

SECTION 05 50 00 - METAL FABRICATIONS

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:Stainless steel wall base.

2. Steel framing and supports for ceiling-hung toilet compartments.
3. Steel framing and supports for countertops.
4. Steel framing and supports for mechanical and electrical equipment.
5. Steel framing and supports for applications where framing and supports are not specified in other Sections.
6. Elevator machine beams, hoist beams, and divider beams.
7. Steel shapes for supporting elevator door sills.
8. Shelf angles.
9. Metal ladders.
10. Ladder safety cages.
11. Miscellaneous steel trim including steel angle corner guards, steel edgings.
12. Metal bollards.
13. Loose bearing and leveling plates for applications where they are not specified in other Sections.
14. Metal bar gratings.

B. Products furnished, but not installed, under this Section:

1. Loose steel lintels.
2. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
3. Steel weld plates and angles for casting into concrete for applications where they are not specified in other Sections.

C. Related Requirements:

1. Section 03 30 00 "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.
2. Section 04 20 00 "Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
3. Section 05 12 00 "Structural Steel Framing."
4. Section 05 51 00 "Metal Stairs."

1.2 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages and steel weld plates and angles for casting into concrete. 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.

1.3 ACTION SUBMITTALS

- A. Product Data: For the following:
 - 1. Nonslip aggregates and nonslip-aggregate surface finishes.
 - 2. Metal nosings and treads.
 - 3. Paint products.
 - 4. Grout.
 - 5. Bar Grating
- B. Shop Drawings: Show fabrication and installation details for metal fabrications.
 - 1. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
- C. Samples for Verification: For each type and finish of extruded nosing and tread.
- D. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.4 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For qualified professional engineer.
- B. Mill Certificates: Signed by manufacturers of stainless-steel certifying that products furnished comply with requirements.
- C. Welding certificates.
- D. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.5 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- B. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 - 2. AWS D1.2/D1.2M, "Structural Welding Code - Aluminum."
 - 3. AWS D1.6, "Structural Welding Code - Stainless Steel."
- C. Metal Bar Grating Standards: Comply with NAAMM MBG 531, "Metal Bar Grating Manual" and NAAMM MBG 532, "Heavy-Duty Metal Bar Grating Manual."

1.6 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication.

1.7 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages for gratings, grating frames, and supports. 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 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Design ladders, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.
- B. Delegated Design: Design gratings, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.
 - 1. Structural Performance: Gratings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated.

- a. Walkways and Elevated Platforms Other Than Exits: Uniform load of 60 lbf/sq. ft. (2.87 kN/sq. m).
 - b. Limit deflection to L/240 or 1/4 inch (6.4 mm), whichever is less.
- C. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.
1. Temperature Change: 120 deg F (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.

2.2 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces unless otherwise indicated. For metal fabrications exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.

2.3 FERROUS METALS

- A. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of pre-consumer recycled content not less than 25 percent.
- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Stainless-Steel Sheet, Strip, and Plate: ASTM A 240/A 240M or ASTM A 666, Type 304.
- D. Stainless-Steel Bars and Shapes: ASTM A 276, Type 304.
- E. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
- F. Rolled-Stainless-Steel Floor Plate: ASTM A 793.
- G. Abrasive-Surface Floor Plate: Steel plate with abrasive material metallurgically bonded to steel.
1. Products: Subject to compliance with requirements, provide one of the following:
 - a. IKG Industries, a division of Harsco Corporation; Mebac.
 - b. SlipNOT Metal Safety Flooring, a W. S. Molnar company; SlipNOT.
- H. Steel Tubing: ASTM A 500, cold-formed steel tubing.
- I. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40) unless otherwise indicated.

- J. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.
 - 1. Size of Channels: 1-5/8 by 1-5/8 inches (41 by 41 mm).
 - 2. Material: Galvanized steel, ASTM A 653/A 653M, structural steel, Grade 33 (Grade 230), with G90 (Z275) coating; 0.064-inch (1.6-mm) nominal thickness.

