

## SECTION 05500

### METAL FABRICATIONS

#### PART 1 - GENERAL

##### 1.1 SUMMARY

- A. This Section includes the following:
1. Loose bearing and leveling plates.
  2. Loose steel lintels.
  3. Steel framing and supports for mechanical and electrical equipment.
  4. Steel framing and supports for applications where framing and supports are not specified in other Sections.
  5. Catwalks.

##### 1.2 PERFORMANCE REQUIREMENTS

- A. Provide ladders meeting the OSHA requirements of 29CFR 1910.27.

##### 1.3 SUBMITTALS

- A. 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.
- B. Welding Certificates: Copies of certificates for welding procedures and personnel.
- C. LEED Submittal:
1. Credit MR 2.1 and 2.2: Comply with Division 1 Section "Construction Waste Management."
  2. Product Data for Credit MR 4.1 and Credit MR 4.2: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content.
    - a. Include statement indicating costs for each product having recycled content.
  3. Credit MR 5.1: Product Data indicating location of material manufacturer for regionally manufactured materials.
    - a. Include statement indicating cost and distance from manufacturer to Project for each regionally manufactured material.

##### 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.

## PART 2 - PRODUCTS

### 2.1 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.
- B. Recycled Content of Steel Products: Provide products with an average recycled content of steel products so postconsumer recycled content plus one-half of preconsumer recycled content is not less than 25 percent.

### 2.2 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. Malleable-Iron Castings: ASTM A 47, Grade 32510 (ASTM A 47M, Grade 22010).
- E. Gray-Iron Castings: ASTM A 48, Class 30 (ASTM A 48M, Class 200), unless another class is indicated or required by structural loads.
- F. 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.
- G. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

### 2.3 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.

## 2.4 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.

## 2.5 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 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.

## 2.7 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.

## 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 that are not a part of structural-steel framework 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.
- C. Galvanize miscellaneous framing and supports where indicated.

## 2.10 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.

## 2.11 STEEL AND IRON FINISHES

- A. Galvanizing: Provide coating for iron and steel fabrications applied by the hot-dipped process, Durogalv by Duncan Galvanizing. The galvanizing bath shall contain high grade zinc and other earthy 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 SETTING 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 nonshrink, nonmetallic grout, unless otherwise indicated.
  - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.
- C. Where bearing plates are indicated with integral anchors, set in cement grout while grout is fluid. Level the surface and provide temporary support while grout hardens. Do not force anchors in partially hardened grout.
  - 1. Where non-shrink grout is indicated, pack between bearing surfaces as indicated above.

### 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 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.

END OF SECTION