

SECTION 05511

METAL STAIRS

PART 1 - GENERAL

1.1 SUMMARY

- A. This Section includes the following:
1. Alternating Tread Stair.
 2. Steel stairs with concrete-filled treads.
 3. Handrails and railings attached to metal stairs.
 4. Handrails attached to walls adjacent to metal stairs.
 5. Handrails at catwalk.

1.2 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide metal stairs capable of withstanding 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 component of metal stairs.
1. Treads and Platforms of Metal Stairs: Capable of withstanding a uniform load of 100 lbf/sq. ft. (4.79 kN/sq. m) or a concentrated load of 300 lbf (1.33 kN) on an area of 4 sq. in. (25.8 sq. cm), whichever produces the greater stress.
 2. Stair Framing: Capable of withstanding stresses resulting from loads specified above in addition to stresses resulting from railing system loads.
 3. Limit deflection of treads, platforms, and framing members to L/360 or 1/4 inch (6.4 mm), whichever is less.
- B. Structural Performance of Railings: Provide railings capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
1. Handrails:
 - a. Uniform load of 50 lbf/sq. ft. (0.73 kN/sq. m) applied in any direction.
 - b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 2. Top Rails of Guards:
 - a. Uniform load of 50 lbf/ ft. (0.73 kN/m) applied in any direction.
 - b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 3. Infill of Guards:
 - a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
 - b. Uniform load of 25 lbf/sq. ft. (1.2 kN/sq. m) applied horizontally.
 - c. Infill load and other loads need not be assumed to act concurrently.
- C. Seismic Performance: Provide metal stairs capable of withstanding the effects of earthquake motions determined according to ASCE 7, "Minimum Design Loads for Buildings and Other Structures": Section 9, "Earthquake Loads."

1.3 SUBMITTALS

- A. Product Data: For metal stairs and the following:
 - 1. Alternating tread stair.
- B. Shop Drawings: Show fabrication and installation details for metal stairs. Include plans, elevations, sections, and details of metal stairs and their connections. Show anchorage and accessory items. Provide templates for anchors and bolts specified for installation under other Sections.
 - 1. 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.
- C. Welding Certificates: Copies of certificates for welding procedures and personnel.
- D. 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. Professional Engineer Qualifications: A professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for installations of metal stairs (including handrails and railing systems) that are similar to those indicated for this Project in material, design, and extent.
- B. Fabricator Qualifications: A firm experienced in producing metal stairs 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.
- C. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel," and AWS D1.3, "Structural Welding Code--Sheet Steel."

PART 2 - PRODUCTS

2.1 MANUFACTURED UNITS

- A. Alternating Tread Stair: Provide ships ladders where shown on the drawings. Stairs shall conform to layout and dimensions indicated in drawings.

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

2.2 FERROUS METALS

- A. 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.
- B. Metal Surfaces, General: Provide metal free from pitting, seam marks, roller marks, and other imperfections where exposed to view on finished units. Do not use steel sheet with variations in flatness exceeding those permitted by referenced standards for stretcher-leveled sheet.
- C. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- D. Steel Tubing: Cold-formed steel tubing complying with ASTM A 500.
- E. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- F. Uncoated, Cold-Rolled Steel Sheet: ASTM A 1008/A 1008M, either commercial steel, Type B, or structural steel, Grade 25 (Grade 170), unless another grade is required by design loads; exposed.
- G. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, either commercial steel, Type B, or structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.
- H. Galvanized Steel Sheet: ASTM A 653/A 653M, G90 (Z275) coating, either commercial quality or structural quality, Grade 33 (Grade 230), unless another grade is required for design loads.
- I. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

2.3 FASTENERS

- A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 25 for exterior use, and 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. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).
- D. Lag Bolts: ASME B18.2.1 (ASME B18.2.3.8M).

- E. Plain Washers: Round, carbon steel, ASME B18.22.1 (ASME B18.22M).
- F. Lock Washers: Helical, spring type, carbon steel, ASME B18.21.1 (ASME B18.21.2M).
- G. 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.

2.4 PAINT

- A. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79.
 - 1. Use primer with a VOC content of 420 g/L (3.5 lb/gal.) or less when calculated according to 40 CFR 59, Subpart D (EPA Method 24).
 - 2. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.
- B. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- C. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12, except containing no asbestos fibers or cold-applied asphalt emulsion complying with ASTM D 1187.

