

SECTION 05500

METAL FABRICATIONS

PART 1 - GENERAL

1.1 GENERAL PROVISIONS

- A. Attention is directed to the **CONTRACT AND GENERAL CONDITIONS** and all Sections within **DIVISION 01 - GENERAL REQUIREMENTS** which are hereby made a part of this Section of the Specifications.

1.2 DESCRIPTION OF WORK

- A. Work Included: Provide labor, materials and equipment necessary to complete the work of this Section, including but not limited to the following:
 - 1. All Work in this Section, including Schedule in Paragraph 2.1 of this Section.
- B. Related Work: The following items are not included in this Section and will be performed under the designated Sections:
 - 1. Section 03300 - **CAST-IN-PLACE CONCRETE** for installing metal items into concrete.
 - 2. Section 04200 - **UNIT MASONRY** for installing metal items into masonry walls.
 - 3. Section 10605 - **WIRE MESH PARTITIONS** for interior wire mesh partitions.

1.3 PERFORMANCE REQUIREMENTS

- A. 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.
- B. 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.

1.4 SUBMITTALS

- A. Product Data: For the following:
 - 1. Paint products.
 - 2. Grout.
- 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.
 - 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, licensed by the local authorities having jurisdiction, responsible for their preparation.
 - 4. Where fabrications are to receive sprayed-on fireproofing, include statement that primer is compatible with fireproofing proposed for use.
- C. Welding certificates.
- D. Qualification Data: For professional engineer.

1.5 QUALITY ASSURANCE

- A. 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."
- B. 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.

1.6 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.

1.7 COORDINATION

- A. Coordinate installation of anchorages for metal fabrications. 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.
- B. Coordinate installation of steel weld plates and angles for casting into concrete that are specified in this Section but required for work of another Section. Deliver such items to Project site in time for installation.

PART 2 - PRODUCTS

2.1 SCHEDULE

- A. Miscellaneous items include the following. Requirements for materials, hot-dip galvanizing and shop-applied primers are included with each item as applicable.
 - 1. Steel framing and supports with shop applied primer for sliding doors.
 - 2. Steel framing and supports for countertops with shop-applied primer.
 - 3. Galvanized 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; galvanized at exterior locations and in exterior walls.
 - 5. Galvanized steel bollards with shop-applied primer.

2.2 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Steel Tubing: ASTM A 500, cold-formed steel tubing.
- C. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- D. Cast Iron: ASTM A 48/A 48M, Class 30, unless another class is indicated or required by structural loads.

2.3 FASTENERS

- A. General: Unless otherwise indicated, provide Type 316 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.

- B. Anchor Bolts: ASTM F 1554, Grade 36. Provide hot-dip or mechanically deposited, zinc-coated anchor bolts where item being fastened is indicated to be galvanized.
- C. 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.
- D. 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. Acceptable Manufacturers: Kwik-Bolt 3 by Hilti, Inc., TruBolt Wedge Anchor by ITW Red Head or Power-Stud by Powers Fasteners.

2.4 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 MPI#79. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.
- C. Zinc-Rich Primer: Complying with SSPC-Paint 20 or SSPC-Paint 29 and compatible with topcoat.
- D. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- E. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.
- F. 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.

2.5 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, 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 true to line and level with accurate angles and surfaces and straight edges.
- E. 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.
- F. 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.
- G. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- H. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- I. 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.

2.6 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 retained by framing and supports. Cut, drill, and tap units to receive hardware, hangers, and similar items.
 - 1. Furnish inserts if units are installed after concrete is placed.

2.7 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 40 steel pipe.

2.8 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.

2.9 STEEL PRIMERS AND FINISHES

- A. 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) and Items Indicated to Receive Zinc-Rich Urethane Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 2. Interiors (SSPC Zone 1A): SSPC-SP 7, "Brush Off Blast Cleaning."
 - 3. Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finishes and those to be field welded, embedded in concrete or masonry, unless otherwise indicated. Extend priming of partially embedded members to a depth of 2 inches.
 - 4. Comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.
 - 5. Comply with SSPC-PA 2, "Measurement of Dry Coating Thickness with magnetic Gages."
- B. Zinc-Rich Primer: Urethane zinc rich primer compatible with topcoat Specified in Section 09900 - PAINTING. Provide primer with a VOC content of 340 g/L (2.8 lb/gal.) or less per OTC ozone standards when calculated according to 40 CFR 59, Subpart D (EPA Method 24). Provide Tnemec Series 394 Perimerprime or Ameron Series 68HS at 3.0 mils DFT or approved equal by DuPont or Carboline.
- C. Hot-Dip Galvanizing: For steel exposed to the elements, weather or corrosive environments and other steel indicated to be galvanized, provide coating for iron and steel fabrications applied by the hot-dip process. Comply with ASTM A 123 for fabricated products and ASTM A 153 for hardware. Provide thickness of galvanizing specified in referenced standards. The galvanizing bath shall contain high grade zinc and other earthly materials. Fill vent holes and grind smooth after galvanizing.
- D. Hot-Dip Galvanizing And Factory-Applied Primer for Steel: Provide hot-dip galvanizing and factory-applied prime coat, certified OTC/VOC compliant less than 2.8 lbs/gal. and conforming to EPA and local requirements.. Apply primer within 12 hours after galvanizing at the galvanizer's plant in a controlled environment meeting

applicable environmental regulations and as recommended by the primer coating manufacturer. Blast cleaning of the surface is unacceptable for surface preparation. Primer shall have a minimum two year re-coat window for application of finish coat. Coatings must meet or exceed the following performance criteria:

1. Abrasion: ASTM D 4060, CS17 Wheel, 1,000 gram load.
2. Adhesion: ASTM D 3359, Method B, 5 mm crosshatch.
3. Humidity Resistance: ASTM D 4585.
4. Salt Spray (Fog): ASTM B 117.

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 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.

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 this Section.
- D. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified in this Section.
 - 1. Grout baseplates of columns supporting steel girders after girders are installed and leveled.

3.3 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.
- B. Fill bollards solidly with concrete, mounding top surface to shed water.

3.4 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