

## SECTION 05500

### METAL FABRICATIONS

#### PART 1 - GENERAL

##### 1.01 RELATED DOCUMENTS

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

##### 1.02 SUMMARY

- A. This Section includes the following:
  - 1. Ladders (including elevator pit ladders).
  - 2. Steel framed stairs.
  - 3. Steel pipe railings, handrails, and guardrails.
  - 4. Loose steel lintels.
  - 5. Steel framing and supports for the following:
    - a. Architectural security grilles (screens).
    - b. Roof openings.
    - c. Elevator door sills.
    - d. Steel framing and supports for mechanical and electrical equipment.
    - e. Steel framing and supports for applications where framing and supports are not specified in other Sections.
  - 6. Metal bollards.
  - 7. Miscellaneous fabrications:
    - a. Countertop supports.
    - b. Sump pit cover and support.
  - 8. Rough hardware.
- B. Products furnished, but not installed, under this Section include the following:
  - 1. Loose steel lintels.
  - 2. Anchor bolts, steel pipe sleeves, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
- C. Related Sections include the following:
  - 1. Division 3 Section "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, wedge-type inserts and other items indicated to be cast into concrete and for concrete fill for stair treads and platforms.
  - 2. Division 4 Section "Unit Masonry Assemblies" for installing loose lintels, anchor bolts, and other items indicated to be built into unit masonry.
  - 3. Division 5 Section "Structural Steel."
  - 4. Division 6 Section "Rough Carpentry" for concealed wood blocking for anchoring railings attached to walls.
  - 5. Division 6 Section "Architectural Woodwork" for manufactured countertop supports.
  - 6. Division 10 Section "Architectural Screens and Grilles" for aluminum security screens.

##### 1.03 PERFORMANCE REQUIREMENTS

- A. Structural Performance of Stairs: Provide metal stairs capable of withstanding the effects of gravity loads, IBC 2003 requirements, and the following loads and stresses within limits and under conditions indicated:
  - 1. Uniform Load: 100 lbf/sq. ft.
  - 2. Concentrated Load: 300 lbf applied on an area of 4 sq. in.
  - 3. Uniform and concentrated loads need not be assumed to act concurrently.
  - 4. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.

5. Limit deflection of treads, platforms, and framing members to L/360 or **1/4 inch**, whichever is less.
  
- B. Structural Performance of Railings: Provide railings capable of withstanding the effects of gravity loads, IBC 2003 requirements, and the following loads and stresses within limits and under conditions indicated:
  1. Handrails:
    - a. Uniform load of **50 lbf/ ft.** applied in any direction.
    - b. Concentrated load of **200 lbf** 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. applied in any direction.
    - b. Concentrated load of **200 lbf** 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 applied horizontally on an area of **1 sq. ft.**
    - b. Uniform load of **25 lbf/ ft.** applied horizontally.
    - c. Infill load and other loads need not be assumed to act concurrently.
  
- C. Structural Performance of Ladders: Provide ladders capable of withstanding the effects of loads and stresses within limits and under conditions specified in ANSI A14.3.
  
- D. Thermal Movements: Provide exterior metal fabrications that allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening 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, ambient; 180 deg F, material surfaces.

#### 1.04 SUBMITTALS

- A. General: Submit in accordance with Section 01300.
  
- B. Product Data: For the following:
  1. Metal stairs.
  2. Paint products.
  3. Grout.
  
- C. Shop Drawings: Show fabrication and installation details for stairs, railings, infill system, guardrails, and metal fabrications.
  1. Include plans, elevations, sections, and details of stairs, railings, infill system, guardrails, and metal fabrications and their connections. Show anchorage and accessory items.
  2. Provide templates for anchors and bolts specified for installation under other Sections.
  3. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
  
- D. Stair Calculations: Designed and engineered by a qualified professional engineer responsible for their preparation. Submittal shall be signed and stamped by engineer.
  
- E. Welding Certificates: Signed by Contractor certifying that welders comply with requirements specified under the "Quality Assurance" Article.

#### 1.05 QUALITY ASSURANCE

- A. Fabricator Qualifications: Firm experienced in producing metal fabrications similar to those indicated for this Project with a record of successful in-service performance, and with sufficient production capacity to produce required units without delaying the Work.

- B. Professional Engineer Qualifications: Professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of kind indicated. Engineering services are defined as those performed for design of concrete filled steel pan stairs that are similar to those indicated for this Project in material, design, and extent.
- C. 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 re-certification.

#### 1.06 PROJECT CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication and indicate measurements on Shop Drawings.
  - 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 wall and other contiguous construction to ensure that actual dimensions correspond to established dimensions.
  - 2. Provide allowance for trimming and fitting at site.

