

**Oakhurst Dairy – New Milk Cooler**

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**SECTION 05530 - GRATINGS****PART 1 - GENERAL****1.1 RELATED DOCUMENTS**

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

**1.2 SUMMARY**

- A. This Section includes the following:
  - 1. Metal bar gratings.
  - 2. Metal frames and supports for gratings.
- B. Related Sections include the following:
  - 1. Division 5 Section "Structural Steel" for structural-steel framing system components.
  - 2. Division 5 Section "Metal Stairs" for grating treads and landings of steel-framed stairs.
  - 3. Division 5 Section "Pipe and Tube Railings" for metal pipe and tube handrails and railings.

**1.3 PERFORMANCE REQUIREMENTS**

- A. Structural Performance of Gratings: Provide gratings capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
  - 1. Floors: Uniform load of 100 lbs./sq. ft. or concentrated load of 2000 lbs., whichever produces the greater stress.
  - 2. Walkways and Elevated Platforms: Uniform load of 100 lbs./sq. ft.
  - 3. Limit deflection to L/240 or 1/4 inch, whichever is less.

**1.4 SUBMITTALS**

- A. Product Data: For the following:
  - 1. Clips and anchorage devices for gratings.
  - 2. Paint products.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

**1.5 QUALITY ASSURANCE**

- A. Metal Bar Grating Standards: Comply with NAAMM MBG 531, "Metal Bar Grating Manual."
- B. Welding: Qualify procedures and personnel according to the following:
  - 1. AWS D1.1, "Structural Welding Code--Steel."

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2. AWS D1.3, "Structural Welding Code--Sheet Steel."
3. AWS D1.6, "Structural Welding Code--Stainless Steel."

**1.6 PROJECT CONDITIONS**

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with gratings 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 gratings 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.

**1.7 COORDINATION**

- A. 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 MANUFACTURERS**

- A. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
- B. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
  1. Metal Bar Gratings:
    - a) All American Grating, Inc.
    - b) Borden Metal Products (Canada) Limited.
    - c) Fisher & Ludlow.
    - d) IKG Industries; a Harsco Company.
    - e) Tru-Weld.

**2.2 FERROUS METALS**

- A. Steel Plates, Shapes, and Bars: ASTM A 36.
- B. Wire Rod for Grating Crossbars: ASTM A 510

**2.3 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. Provide stainless-steel fasteners for fastening aluminum. Select fasteners for type, grade, and class required.

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- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy that is welded.
- B. Shop Primers: Provide primers that comply with Division 9.
- C. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.

**2.5 FABRICATION**

- A. Shop Assembly: Fabricate grating sections 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. Cut, drill, and punch material 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.
- C. Form from materials of size, thickness, and shapes indicated, but not less than that needed to support indicated loads.
- D. Fit exposed connections accurately together to form hairline joints.
- E. Welding: Comply with AWS recommendations and the following:
  - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
  - 2. Obtain fusion without undercut or overlap.
  - 3. Remove welding flux immediately.
- F. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space the anchoring devices to secure gratings, frames, and supports rigidly in place and to support indicated loads.
  - 1. Fabricate toeplates to fit grating units and weld to units in shop, unless otherwise indicated.
  - 2. Fabricate toeplates for attaching in the field.
  - 3. Toeplate Height: 4 inches, unless otherwise indicated.

**2.6 METAL BAR GRATINGS**

- A. Welded Steel Grating:
  - 1. Bearing Bar Spacing: 1-3/16 inches o.c.
  - 2. Bearing Bar Depth: 1-1/4 or 1-1/2 inches, See Drawings.
  - 3. Bearing Bar Thickness: 3/16 inch.
  - 4. Crossbar Spacing: 4 inches o.c.
  - 5. Traffic Surface: Plain.

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6. Steel Finish: Shop primed, except where noted as galvanized. Hot-dip galvanize with a coating weight of not less than 1.8 oz./sq. ft. of coated surface.
- B. Pressure-Locked, Stainless-Steel Grating: Fabricated by pressing rectangular flush-top crossbars into slotted bearing bars.
1. Bearing Bar Spacing: 7/16 or 1/2 inch.
  2. Bearing Bar Depth: 1 inch.
  3. Bearing Bar Thickness: 1/8 inch.
  4. Crossbar Spacing: 4 inches o.c.
  5. Traffic Surface: Plain.
  6. Finish: Mill finish.

**2.7 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. Equip units indicated to be cast into concrete or built into masonry with integrally welded anchors. Unless 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.
- B. Galvanize steel frames and supports for all exterior locations and for interior locations, where indicated.

**2.8 STEEL FINISHES**

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish gratings, frames, and supports after assembly.
- C. Galvanizing: For those items indicated for galvanizing, apply zinc coating by the hot-dip process complying with ASTM A 123.
- 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 metal fabrications:
1. Exteriors (SSPC Zone 1B): SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
  2. Interiors (SSPC Zone 1A): SSPC-SP 7/NACE No. 4, "Brush-off Blast Cleaning."
- E. Apply shop primer to uncoated surfaces of gratings, frames, and supports, except those with galvanized finishes and those to be embedded in concrete 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.

**PART 3 - EXECUTION**

**3.1 INSTALLATION, GENERAL**

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing gratings 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 gratings. Set units accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.
- C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete or masonry.
- D. Fit exposed connections accurately together to form hairline joints.
  - 1. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade the surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- E. Attach toeplates to gratings by welding at locations indicated.
- 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.

**3.2 INSTALLING METAL BAR 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.

**3.3 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 same material as used for shop painting to comply with SSPC-PA 1 requirements for touching up shop-painted surfaces.
  - 1. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.

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

END OF SECTION 05530