2.5 CONCRETE FILL AND REINFORCING MATERIALS

- A. Concrete Materials and Properties: Comply with requirements in Division 3 Section "Cast-in-Place Concrete" for normal-weight, ready-mixed concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa), unless higher strengths are indicated.
- B. Welded Wire Fabric: ASTM A 185, 6 by 6 inches (152 by 152 mm)--W1.4 by W1.4, unless otherwise indicated.

2.6 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, struts, handrails, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
 - 1. Join components by welding, unless otherwise indicated.
 - 2. Use connections that maintain structural value of joined pieces.
 - 3. Fabricate treads and platforms of exterior stairs so finished walking surfaces slope to drain.
- B. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," for class of stair designated, unless more stringent requirements are indicated.
 - 1. Commercial class, unless otherwise indicated.

- C. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges. Shear and punch metals cleanly and accurately. Remove sharp or rough areas on exposed surfaces.
- D. 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.
- E. Weld connections 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. Weld exposed corners and seams continuously, unless otherwise indicated.
 5. 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. 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.
- G. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.

2.7 STEEL-FRAMED STAIRS

- A. Stair Framing: Fabricate stringers of structural-steel channels, plates, or a combination of both, as indicated. Provide closures for exposed ends of stringers. Construct platforms of structural-steel channel headers and miscellaneous framing members as indicated. Bolt or weld headers to stringers; bolt or weld framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.
 1. Where stairs are enclosed by gypsum board or shaft-wall assemblies, provide hanger rods to support landings from floor construction above. Locate hanger rods within stud space of shaft-wall construction.
- B. Metal-Pan Stairs: Form risers, subtreads pans, and subplatforms to configurations shown from steel sheet of thickness necessary to support indicated loads, but not less than 0.0677 inch (1.7 mm).
 1. Steel Sheet: Uncoated cold-rolled steel sheet, unless otherwise indicated.
 2. Attach risers and subtreads to stringers with brackets made of steel angles or bars. Weld brackets to stringers and attach metal pans to brackets by welding, riveting, or bolting.
 3. Shape metal pans to include nosing integral with riser.
 4. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.

2.8 STEEL TUBE HANDRAILS AND RAILINGS

- A. General: Fabricate handrails and railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.

1. Configuration: As indicated on the drawings.
 2. Gates: Form gates from steel tube of same size and shape as top rails. Provide with hinges for fastening to wall and overlapping stop with rubber bumper to restrict gate to opening in the direction of egress.
- B. Interconnect members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
1. At tee and cross intersections, cope ends of intersecting members to fit contour of tube to which end is joined, and weld all around.
- C. Form changes in direction of handrails and rails as follows:
1. As detailed.
 2. By bending.
 3. By flush-radius bends.
 4. By radius bends of radius indicated.
 5. By inserting prefabricated flush-elbow fittings.
 6. By any method indicated above, applicable to change of direction involved.
- D. Form simple and compound curves by bending members in jigs to produce uniform curvature for each repetitive configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- E. Close exposed ends of handrail and railing members with prefabricated end fittings.
- F. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated. Close ends of returns, unless clearance between end of rail and wall is 1/4 inch (6 mm) or less.
- G. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting railings and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
1. Connect railing posts to stair framing by direct welding, unless otherwise indicated.
- H. 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.
- I. For galvanized handrails and railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
- J. For nongalvanized handrails and railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.

2.9 FINISHES

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

- C. 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.
 - 1. Fill vent and drain holes that will be exposed in finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.
- D. 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 products:
 - 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."
- E. Apply shop primer to prepared surfaces of metal stair components, unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1," for shop painting. Primer need not be applied to surfaces to be embedded in concrete or masonry.
 - 1. Do not apply primer to galvanized surfaces.
 - 2. 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 stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. 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 from rack.
- C. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete, unless otherwise indicated.
- D. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- E. 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.
- F. 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.

3.2 INSTALLING STEEL TUBE RAILINGS AND HANDRAILS

- A. Adjust handrails and railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and railing ends to building construction as follows:
 1. Anchor posts to steel by welding directly to steel supporting members.
 2. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.
- B. Attach handrails to wall with wall brackets. Provide bracket with 1-1/2-inch (38-mm) 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. Use type of bracket with predrilled hole for exposed bolt anchorage.
 2. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 3. For hollow masonry anchorage, use toggle bolts.
 4. 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.

3.3 INSTALLING ALTERNATING TREAD STAIR

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

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