#### 1.07 COORDINATION

- A. Coordinate installation of anchorages for metal fabrications and metal stairs. 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

#### 2.01 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.

#### 2.02 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
  - 1. Galvanized finish for exterior installations and where indicated.
- B. Steel Tubing: Product type (manufacturing method) and as follows:
  - 1. Cold-Formed Steel Tubing: ASTM A 500.
  - 2. Hot-Formed Steel Tubing: ASTM A 501.
  - 3. For exterior installations and where indicated, provide tubing with hot-dip galvanized coating per ASTM A 53.
- C. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
  - 1. Black finish, unless otherwise indicated.
  - 2. Galvanized finish for exterior installations and where indicated.

#### 2.03 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, Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.

- B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, nuts and, where indicated, flat washers; ASTM F 593 for bolts and ASTM F 594 for nuts, Alloy Group 1.
- D. Anchor Bolts: ASTM F 1554, Grade 36.
  - 1. Provide hot-dip or mechanically deposited, zinc-coated anchor bolts where item being fastened is indicated to be galvanized.
- E. Eyebolts: ASTM A 489.
- F. Machine Screws: ASME B18.6.3.
- G. Lag Bolts: ASME B18.2.1.
- H. Wood Screws: Flat head, ASME B18.6.1.
- I. Plain Washers: Round, ASME B18.22.1.
- J. Lock Washers: Helical, spring type, ASME B18.21.1.
- K. Cast-in-Place Anchors in Concrete: Anchors capable of sustaining, without failure, a load equal to four times the load imposed, as determined by testing according to ASTM E 488, conducted by a qualified independent testing agency.
  - 1. Threaded or wedge type; 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, hot-dip galvanized per ASTM A 153/A 153M.
- L. Expansion Anchors: Anchor bolt and sleeve assembly with capability to sustain, 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.
  - 1. Material for Anchors in Interior Locations: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.
  - 2. Material for Anchors in Exterior Locations: Alloy Group 1 stainless-steel bolts complying with ASTM F 593 and nuts complying with ASTM F 594.
- M. Toggle Bolts: FS FF-B-588, tumble-wing type, class and style as required.
- N. Chemical Anchors: Two-part epoxy systems with impacted bolt, rod or anchor as follows:
  - 1. Concrete Anchor: Epoxy capsule system similar to Hilti HVA Adhesive Anchor System, Ramset Chemset anchor system, or approved equal.
  - 2. Masonry Anchor: Epoxy injection system similar to Hilti HIT C-100 System.

#### 2.04 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with performance requirements of FS TT-P-664, selected for good resistance to normal atmospheric corrosion, compatibility with finish paint system indicated, and capability to provide a sound foundation for field-applied topcoats despite prolonged exposure.
- C. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- D. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.

- E. 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. Products:
    - a. Sure-grip High Performance Grout; Dayton Superior Corp.
    - b. Euco N-S Grout; Euclid Chemical Co.
    - c. Five Star Grout; Five Star Products.
    - d. Crystex; L & M Construction Chemicals, Inc.
    - e. Masterflow 928 and 713; Master Builders Technologies, Inc.
    - f. Sealtight 588 Grout; W. R. Meadows, Inc.
    - g. SonogROUT 14; Sonneborn Building Products - ChemRex, Inc.
- F. Concrete Materials and Properties: Comply with requirements in Division 3 Section "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of **3000 psi**, unless otherwise indicated.

## 2.05 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in 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. Form metal fabrications from materials of size, thickness, and shapes indicated but not less than 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.
- C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately **1/32 inch**, unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- E. Form exposed work true to line and level with accurate angles and surfaces and straight edges.
- F. Thermal Movements: Allow for thermal movement resulting from the following maximum change (range) in ambient temperature in the design, fabrication, and installation of installed metal assemblies to prevent buckling, opening up of joints, and over-stressing of welds and fasteners. Base design calculations on actual surface temperatures of metals due to both solar heat gain and nighttime sky heat loss.
  - 1. Temperature Change (Range): 120 deg F, ambient; 180 deg F, material surfaces.
- G. 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.
- H. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts, unless otherwise indicated. Locate joints where least conspicuous.
- I. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- J. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.

- K. 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. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches, with a minimum 6-inch embedment and 2-inch hook, not less than 8 inches from ends and corners of units and 24 inches o.c., unless otherwise indicated.

## 2.06 METAL LADDERS

- A. General:
1. Comply with ANSI A14.3, unless otherwise indicated.
  2. For elevator pit ladders, comply with ASME A17.1 and the following requirements.
  3. Space siderails **18 inches** apart, unless otherwise indicated.
  4. Support each ladder at top and bottom and not more than **60 inches** o.c. with welded or bolted brackets, made from same metal as ladder.
    - a. 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**.
    - b. Extend siderails 48 inches above top rung and return rails to wall or structure unless other secure handholds are provided. If the adjacent structure does not extend above the top rung, gooseneck the extended rails back to the structure to provide secure ladder access.
- B. Steel Ladders:
1. Siderails: As indicated on Drawings.
  2. Rungs: 3/4-inch- diameter steel bars, spaced 12 inches o.c.
  3. Fit rungs in centerline of siderails; 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.

