrications similar in material, design, and extent to that indicated for this Project.

1.6 PROJECT CONDITIONS

- A. Field Measurements: Check actual locations of walls and other construction to which metal fabrications must fit, by accurate field measurements before fabrication; show recorded measurements on final shop drawings. Coordinate fabrication schedule with construction progress to avoid delay of Work.

1.7 SEQUENCING AND SCHEDULING

- A. Sequence and coordinate installation of handrails as follows:
 - 1. Mount handrails only on completed construction. Do not support handrails temporarily by any means not satisfying structural performance requirements.

2 PART 2 PRODUCTS

2.1 FERROUS METALS

- A. Metal Surfaces, General: For metal fabrications exposed to view upon completion of the Work, provide materials selected for their surface flatness, smoothness, and freedom from surface blemishes. Do not use materials whose exposed surfaces exhibit pitting, seam marks, roller marks, rolled trade names, roughness, and, for steel sheet, variations in flatness exceeding those permitted by reference standards for stretcher-leveled sheet.
- B. Steel Plates, Shapes, and Bars: ASTM A 36.
- C. Steel Tubing: ASTM A 513, Type 5, minimum 50 ksi yield strength.
- D. Steel Pipe: ASTM A53, Grade B, Schedule 40.
- E. Hollow Structural Sections: [ASTM A500, Grade B.] [ASTM A501.]
- F. Sheet Steel: ASTM A653/A653M, Grade 33 Structural Quality with galvanized coating.
- G. Handrail Fittings: Elbows, T-shapes, wall brackets, escutcheons; cast or machined steel.
- H. Anchor Rods: ASTM F1554; Grade 55, weldable.
 - 1. Shape: Straight.
- I. Brackets, Flanges and Anchors: Cast or formed metal of the same type material and finish as supported rails, unless otherwise indicated.
- J. Concrete Inserts: Threaded or wedge type; galvanized ferrous castings, either malleable iron, ASTM A 47, or cast steel, ASTM A 27. Provide bolts, washers, and shims as required, hot-dip galvanized per ASTM A 153.
- K. Welding Rods and Bare Electrodes: Select in accordance with AWS specifications for the metal alloy to be welded.

2.2 GROUT AND ANCHORING CEMENT

- A. Nonshrink Nonmetallic Grout: Premixed, factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with CE CRD-C 621. Provide grout specifically recommended by manufacturer for interior and exterior applications of type specified in this section.
- B. Erosion-Resistant Anchoring Cement: Factory-prepackaged, nonshrink, nonstaining, hydraulic controlled expansion cement formulation for mixing with water at Project site to create pourable anchoring, patching, and grouting compound. Provide formulation that

is resistant to erosion from water exposure without need for protection by a sealer or waterproof coating and is recommended for exterior use by manufacturer.

- C. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include but are not limited to the following:
1. Nonshrink Nonmetallic Grouts:
 - a. "Bonsal Construction Grout"; W. R. Bonsal Co.
 - b. "Diamond-Crete Grout"; Concrete Service Materials Co.
 - c. "Euco N-S Grout"; Euclid Chemical Co.
 - d. "Kemset"; Chem-Masters Corp.
 - e. "Crystex"; L & M Construction Chemicals, Inc.
 - f. "Masterflow 713"; Master Builders.
 - g. "Sealtight 588 Grout"; W. R. Meadows, Inc.
 - h. "SonogROUT"; Sonneborn Building Products Div., ChemRex Products, Inc.
 - i. "Stoncrete NM1"; Stonhard, Inc.
 - j. "Five Star Grout"; U. S. Grout Corp.
 - k. "Vibropruf #11"; Lambert Corp.
 2. Erosion-Resistant Anchoring Cement:
 - a. "Super Por-Rok"; Minwax Construction Products Division.

2.3 FASTENERS

- A. General: Provide hot dipped galvanized fasteners for exterior use or where built into exterior walls. Select fasteners for the type, grade, and class required.
- B. Bolts: ASTM A307; Grade A.
 1. Finish: Unfinished at interior applications. Hot dipped galvanized at exterior applications.
- C. Nuts: ASTM A563 heavy hex type.
 1. Finish: Unfinished at interior applications. Hot dipped galvanized at exterior applications.
- D. Washers: ASTM F436; Type 1.
 1. Finish: Unfinished at interior applications. Hot dipped galvanized at exterior applications.
- E. Drilled-In Expansion Anchors: Expansion anchors complying with FS FF-S- 325, Group VIII (anchors, expansion, [nondrilling]), Type I (internally threaded tubular expansion anchor); and machine bolts complying with FS FF- B-575, Grade 5.
- F. Lock Washers: Helical spring type carbon steel, FS FF-W-84.

2.4 PAINT

- A. Shop Primer for Ferrous Metal: Manufacturer's or fabricator's standard, fast-curing, lead-free, universal modified alkyd primer selected for good resistance to normal atmospheric corrosion, for compatibility with finish paint systems indicated, and for capability to provide a sound foundation for field-applied topcoats despite prolonged exposure complying with performance requirements of FS TT-P-645.

- B. Galvanizing Repair Paint: High zinc dust content paint for regalvanizing welds in galvanized steel, with dry film containing not less than 94 percent zinc dust by weight, and complying with DOD-P-21035 or SSPC-Paint- 20.
- C. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12 except containing no asbestos fibers.

2.5 CONCRETE FILL AND REINFORCING MATERIALS

- A. Concrete Materials and Properties: Comply with requirements of Division 3 section "Concrete Work" for normal weight, ready-mix concrete with minimum 28-day compressive strength of 2,500 psi, 440 lb cement per cu. ft. minimum, and W/C ratio of 0.65 maximum, unless higher strengths indicated.
- B. Reinforcing Bars: ASTM A 615, Grade 60, unless otherwise indicated.

2.6 FABRICATION, GENERAL

- A. Form metal fabrications from materials of size, thickness, and shapes indicated but not less than that needed to comply with performance requirements indicated. Work to dimensions indicated or accepted on shop drawings, using proven details of fabrication and support. Use type of materials indicated or specified for various components of each metal fabrication.
- B. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
- C. Shear and punch metals cleanly and accurately. Remove burrs.
- D. Ease exposed edges to a radius of approximately 1/32 inch, unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- E. Remove sharp or rough areas on exposed traffic surfaces.
- F. Weld corners and seams continuously to comply with AWS recommendations and 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 that no roughness shows after finishing and contour of welded surface matches those adjacent.
- G. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners wherever possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.

- H. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to provide adequate support for intended use.
- I. 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.
- J. Cut, reinforce, drill and tap miscellaneous metal work as indicated to receive finish hardware, screws, and similar items.

2.7 ROUGH HARDWARE

- A. Furnish bent or otherwise custom fabricated bolts, plates, anchors, hangers, dowels, and other miscellaneous steel and iron shapes as required for framing and supporting woodwork, and for anchoring or securing woodwork to concrete or other structures. Straight bolts and other stock rough hardware items are specified in Division 6 sections.
- B. Fabricate items to sizes, shapes, and dimensions required.

2.8 STEEL LADDERS

- A. General: Fabricate ladders for the locations shown, with dimensions, spacings, details and anchorages as indicated. Comply with requirements of ANSI A14.3.
- B. Siderails: Continuous steel flat bars, 1/2 inch x 2-1/2 inches, with eased edges, spaced 18 inches apart.
- C. Bar Rungs: Square steel bars, 3/4 inch, spaced 12 inches oc.
- D. Fit rungs in centerline of side rails, plug weld and grind smooth on outer rail faces.
- E. Support each ladder at top and bottom and at intermediate points spaced not more than 5'-0" oc. by means of welded or bolted steel brackets.
- F. Size brackets to support design dead and live loads indicated and to hold centerline of ladder rungs clear of the wall surface by not less than 7 inches.
- G. Provide non-slip surface on top of each rung, either by coating the rung with aluminum oxide granules set in epoxy resin adhesive, or by using a type of manufactured rung which is filled with aluminum oxide grout.

2.9 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction, made flat, free from warps or twists, and of required thickness and bearing area. Drill plates to receive anchor bolts and for grouting as required. Galvanize after fabrication.

2.10 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports for applications indicated or which are not a part of structural steel framework, as required to complete work.

- B. Fabricate units to sizes, shapes, and profiles indicated and required to receive adjacent other construction retained by framing and supports. Fabricate from structural steel shapes, plates, and steel bars of welded construction using mitered joints for field connection. Cut, drill, and tap units to receive hardware, hangers, and similar items.

2.11 STEEL PIPE RAILINGS AND HANDRAILS

- A. General: Fabricate pipe railings and handrails to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of pipe, post spacings, and anchorage, but not less than that required to support structural loads.
- B. Interconnect railing and handrail members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
- C. At tee and cross intersections, notch ends of intersecting members to fit contour of pipe to which end is joined and weld all around.
- D. Form simple and compound curves by bending pipe in jigs to produce uniform curvature for each repetitive configuration required; maintain cylindrical cross-section of pipe throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of pipe.
- E. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated.
- F. Close exposed ends of pipe by welding 3/16 inch thick steel plate in place or by use of prefabricated fittings.
- G. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnections of pipe and attachment of railings and handrails to other work. Furnish inserts and other anchorage devices for connecting railings and handrails to concrete or masonry work.
- H. For railing posts set in concrete fabricate sleeves from steel pipe not less than 6 inches long and with an inside diameter not less than 1/2 inch greater than the outside diameter of post, with steel plate closure welded to bottom of sleeve.
- I. Fillers: Provide steel sheet or plate fillers of thickness and size indicated or required to support structural loads of handrails where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses. Size fillers to produce adequate bearing to prevent bracket rotation and overstressing of substrate.

2.12 PIPE BOLLARDS

- A. Fabricate pipe bollards from Schedule 80 steel pipe. Fill bollards with 3000 psi strength concrete. Shape top of concrete into half sphere shape.

2.13 FINISHES, GENERAL

- A. Comply with NAAMM "Metal Finishes Manual" for recommendations relative to application and designations of finishes.
- B. Finish metal fabrications after assembly.

2.17 STEEL AND IRON FINISHES

- A. 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-SP6 "Commercial Blast Cleaning."
Interiors (SSPC Zone 1A): SSPC-SP3 "Power Tool Cleaning:"
- B. Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finish or to be embedded in concrete, sprayed-on fireproofing, or masonry, unless otherwise indicated. Comply with requirements of SSPC-PA1 "Paint Application Specification No. 1" for shop painting.
- C. Galvanizing: For those items indicated for galvanizing, apply zinc-coating by the hot-dip process compliance with the following requirements:
 - 1. ASTM A 153 for galvanizing iron and steel hardware.
 - 2. ASTM A123 for galvanizing both fabricated and unfabricated iron and steel products made of uncoated rolled, pressed, and forged shapes, plates, bars, and strip 0.0299 inch thick and heavier.

3 PART 3 EXECUTION

3.1 PREPARATION

- A. Coordinate and furnish anchorages, setting drawings, diagrams, templates, instructions, and directions for installation of anchorages, including concrete inserts, sleeves, anchor bolts, and miscellaneous items having integral anchors that are to be embedded in concrete or masonry construction. Coordinate delivery of such items to project site.
- B. Set sleeves in concrete with tops flush with finish surface elevations; protect sleeves from water and concrete entry.

3.2 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing miscellaneous 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 as required.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installation of miscellaneous metal fabrications. Set metal fabrication 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 the surfaces of exterior units which have been hot-dip galvanized after fabrication, and are intended for bolted or screwed field connections.

- E. Field Welding: Comply with AWS Code for procedures of manual shielded metal-arc welding, appearance and quality of welds made, methods used in correcting welding work, and 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 that no roughness shows after finishing and contour of welded surface matches those adjacent.

3.3 SETTING LOOSE PLATES

- A. Clean concrete and masonry bearing surfaces of any bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of bearing plates.
- B. Set loose leveling and bearing plates on wedges, or other adjustable devices. After the bearing members have been positioned and plumbed, tighten the anchor bolts. Do not remove wedges or shims, but if protruding, cut off flush with the edge of the bearing plate before packing with grout.
1. Use nonmetallic nonshrink grout, unless otherwise indicated.
 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.4 INSTALLATION OF STEEL PIPE RAILINGS AND HANDRAILS

- A. Adjust railings prior to anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated, or if not indicated, as required by design loadings. Plumb posts in each direction. Secure posts and railing ends to building construction.
- B. Secure handrails to wall with wall brackets and end fittings. Provide bracket with 1-1/2 inch clearance from inside face of handrail and finished wall surface. Locate brackets as indicated, or if not indicated, at spacing required to support structural loads. Secure wall brackets and wall return fittings to building construction.
- C. For steel framed gypsum board assemblies, fasten brackets directly to steel framing or concealed anchors using self-tapping screws of size and type required to support structural loads.
- D. Set handrail and guardrail posts in sleeves cast into concrete, and fill annular space around posts with non-shrink non-metallic grout.

3.5 INSTALLATION OF BOLLARDS

- A. Anchor bollards in concrete footings set below frost level.

3.6 ADJUSTING AND CLEANING

- A. Touch-Up Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting to comply with SSPC-PA 1 requirements for touch-up of field painted surfaces.
- B. Apply by brush or spray to provide a minimum dry film thickness of 2.0 mils.
- C. For galvanized surfaces clean welds, bolted connections and abraded areas and apply galvanizing repair paint to comply with ASTM A 780.

...END OF SECTION