2.4 NONFERROUS METALS

- A. Aluminum Plate and Sheet: ASTM B 209 (ASTM B 209M), Alloy 6061-T6.
- B. Aluminum Extrusions: ASTM B 221 (ASTM B 221M), Alloy 6063-T6.
- C. Aluminum-Alloy Rolled Tread Plate: ASTM B 632/B 632M, Alloy 6061-T6.
- D. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

2.5 FASTENERS

- A. General: Unless otherwise indicated, provide Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, at interior walls. Select fasteners for type, grade, and class required.
 - 1. Provide stainless-steel fasteners for fastening aluminum.
 - 2. Provide stainless-steel fasteners for fastening stainless steel.
- B. Steel 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 flat washers.
- C. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593 (ASTM F 738M); with hex nuts, ASTM F 594 (ASTM F 836M); and, where indicated, flat washers; Alloy Group 1 (A1).
- D. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; and, where indicated, flat washers.
 - 1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.
- E. Eyebolts: ASTM A 489.
- F. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).
- G. Lag Screws: ASME B18.2.1 (ASME B18.2.3.8M).
- H. Wood Screws: Flat head, ASME B18.6.1.

- I. Plain Washers: Round, ASME B18.22.1 (ASME B18.22M).
- J. Lock Washers: Helical, spring type, ASME B18.21.1 (ASME B18.21.2M).
- K. Anchors, General: Anchors capable of sustaining, without failure, a load equal to six times the load imposed when installed in unit masonry and four times the load imposed when installed in concrete, as determined by testing according to ASTM E 488, conducted by a qualified independent testing agency.
- L. Cast-in-Place Anchors in Concrete: Either threaded type or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A 47/A 47M malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F 2329.
- M. Post-Installed Anchors: chemical anchors.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).
- N. Slotted-Channel Inserts: Cold-formed, hot-dip galvanized-steel box channels (struts) complying with MFMA-4, 1-5/8 by 7/8 inches (41 by 22 mm) by length indicated with anchor straps or studs not less than 3 inches (75 mm) long at not more than 8 inches (200 mm) o.c. Provide with temporary filler and tee-head bolts, complete with washers and nuts, all zinc-plated to comply with ASTM B 633, Class Fe/Zn 5, as needed for fastening to inserts.

2.6 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Shop Primers: Provide primers that comply with Section 09 91 23 Interior Painting."
- C. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.
 - 1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.
- D. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.
 - 1. Products: Subject to compliance with requirements, provide one of the following:
 - a. SikaCor Zinc R or Equal.

- E. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- F. Non-shrink, Metallic Grout: Factory-packaged, ferrous-aggregate grout complying with ASTM C 1107, specifically recommended by manufacturer for heavy-duty loading applications.
- G. Non-shrink, Nonmetallic Grout: Factory-packaged, non-staining, noncorrosive, nongaseous grout complying with ASTM C 1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- H. Concrete: Comply with requirements in Section 03 30 00 "Cast-in-Place Concrete" for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa).

2.7 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in the shop to greatest extent possible. 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. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch (1 mm) unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- C. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- D. Form exposed work with accurate angles and surfaces and straight edges.
- E. Fit exposed connections accurately together to form hairline joints.
- F. 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.
- G. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners or welds where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) fasteners unless otherwise indicated. Locate joints where least conspicuous.

- H. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- I. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- J. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
 - 1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches (3.2 by 38 mm), with a minimum 6-inch (150-mm) embedment and 2-inch (50-mm) hook, not less than 8 inches (200 mm) from ends and corners of units and 24 inches (600 mm) o.c., unless otherwise indicated.
 - 2. Fabricate grating toeplates for attaching in the field.
 - a. Toeplate Height: 4 inches (100 mm) unless otherwise indicated.

2.8 METAL BAR GRATINGS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. All American Grating.
 - 2. BarnettBates Corporation.
 - 3. Borden Metal Products (Canada) Limited.
 - 4. Fisher & Ludlow; Division of Harris Steel Limited.
 - 5. Grating Pacific, Inc.
 - 6. Grupo Metelmex, S.A. de C.V.
 - 7. IKG Industries; a division of Harsco Corporation.
 - 8. Marwas Steel Co.; Laurel Steel Products Division.
 - 9. Ohio Gratings, Inc.
 - 10. Seidelhuber Metal Products; Division of Brodhead Steel Products.
- B. MBG-1, Welded Steel Grating
 - 1. Bearing Bar Spacing: 1-3/16 inches (30 mm)
 - 2. Bearing Bar Depth: 1-1/4 inches (32 mm)
 - 3. Bearing Bar Thickness: 3/16 inch (4.8 mm)
 - 4. Crossbar Spacing: 2 inches (51 mm)
 - 5. Traffic Surface: Applied abrasive finish consisting of aluminum-oxide aggregate in an epoxy-resin adhesive.
 - 6. Steel Finish: Hot-dip galvanized with a coating weight of not less than 1.8 oz./sq. ft. (550 g/sq. m) of coated surface.

2.9 GRATING FRAMES AND SUPPORTS

- A. Frames and Supports for Metal Gratings: Fabricate from metal shapes, plates, and bars of welded construction to sizes, shapes, and profiles indicated and as necessary to receive gratings. Miter and weld connections for perimeter angle frames. Cut, drill, and tap units to receive hardware and similar items.
 - 1. Unless otherwise indicated, fabricate from same basic metal as gratings.
 - 2. Unless otherwise indicated, space anchors 24 inches (600 mm) o.c. and provide minimum anchor units in the form of steel straps 1-1/4 inches (32 mm) wide by 1/4 inch (6 mm) thick by 8 inches (200 mm) long.
- B. Galvanize steel frames and supports in the following locations:
 - 1. Exterior.

2.10 SB-1, METAL BASE

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. DiamondLife, Base Molding MX
 - 2. Equal as approved by Architect.
- B. Form metal base from metal of type and thickness indicated below:
 - 1. Stainless-Steel Sheet: 0.030 inch (1.27 mm) minimum.
 - 2. Height as indicated on Drawings
 - 3. Finish: No. 4, brushed.
 - 4. Preformed inside and outside corners.

2.11 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports not specified in other Sections as needed to complete the Work.
- B. Fabricate units from 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.
 - 1. Fabricate units from slotted channel framing where indicated.
 - 2. Furnish inserts for units installed after concrete is placed.
- C. Fabricate supports for operable partitions from continuous steel beams of sizes indicated with attached bearing plates, anchors, and braces as indicated. Drill or punch bottom flanges of beams to receive partition track hanger rods; locate holes where indicated on operable partition Shop Drawings.

- D. Fabricate steel girders for wood frame construction from continuous steel shapes of sizes indicated.
 - 1. Provide bearing plates welded to beams where indicated.
 - 2. Drill or punch girders and plates for field-bolted connections where indicated.
 - 3. Where wood nailer's are attached to girders with bolts or lag screws, drill or punch holes at 24 inches (600 mm) o.c.
- E. Fabricate steel pipe columns for supporting wood frame construction from steel pipe with steel baseplates and top plates as indicated. Drill or punch baseplates and top plates for anchor and connection bolts and weld to pipe with fillet welds all around. Make welds the same size as pipe wall thickness unless otherwise indicated.
 - 1. Unless otherwise indicated, fabricate from Schedule 40 steel pipe.
 - 2. Unless otherwise indicated, provide 1/2-inch (12.7-mm) baseplates with four 5/8-inch (16-mm) anchor bolts and 1/4-inch (6.4-mm) top plates.
- F. Galvanize miscellaneous framing and supports where indicated.
- G. Prime miscellaneous framing and supports with [zinc-rich primer] [primer specified in Section 09 96 00 "High-Performance Coatings"] where indicated.

2.12 SHELF ANGLES

- A. Fabricate shelf angles from steel angles of sizes indicated and for attachment to concrete framing. Provide horizontally slotted holes to receive 3/4-inch (19-mm) bolts, spaced not more than 6 inches (150 mm) from ends and 24 inches (600 mm) o.c., unless otherwise indicated.
 - 1. Provide mitered and welded units at corners.
 - 2. Provide open joints in shelf angles at expansion and control joints. Make open joint approximately 2 inches (50 mm) larger than expansion or control joint.
- B. For cavity walls, provide vertical channel brackets to support angles from backup masonry and concrete.
- C. Galvanize shelf angles located in exterior walls.
- D. Prime shelf angles located in exterior walls with zinc-rich primer.
- E. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.

2.13 METAL LADDERS

- A. General:
 - 1. Comply with ANSI A14.3 unless otherwise indicated.

2. For elevator pit ladders, comply with ASME A17.1.

B. Steel Ladders:

1. Space side rails 18 inches (457 mm) apart unless otherwise indicated.
2. Rungs: 1-inch- (25-mm-) square] steel bars.
3. Fit rungs in centerline of side rails; plug-weld and grind smooth on outer rail faces.
4. Provide nonslip surfaces on top of each rung, either by coating rung with aluminum-oxide granules set in epoxy-resin adhesive or by using a type of manufactured rung filled with aluminum-oxide grout.
5. Provide nonslip surfaces on top of each rung by coating with abrasive material metallically bonded to rung.
 - a. Products: Subject to compliance with requirements, provide one of the following:
 - 1) IKG Industries, a division of Harsco Corporation; Mebac.
 - 2) SlipNOT Metal Safety Flooring, a W. S. Molnar company; SlipNOT.
6. Provide platforms as indicated fabricated from welded or pressure-locked steel bar grating, supported by steel angles. Limit openings in gratings to no more than 3/4 inch (19 mm) in least dimension.
7. Support each ladder at top and bottom and not more than 60 inches (1500 mm) o.c. with welded or bolted steel brackets.
8. Galvanize exterior ladders, including brackets and fasteners.

2.14 LADDER SAFETY CAGES

A. General:

1. Fabricate ladder safety cages to comply with ANSI A14.3. Assemble by welding or with stainless-steel fasteners.
2. Provide primary hoops at tops and bottoms of cages and spaced not more than 20 feet (6 m) o.c. Provide secondary intermediate hoops spaced not more than 48 inches (1200 mm) o.c. between primary hoops.
3. Fasten assembled safety cage to ladder rails and adjacent construction by welding or with stainless-steel fasteners unless otherwise indicated.

B. Steel Ladder Safety Cages:

1. Primary Hoops: 1/4-by-4-inch (6.4-by-100-mm) flat bar hoops.
2. Secondary Intermediate Hoops: 1/4-by-2-inch (6.4-by-50-mm) flat bar hoops.
3. Vertical Bars: 3/16-by-1-1/2-inch (4.8-by-38-mm) flat bars secured to each hoop.
4. Galvanize ladder safety cages, including brackets and fasteners.

2.15 METAL FLOOR PLATE

- A. Fabricate from rolled-steel floor abrasive-surface floor plate of thickness indicated below:
 - 1. Thickness: 3/8 inch (9.5 mm).
- B. Provide steel angle supports as indicated.
- C. Include steel angle stiffeners, and fixed and removable sections as indicated.
- D. Provide flush steel bar drop handles for lifting removable sections, one at each end of each section.

2.16 MISCELLANEOUS STEEL TRIM

- A. Unless otherwise indicated, fabricate units from steel shapes, plates, and bars of profiles shown with continuously welded joints and smooth exposed edges. Miter corners and use concealed field splices where possible.
- B. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work.
 - 1. Provide with integrally welded steel strap anchors for embedding in concrete or masonry construction.
- C. Galvanize exterior miscellaneous steel trim.

2.17 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 80 steel pipe 1/4-inch (6.4-mm) wall-thickness rectangular steel tubing.
 - 1. Cap bollards with 1/4-inch- (6.4-mm-) thick steel plate.
 - 2. Where bollards are indicated to receive controls for door operators, provide necessary cutouts for controls and holes for wire.
 - 3. Where bollards are indicated to receive light fixtures, provide necessary cutouts for fixtures and holes for wire.
- B. Fabricate internal sleeves for removable bollards from Schedule 40 steel pipe or 1/4-inch (6.4-mm) wall-thickness steel tubing with an OD approximately 1/16 inch (1.5 mm) less than ID of bollards. Match drill sleeve and bollard for 3/4 inch (19 mm) steel machine bolt.
- C. Prime bollards with zinc-rich primer.

2.18 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts and for grouting.
- B. Galvanize plates.
- C. Prime plates with zinc-rich primer.

2.19 LOOSE STEEL LINTELS

- A. Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated. Fabricate in single lengths for each opening unless otherwise indicated. Weld adjoining members together to form a single unit where indicated.
- B. Size loose lintels to provide bearing length at each side of openings equal to 1/12 of clear span but not less than 8 inches (200 mm) unless otherwise indicated.
- C. Galvanize loose steel lintels located in exterior walls.
- D. Prime loose steel lintels located in exterior walls with zinc-rich primer.

2.20 STEEL WELD PLATES AND ANGLES

- A. Provide steel weld plates and angles not specified in other Sections, for items supported from concrete construction as needed to complete the Work. Provide each unit with no fewer than two integrally welded steel strap anchors for embedding in concrete.

2.21 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.
- C. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.22 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.
 - B. Shop prime iron and steel items not indicated to be galvanized unless they are to be embedded in concrete, sprayed-on fireproofing, or masonry, or unless otherwise indicated.
 1. Shop prime with [universal shop primer] [primers specified in Section 09 91 13 "Exterior Painting"] [primers specified in Section 09 91 23 "Interior Painting"] unless [zinc-rich primer is] [primers specified in Section 09 96 00 "High-Performance Coatings" are] indicated.
 - C. Preparation for Shop Priming: Prepare surfaces to comply with [SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."] [SSPC-SP 3, "Power Tool Cleaning."] [requirements indicated below:]
 1. Exterior Items: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 2. Items Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 3. Items Indicated to Receive Primers Specified in Section 099600 "High-Performance Coatings": SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 4. Other Items: SSPC-SP 3, "Power Tool Cleaning."
 - D. Shop Priming: Apply shop primer to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.
 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.
- 2.23 ALUMINUM FINISHES
- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
 - B. As-Fabricated Finish: AA-M10 (Mechanical Finish: as fabricated, unspecified).
 - C. Class I, Clear Anodic Finish: AA-M12C22A41 (Mechanical Finish: non-specular as fabricated; Chemical Finish: etched, medium matte; Anodic Coating: Architectural Class I, clear coating 0.018 mm or thicker) complying with AAMA 611.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. 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.

- B. 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.
- C. 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.
- D. Fastening to In-Place Construction: Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction. Provide threaded fasteners for use with concrete and masonry inserts, toggle bolts, through bolts, lag screws, wood screws, and other connectors.
- E. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with the following:
 - 1. Cast Aluminum: Heavy coat of bituminous paint.
 - 2. Extruded Aluminum: Two coats of clear lacquer.

3.2 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.
- B. Anchor supports for operable partitions securely to and rigidly brace from building structure.
- C. Support steel girders on solid grouted masonry, concrete, or steel pipe columns. Secure girders with anchor bolts embedded in grouted masonry or concrete or with bolts through top plates of pipe columns.

1. Where grout space under bearing plates is indicated for girders supported on concrete or masonry, install as specified in "Installing Bearing and Leveling Plates" Article.
- D. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified in "Installing Bearing and Leveling Plates" Article.
1. Grout baseplates of columns supporting steel girders after girders are installed and leveled.
- 3.3 INSTALLING PREFABRICATED BUILDING COLUMNS
- A. Install prefabricated building columns to comply with AISC's "Specification for Structural Steel Buildings" and with requirements applicable to listing and labeling for fire-resistance rating indicated.
- 3.4 INSTALLING METAL BOLLARDS
- A. Fill metal-capped bollards solidly with concrete and allow concrete to cure seven days before installing.
1. Do not fill removable bollards with concrete.
- B. Anchor internal sleeves for removable bollards in place with concrete footings. Center and align sleeves in holes 3 inches (75 mm) above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace sleeves in position until concrete has cured.
- C. Place removable bollards over internal sleeves and secure with 3/4-inch (19-mm) machine bolts and nuts. After tightening nuts, drill holes in bolts for inserting padlocks. Owner will furnish padlocks.
1. Do not fill removable bollards with concrete.
- 3.5 INSTALLING NOSINGS, TREADS, AND THRESHOLDS
- A. Center nosing's on tread widths unless otherwise indicated.
- B. For nosing's embedded in concrete steps or curbs, align nosing's flush with riser faces and level with tread surfaces.
- C. Seal thresholds exposed to exterior with elastomeric sealant complying with Section 07 92 00 "Joint Sealants" to provide a watertight installation.

3.6 INSTALLING METAL GRATINGS

- A. General: Install gratings to comply with recommendations of referenced metal bar grating standards that apply to grating types and bar sizes indicated, including installation clearances and standard anchoring details.
- B. Attach removable units to supporting members with type and size of clips and fasteners indicated or, if not indicated, as recommended by grating manufacturer for type of installation conditions shown.
- C. Attach nonremovable units to supporting members by welding where both materials are same; otherwise, fasten by bolting as indicated above.
- D. Attach toeplates to gratings by welding at locations indicated.

3.7 INSTALLING BEARING AND LEVELING PLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of plates.
- B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.
 - 1. Use non-shrink grout, either metallic or nonmetallic, in concealed locations where not exposed to moisture; use non-shrink, nonmetallic grout in exposed locations unless otherwise indicated.
 - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.8 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded 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. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in "Section 09 91 23 "Interior Painting."
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

Maine Medical Center
Bean 2 Roof Addition
For Construction
Addendum No. 2
Issued for Permit

PERKINS+WILL
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END OF SECTION