## 2.07 STEEL FRAMED STAIRS

- A. General: Construct stairs to conform to sizes and arrangements indicated. Join pieces together by welding, unless otherwise indicated. Provide complete stair assemblies including metal framing, hangers, columns, railings, newels, balusters, struts, clips, brackets, bearing plates and other components necessary for support of stairs and platforms and as required to anchor and contain stairs on supporting structure.
- B. Stair Framing: Fabricate stringers of structural steel channels, plates, or tubes or a combination thereof, as indicated. Provide closures for exposed ends of stringers. Construct platforms of structural steel channel headers and miscellaneous framing members as indicated. Weld headers to strings and framing members to strings and headers.
1. Where masonry walls support steel stairs, provide temporary supporting struts designed for erection of steel stair components before installation of masonry.
- C. Concrete-Filled Metal-Pan Stairs: Form risers, subread pans, and subplatforms to conform to configuration shown from steel sheet of thickness needed to comply with performance requirements but not less than 0.093 inch, 12 gage.
1. Form metal pans of carbon steel sheet or as indicated.
  2. Provide sub-platforms of configuration and constructions indicated, or if not indicated, of same metal as risers and sub-treads and in thickness required to support design loading. Attach sub-platform to platform framing members with welds. Locate welds where they will be concealed by concrete fill.
  3. Attach risers and subtreads to stringers, by means of brackets made of steel angles. Weld brackets to stringers and attach metal pans to brackets by welding. Do not weld risers to stringers.
  4. Shape metal pans to include nosing integral with riser.

## 2.08 STEEL PIPE RAILINGS, HANDRAILS, AND GUARDRAILS

- A. General: Fabricate steel pipe railings and handrails 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: To details indicated.
  - 2. Gates: Form gates from steel tube of same size and shape as top rails, with infill to match guards. Provide with cam-type self-closing hinges for fastening to wall and overlapping stop with rubber bumper to prevent gate from opening in direction opposite egress.
- B. Guardrails and Light Fixture Support System: Fabricate steel guardrails to comply with requirements indicated for design, dimensions, details, and member sizes, including post spacings, and anchorage, but not less than that needed to withstand indicated design and dead loads.
  - 1. Wall Thickness: of Tube: Not less than 3/16 inch.
  - 2. Finish: Galvanized after fabrication.
- C. Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings. All exposed welds shall be ground smooth.
- D. Form changes in direction of railings by use of prefabricated elbow fittings and radius bends.
- E. 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.
- F. Close exposed ends of railing members by welding 3/16-inch thick steel plate in place or by use of prefabricated fittings.
- G. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated.
- H. For railing posts set in concrete provide sleeves of galvanized steel pipe not less than 6" long and with an inside diameter not less than 1/2-inch greater than the outside diameter of pipe. Provide steel plate closure welded to bottom of sleeve and of width and length not less than 1-inch greater than outside diameter of sleeve.
- I. Provide friction fit, removable covers designed to keep sleeves clean and hold top edge of sleeve 1/2-inch below finished-surface of concrete.
- J. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
  - 1. Wall Brackets for Pipe Handrails: Julius Blum No. 306, cast malleable iron.
- K. 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.
- L. Provide galvanized finish for all exterior steel guardrails, including tubes, brackets, and other ferrous components. Shop prime steel pipe for interior railings.
  - 1. All fasteners for exterior railings shall be stainless steel.

## 2.09 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 for equal bearing of 1-inch per foot of clear span but not less than 8-inches bearing at each side of openings, unless otherwise indicated.
- D. Galvanize loose steel lintels located in exterior walls.

#### 2.10 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports for applications indicated that are 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 retained by framing and supports. Cut, drill, and tap units to receive hardware, hangers, and similar items.
  - 1. Equip units with integrally welded anchors for casting into concrete or building into masonry. Furnish inserts if units must be installed after concrete is placed.
    - a. Except as otherwise indicated, space anchors 24 inches o.c. and provide minimum anchor units in the form of steel straps 1-1/4 inches wide by 1/4 inch thick by 8 inches long.
  - 2. Furnish inserts if units are installed after concrete is placed.
  - 3. Fabricate steel guardrails to comply with requirements indicated for design, dimensions, details, and member sizes, including post spacings, and anchorage, but not less than that needed to withstand indicated design and dead loads.
- C. Light Fixture and Security Screen Support System: Fabricate steel support posts to comply with the indicated design, dimensions, and member sizes, including post spacings, and anchorage, but not less than that needed to withstand dead loads of security screens and light fixtures. Close exposed ends to prevent water infiltration. Provide support brackets for attaching security screens to posts; coordinate with security screen manufacturer.
  - 1. Wall Thickness: Not less than 3/16 inch.
  - 2. Light Fixture Base: Fabricated to detail of same material and finish as support system.
  - 3. Fasteners: Select stainless steel fasteners of type, grade, and class required to produce connections suitable for anchoring support systems to other types of construction indicated and capable of withstanding design loads.
  - 4. Finish: Galvanized.
- D. Galvanize miscellaneous framing and supports at exterior locations and where indicated.

