

## SECTION 05500 - METAL FABRICATIONS

### 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. Loose bearing and leveling plates.
  - 2. Loose steel lintels.
  - 3. Steel framing and supports for applications where framing and supports are not specified in other Sections.
  - 4. Metal edgings.
  - 5. Miscellaneous metal trim.
  - 6. Pipe bollards.
- B. Related Sections include the following:
  - 1. Division 5 Section "Structural Steel" for structural-steel framing system components.
  - 2. Division 6 Section "Rough Carpentry" for metal framing anchors and other rough hardware.

#### 1.3 SUBMITTALS

- A. Product Data: For the following:
  - 1. Nonslip aggregates and nonslip-aggregate surface finishes.
  - 2. Prefabricated building columns.
  - 3. Cast nosings and treads.
  - 4. Extruded nosings and treads.
  - 5. Paint products.
  - 6. Grout.
- B. 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.
- C. Samples for Verification: For each type and finish of extruded nosing and tread.

- D. Mill Certificates: Signed by manufacturers of stainless-steel sheet certifying that products furnished comply with requirements.
- E. Welding Certificates: Copies of certificates for welding procedures and personnel.
- F. Qualification Data: For firms and persons specified in "Quality Assurance" Article to demonstrate their capabilities and experience. Include lists of completed projects with project names and addresses, names and addresses of architects and owners, and other information specified.

#### 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 D1.2, "Structural Welding Code--Aluminum."
  - 3. AWS D1.3, "Structural Welding Code--Sheet Steel."
  - 4. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.

#### 1.5 PROJECT CONDITIONS

- A. Field Measurements: Where metal fabrications are indicated to fit walls and other construction, verify dimensions by field measurements before fabrication and indicate measurements on Shop Drawings. Coordinate fabrication schedule with construction progress to avoid delaying the Work.
  - 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 construction to ensure that actual dimensions correspond to established dimensions. Allow for trimming and fitting.

#### 1.6 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.

### 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.

## 2.2 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Stainless-Steel Sheet, Strip, Plate, and Flat Bars: ASTM A 666, Type 304.
- C. Stainless-Steel Bars and Shapes: ASTM A 276, Type 304.
- D. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
- E. Rolled-Stainless-Steel Floor Plate: ASTM A 793.
- F. Steel Tubing: Cold-formed steel tubing complying with ASTM A 500.
- G. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- H. Slotted Channel Framing: Cold-formed metal channels with flange edges returned toward web and with ~~9/16-inch~~ (14.3-mm) wide slotted holes in webs at ~~2 inches~~ (51 mm) o.c.
  - 1. Finish: Hot-dip galvanized after fabrication.
- I. Malleable-Iron Castings: ~~ASTM A 47, Grade 32510~~ (ASTM A 47M, Grade 22010).
- J. Gray-Iron Castings: ~~ASTM A 48, Class 30~~ (ASTM A 48M, Class 200), unless another class is indicated or required by structural loads.
- K. 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.
- L. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

## 2.3 ALUMINUM

- A. Aluminum Extrusions: ~~ASTM B 221~~ (ASTM B 221M), alloy 6063-T6.
- B. Aluminum-Alloy Rolled Tread Plate: ASTM B 632/B 632M, alloy 6061-T6.

## 2.4 PAINT

- A. Shop Primers: Provide primers that comply with Division 9 Section "Painting."
- B. 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.
- C. Shop Primer for Ferrous Metal: Organic zinc-rich primer, complying with SSPC-Paint 20 and compatible with topcoat.
  - 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. Carboline 621; Carboline Company.
    - b. Aquapon Zinc-Rich Primer 97-670; PPG Industries, Inc.
    - c. Tneme-Zinc 90-97; Tnemec Company, Inc.
- 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 mastic complying with SSPC-Paint 12, except containing no asbestos fibers, or cold-applied asphalt emulsion complying with ASTM D 1187.

## 2.5 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: Alloy Group 1 or 2 stainless-steel bolts complying with **ASTM F 593 (ASTM F 738M)** and nuts complying with **ASTM F 594 (ASTM F 836M)**.

J. Toggle Bolts: FS FF-B-588, tumble-wing type, class and style as needed.

## 2.6 GROUT

- A. Nonshrink, Metallic Grout: Factory-packaged, ferrous-aggregate grout complying with ASTM C 1107, specifically recommended by manufacturer for heavy-duty loading applications.
- B. 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.

## 2.7 CONCRETE FILL

- A. 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 (20 MPa)**, unless otherwise indicated.

## 2.8 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.

## 2.9 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.
- B. Galvanize plates after fabrication.

## 2.10 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.

## 2.11 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. General: Provide steel framing and supports indicated and as necessary to complete the Work.
- C. 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. Fabricate units from slotted channel framing where indicated.
2. 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.
3. Furnish inserts if units must be installed after concrete is placed.

D. Galvanize miscellaneous framing and supports where indicated.

## 2.12 MISCELLANEOUS STEEL TRIM

A. Unless otherwise indicated, fabricate units from structural-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. Provide anchors, welded to trim, for embedding in concrete or masonry construction, spaced not more than **6 inches (150 mm)** from each end, **6 inches (150 mm)** from corners, and **24 inches (600 mm)** o.c., unless otherwise indicated.

C. Galvanize miscellaneous steel trim in the following locations:

1. Exterior.
2. Interior, where indicated.

## 2.13 PIPE BOLLARDS

A. Fabricate pipe bollards from Schedule 40 steel pipe.

B. Fabricate pipe bollards from Schedule 80 steel pipe.

1. Cap bollards with **1/4-inch- (6-mm-)** minimum steel plate.

C. Fabricate sleeves for bollard anchorage from steel pipe with **1/4-inch (6-mm)** thick steel plate welded to bottom of sleeve.

D. Fabricate internal sleeves for removable bollards from Schedule 40 steel pipe or **1/4-inch (6-mm)** wall-thickness steel tubing with an OD **1/16 inch (1.5 mm)** less than ID of bollards. Match drill sleeve and bollard for **1/2-inch (12-mm)** steel machine bolt.

## 2.14 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.

## 2.15 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with applicable standard listed below:
  - 1. ASTM A 123, for galvanizing steel and iron products.
  - 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. 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.

## 2.16 STAINLESS-STEEL FINISHES

- A. Remove tool and die marks and stretch lines or blend into finish.
- B. Grind and polish surfaces to produce uniform, directionally textured, polished finish indicated, free of cross scratches. Run grain with long dimension of each piece.
- C. Bright, Directional Polish: No. 4 finish.
- D. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

## 2.17 ALUMINUM FINISHES

- A. As-Fabricated Finish: AA-M10 (Mechanical Finish: as fabricated, unspecified).

## 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 grout, either metallic or nonmetallic, in concealed locations where not exposed to moisture; use nonshrink, nonmetallic grout in exposed locations, unless otherwise indicated.
  - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

### 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.
- 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 at girders supported on concrete or masonry, install as specified above for setting and grouting bearing and leveling plates.
- D. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified above for setting and grouting bearing and leveling plates.
1. Do not grout baseplates of columns supporting steel girders until girders are installed and leveled.

### 3.4 INSTALLING PIPE BOLLARDS

- A. Anchor bollards in concrete in formed or core-drilled holes not less than **8 inches (200 mm)** deep and **3/4 inch (19 mm)** greater than OD of bollard. After bollards have been inserted into holes, fill annular space surrounding bollard solidly with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately **1/8 inch (3 mm)** toward bollard.
- B. Anchor internal sleeves for removable bollards in concrete by inserting into pipe sleeves preset into concrete. After internal sleeves have been inserted, fill annular space between sleeves solidly with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately **1/8 inch (3 mm)** toward internal sleeve.
- C. Fill bollards solidly with concrete, mounding top surface.
1. Do not fill removable bollards with concrete.

### 3.5 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. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in Division 9 Section "Painting."
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 05500