#### 2.11 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.

#### 2.12 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 40 steel pipe.
  - 1. Cap bollards with 1/4-inch- thick steel plate.
  - 2. Fill bollard with concrete.
  - 3. Galvanize for exterior locations, including at parking levels.



## 2.13 MISCELLANEOUS FABRICATIONS

- A. Countertop Supports: Fabricate from steel angle with steel gussets to configuration indicated. Round edges and ends to remove sharp edges.
- B. Sump Pit Covers and Supports: Fabricate covers from rolled-steel diamond plate, 1/4-inch thick minimum. Provide angle frame for opening size indicated. Frames shall be installed after concrete poured using expansion anchors.

## 2.14 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. Furnish malleable-iron washers for heads and nuts that bear on wood structural connections, and furnish steel washers elsewhere.

## 2.15 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.

## 2.16 STEEL AND IRON FINISHES

- A. Galvanizing: Provide coating for iron and steel fabrications applied by the hot-dip process, 0.05 - 0.09% nickel content, Deltagalv by Duncan Galvanizing, or approved equal. Provide thickness of galvanizing specified in referenced standards. Hot-dip galvanize items as indicated to comply with applicable standard listed below:
  - 1. ASTM A 123/A 123M, for galvanizing both fabricated and unfabricated steel and iron products made of uncoated rolled, pressed, and forged shapes, plates, bars, and strip 0.0299 inch thick or thicker.
  - 2. ASTM A 153/A 153M, for galvanizing steel and iron hardware.
- 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. Shop Priming: 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: Shop, Field, and Maintenance Painting of Steel," for shop painting.
  - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

## PART 3 - EXECUTION

### 3.01 PREPARATION

- A. Coordinate and furnish anchorages, setting drawings, diagrams, templates, instructions, and directions for installing 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.

### 3.02 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 intended 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 bolts, 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 a heavy coat of bituminous paint.
- G. Adjust railings before anchoring to ensure matching alignment at abutting joints.

### 3.03 STAIR INSTALLATION

- A. General Installation:
  - 1. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
  - 2. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.
  - 3. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
  - 4. 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.
  - 5. Field Welding: Comply with the following requirements:
    - a. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
    - b. Obtain fusion without undercut or overlap.
    - c. Remove welding flux immediately.
    - d. 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.
  - 6. Place and finish concrete fill for treads and platforms to comply with Division 3 Section "Cast-in-Place Concrete."

- B. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of baseplates.
- C. Set steel stair baseplates on wedges, shims, or leveling nuts. After stairs have been positioned and aligned, 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 nonmetallic, nonshrink grout, unless otherwise indicated.
  - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

#### 3.04 INSTALLING RAILINGS AND HANDRAILS

- A. Adjust 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 rail ends to building construction as follows:
  - 1. Anchor posts to steel by welding directly to steel supporting members.
- B. Attach handrails to wall with wall brackets. 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 to building construction as follows:
  - 1. For steel-framed gypsum board assemblies, use hanger or lag bolts set into wood backing between studs. Coordinate with stud installation to locate backing members.

#### 3.05 INSTALLING GUARDRAILS AND SUPPORT SYSTEMS

- A. Space posts at spacing indicated or, if not indicated, as required by design loads. Set posts accurately in location, alignment, and elevation; measured from established lines and levels and free of rack; plumb posts in each direction.
  - 1. Do not weld, cut, or abrade surfaces of support system that have been finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
  - 2. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
- B. Fastening to In-Place Construction: Use drilled-in expansion shields for anchoring light fixture and security screen support systems and for properly transferring loads to in-place construction.
- C. Adjust guardrails before anchoring to posts to ensure matching alignment at abutting joints. Fit exposed connections together to form tight, hairline joints.
  - 1. Align guardrails so variations from level do not exceed 1/4 inch in 12 feet.

#### 3.06 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.

#### 3.07 INSTALLING PIPE BOLLARDS

- A. Anchor bollards in place with concrete footings. Center and align bollards in holes 3 inches above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace bollards in position until concrete has cured.

3.08 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 dry film thickness.
  
- B. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION