

SECTION 05120 – STRUCTURAL STEEL

PART 1 GENERAL

1.01 RELATED DOCUMENTS

- A. The drawings and general conditions of the contract including General and Supplementary Conditions and other Division 1 Specification sections apply to work of this section.
- B. Examine all other sections of the Specifications for requirements which affect work of this Section whether or not such work is specifically mentioned in this Section.
- C. Coordinate work with that of all trades affecting or affected by work of this Section. Cooperate with such trades to assure the steady progress of all work under the Contract.

1.02 DESCRIPTION OF WORK:

- A. Extent of structural steel work is shown on drawings, including schedules, notes and details to show size and location of members, typical connections, and type of steel required.
- B. Structural steel is that work defined in AISC “Code of Standard Practice” and as otherwise shown on drawings.

1.03 RELATED WORK

- 1. Section 05300 – Metal Deck
- 2. Section 05500 - Metal Fabrications

1.04 QUALITY ASSURANCE:

- A. Codes and Standards: Comply with provisions of the following, except as otherwise indicated:
 - 1. AISC “Code of Standard Practice for Steel Buildings and Bridges-March 7, 2000”.
 - a. Exclude the word “structural” in reference to the “Design Drawings” in section 3.1 of the Code.
 - 2. AISC “Specification for Structural Steel Buildings - Allowable Stress Design and Plastic Design”, June 1, 1989 including “Commentary” and Supplements issued thereto. A
 - 3. AISC “*Specifications for Structural Joints using ASTM A 325 or A 490 Bolts*” approved by the Research Council on Structural Connections of the Engineering Foundation.
 - 4. AISC 341, “Seismic Provisions for Steel Buildings”.
 - 5. AWS D1.1 - 2004 “Structural Welding Code” - Steel.

6. AWS D1.3 - 2004 "Structural Welding Code" - Sheet Steel.
 7. ASTM A6 "General Requirements for Delivery of Rolled Steel Plates, Shapes, Sheet Piling and Bars for Structural Use."
 8. "Code of Federal Regulations, Part 1926" per the Occupational Safety and Health Administration (OSHA), Department of Labor (Latest Revision).
- B. Qualifications for Welding Work: Qualify welding processes and welding operators in accordance with AWS D1.1 "Standard Qualification Procedure."
1. Provide certification that welders to be employed in work have satisfactorily passed AWS D1.1 qualification tests and maintained a current certification. Current certification and/or continuity log shall be submitted and be available in the field.
 2. If re-certification of welders is required, retesting will be the Contractor's responsibility.
- C. Fabricator Qualifications: Fabricator must be a member of the American Institute of Steel Construction (AISC), be certified for SBD – Conventional Steel Building Structures, STD – Standard for Steel Building Structures. Fabricator shall be certified at time of bidding and for duration of project.

1.05 SUBMITTALS

- A. Unless otherwise specified, submittals required in this section shall be submitted for review. Submittals shall be prepared and submitted in accordance with this section and Division 1.
- B. General Contractor shall submit a Submittal Schedule to the engineer within 30 days after they have received the Owner's Notice to Proceed.
- C. All submittals shall be reviewed and returned to the Architect within 10 working days.
- D. INCOMPLETE SUBMITTALS WILL NOT BE REVIEWED.
- E. Submittals not reviewed by the General Contractor prior to submission to the Engineer will not be reviewed. Include on the submittal statement or stamp of approval by Contractor, representing that the Contractor has seen and examined the submittal and that all requirements listed in Division 1 have been complied with.
- F. Engineer will review submittals a maximum of two review cycles as part of their normal services. If submittals are incomplete or otherwise unacceptable and re-submitted, General Contractor shall compensate Engineer for additional review cycles.
- G. Product Data: Submit producer's or manufacturer's specifications and installation instructions for the following products. Include laboratory test reports and other data to show compliance with specifications (including specified standards).
 1. Structural steel certified mill reports for each grade of steel covering chemical and physical properties and yield strengths.

2. High-strength bolts (each type), including nuts and washers.
 3. Structural steel primer paint (where applicable).
 4. Structural steel top coat paint (where applicable). (Refer to Section 09900.)
 5. AWS D1.1 Welder certifications.
 6. Expansion/Adhesive Anchors (coordinate with section 03300).
- H. Fabricator's Quality Control Procedures: Fabricator shall submit their written procedural and quality control manuals, and evidence of periodic auditing of fabrication practices by an approved inspection Agency.
- I. Fabricator's Certificate of Compliance: At completion of fabrication, fabricator shall submit a certificate of compliance stating that the work was performed in accordance with the construction documents.
- J. Shop Drawings:
1. Shop Drawing Review: Electronic files of structural drawings will not be provided to the contractor for preparation of shop drawings. Reproduction of any portion of the Construction Documents for use as Shop drawings and/or Erection Drawings is prohibited. Shop drawings and/or Erection drawings created from reproduced Construction Documents will be returned without review.
 - a. Review of the shop drawings will be made for the size and arrangement of the members and strength of the connections. Conformance of the Shop Drawings to the Contract Drawings remains the responsibility of the General Contractor. Engineer's review in no way relieves the General Contractor of this responsibility. **Submit three prints. Prints will be reviewed by the Engineer, and then the Architect. One marked print will be returned to Contractor for printing and distribution. Multiple copies will not be marked by the Engineer.**
 - b. Shop drawings will not be reviewed as partial submittals. A complete submittal shall be provided and shall include; erection and piece drawings indicating all members, braced frames, moment frames and connections. **Incomplete submittals will not be reviewed.**
 2. Alternate Connection Design: Connections for all beam, column, braced frame, and moment connections not tabulated in the AISC "Manual of Steel Construction" (ASD or LRFD) have been designed and detailed in the drawings. Alternate connection design shall be allowed only with prior approval of the Structural Engineer. If such approval is granted, all redesigned connections shall be designed by the fabricator's engineer, registered in the State of Maine. Calculations for redesigned connections shall signed and sealed.
 3. Test Reports: Submit copies of reports of tests conducted on shop and field bolted and welded connections. Include data on type(s) of test conducted and test results.

1.06 DELIVERY, STORAGE AND HANDLING:

- A. Deliver materials to site at such intervals to insure uninterrupted progress of work.
- B. Deliver anchor bolts and anchorage devices, which are to be embedded in cast-in-place, in ample time to not delay work.
- C. Store materials to permit easy access for inspection and identification. Keep steel members off ground, using pallets, platforms, or other supports. Protect steel members and packaged materials from corrosion and deterioration.
- D. Do not store materials on structure in a manner that might cause distortion or damage to members or supporting structures. Steel materials shall be stored in a manner to avoid ponding of precipitation on members. Repair or replace damaged materials or structures as directed.

PART 2 PRODUCTS

2.01 MATERIALS:

- A. Structural Steel Shapes, Plates and Bars (U.N.O): ASTM A 36 minimum, higher strength steel is acceptable.
- B. Structural Steel Hot Rolled Wide Flange Shapes: ASTM A 992 Grade 50 (ASTM A572 Grade 50 with special requirements per AISC Technical Bulletin #3, dated March 1997)
- C. Steel Tube: ASTM A 500, Grade B, $F_y = 46$ ksi.
- D. Steel Pipe: ASTM A 53, Grade B.
- E. Anchor Bolts: ASTM F1554, Grade 36 weldable steel, unless noted otherwise on drawings. Anchor rods that are to be exposed to weather, located in unheated enclosures, or in contact with pressure treated lumber shall be hot dipped galvanized. All anchor bolts shall be headed or double nutted. "J" or "L" type anchor bolts are not permitted.
- F. Unfinished Threaded Fasteners: ASTM A 307, Grade A, regular low-carbon steel bolts and nuts. Provide hexagonal heads and nuts for all connections.
- G. High-Strength Threaded Fasteners: Heavy hexagon structural bolts, heavy hexagon nuts, and hardened washers, as follows:
 - 1. Quenched and tempered medium-carbon steel bolts, nuts and washers, complying with ASTM A325 or ASTM A490. Refer to drawings for diameter.
 - 2. Direct tension indicator washers or bolts may be used at Contractor's option.
 - 3. Provide hot-dipped galvanized fasteners at relieving angles.
- H. Steel Shear Studs: Headed type manufactured from steel conforming to ASTM A108 Grade C1015 by KSM or Nelson. Refer to Drawings for diameter and length.

- I. Electrodes for Welding: E70XX and comply with AWS Codes with proper rod to produce optimum weld joint considering material, weld position and size of joint. All filler metal used for complete penetration groove welds shall have a minimum Charpy V Notch value of 20 ft-lbs. at 40 degrees F for enclosed and heated structures and 20 ft-lbs. at 0 degrees F for all other structures. Electrodes shall be compatible with steel of both connected elements.
- J. Structural Steel Coatings shall be as specified in the Structural Steel Coatings section of this specification, and as specified in Division 9.
- K. Steel Coatings for Exterior Exposed Steel: Except where indicated to be primed and painted, Hot Dipped Galvanized per ASTM A123/A123M (latest edition). Galvanizing shall be applied in a manner to provide Class C faying surfaces for slip critical connections. See Structural Steel Coatings section for additional requirements for galvanizing and painting.
- L. Non Shrink Cement-Based Grout: See Section 03300
- M. Drilled Anchors: Expansion and adhesive by HILTI, SIMPSON or POWERS/RAWL as indicated on the drawings.

2.02 FABRICATION:

- A. Shop Fabrication and Assembly: Fabricate and assemble structural assemblies in shop to greatest extent possible. Fabricate items of structural steel in accordance with AISC Specifications and as indicated on final shop drawings.
 - 1. Properly mark and match-mark materials for field assembly. Fabricate for delivery sequence which will expedite erection and minimize field handling of materials.
 - 2. Where finishing is required, complete assembly, including welding of units, before start of finishing operations. Provide finish surfaces of members exposed in final structure free of markings, burrs and other defects.
- B. Connections: Weld or bolt shop connections, as indicated.
 - 1. Provide field bolted connections, except where welded connections or other connections are indicated.
 - 2. Provide high-strength threaded fasteners for principal bolted connections, except where unfinished bolts are indicated.
- C. High-Strength Bolted Connection: Install high-strength threaded fasteners in accordance with AISC "Specification for Structural Joints using ASTM A 325 or A 490 Bolts". Unless otherwise indicated, all bolted connections are to be tightened to the snug tight condition as defined by AISC.
- D. Welded Construction: Comply with AWS Codes for procedures, appearance and quality of welds, and methods used in correcting welding work.
- E. Holes for Other Work: Provide holes required for securing other work to structural steel framing, and for passage of other work through steel framing members, as shown on final shop drawings.

- F. Cut, drill, or punch holes perpendicular to metal surfaces. Do not flame cut holes or enlarge holes by burning. Drill holes in bearing plates.
- G. Camber, if any, is indicated on the drawings. Camber indicated is the required camber at time of erection. Contractor shall survey camber prior to placing metal deck.

2.03 STRUCTURAL STEEL COATINGS

- A. Coordinate coating requirements with the Architect, and with Division 9 of the specifications.
- B. To the greatest extent possible, structural steel coatings shall be shop applied.
- C. Galvanizing, priming and painting for structural steel permanently exposed to view shall meet the requirements of Section 10 of the Code of Standard Practice, "Architecturally Exposed Structural Steel".
- D. Provide venting/drainage holes in closed tubular members to be hot-dipped galvanized. Holes shall be provided in a location hidden from view in the final condition and in a manner that will not reduce the strength of the member. Hole locations shall be clearly indicated on the Shop Drawings and are subject to review by the Architect.
- E. Follow manufacturer's installation and safety instructions when applying coatings. Adhere to recoat time recommendations set forth by manufacturer.
- F. General: Shop priming of structural steel is not required for heated, interior steel not exposed to view unless noted otherwise.
- G. Steel which is to receive spray-on fireproofing shall not to be primed or painted, unless specified by the Architect.
- H. Coatings: All exterior steel and/or steel permanently exposed to view shall receive a coating. Unless noted otherwise, refer to Division 9 specifications for products and surface preparation requirements.
- I. Brick masonry loose lintels and relieving angle assemblies, including fasteners, shall be hot dipped galvanized, unless noted otherwise on the Architectural Drawings
- J. Unheated structural steel to be enclosed with architectural finishes, including but not by limitation, canopy members and/or roof pop-up members shall be primed with rust inhibitive alkyd primer, Tnemec Series 349 unless noted otherwise. Follow manufacturer's instructions for surface preparation and application. Substitution shall be equal to the above specified products, and shall be submitted for review.
- K. Steel Embedded in Concrete/Below Grade: Steel which is embedded in concrete, below grade/slab level, or as otherwise indicated on the drawings, shall be field painted with TNE MEC FIBRETAR No 250 Coal Tar Epoxy. Paint embedded areas only. Do not paint surfaces which are to be welded until welding is complete.
- L. Field Touch-up: Touch-up all paint and galvanizing damage, including but not by limitation, damage caused during shipping, erection, construction damage, and field welded steel. See Division 9 specifications for additional requirements.

PART 3 EXECUTION

3.01 ERECTION:

- A. General: Comply with AISC Specifications for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds.
- B. Erection Procedures: Comply with "Code of Federal Regulations, Part 1926" per the Occupational Safety and Health Administration (OSHA), Department of Labor (Latest Revision).
- C. Surveys: Employ a Registered Land Surveyor elevations of concrete bearing surfaces, and locations of anchor bolts and similar devices, before erection work proceeds, and report discrepancies to Architect and Structural Engineer. Do not proceed with erection until corrections have been made, or until compensating adjustments to structural steel work have been approved by Structural Engineer of Record. Additional surveys required to verify out-of-alignment work and/or corrective work shall be performed at the contractor's expense.
- D. Temporary Shoring and Bracing: This is the sole responsibility of the Contractor. Provide temporary shoring and bracing members with connections of sufficient strength to support imposed loads. Remove temporary members and connections when all permanent members are in place, and all final connections are made, including the floor and roof diaphragms. Provide temporary guy lines to achieve proper alignment of structures as erection proceeds. Comply with OSHA Standard referenced previous. Retain the services of a Specialty Structural Engineer (Not the Engineer of Record) to design specialty shoring and bracing.
- E. Anchor Bolts: Furnish anchor bolts and other connectors required for securing structural steel to foundations and other in-place work.
 - 1. Tighten anchor bolts after supported members have been positioned and plumbed. Do not remove wedges or shims, but if protruding, cut off flush with edge of base or bearing plate prior to packing with grout.
 - 2. Welding to anchor bolts for corrective measures is strictly prohibited without prior written approval from the Engineer.
- F. Setting Plates and Base Plates:
 - 1. Furnish templates and other devices as necessary for presetting bolts and other anchors to accurate locations. Refer to division 3 of the project Specifications for anchor bolt installation requirements in concrete.
 - 2. Clean concrete bearing surfaces of bond-reducing materials. Clean bottom surface of setting and bearing plates.
 - 3. Set loose and attached base plates for structural members on wedges or other adjusting devices.
 - 4. Pack non-shrink grout solidly between bearing surfaces and bases or plates to ensure that no voids remain. Finish exposed surfaces, protect installed materials,

and allow to cure. For proprietary grout materials, comply with manufacturer's instructions.

- G. Concrete slabs that are part of elevated floors framing systems shall achieve 28-day design strength prior to the application of any superimposed loads such as curtain walls, masonry veneer, mechanical equipment and stairs. Additional testing beyond that specified in division 3 required to verify the concrete strength prior to application of superimposed loads shall be done at the Contractor's expense.
- H. When installing expansion bolts or adhesive anchors, the contractor shall take measures to avoid drilling or cutting any existing reinforcement or damaging adjacent concrete. Holes shall be blown clean with compressed air and/or cleaned per manufacturer's recommendations prior to the installation of anchors.
- I. Field Assembly:
1. Set structural frames accurately to lines and elevations indicated.
 2. Align, adjust, level and plumb members of complete frame in to the tolerances indicated in the AISC Code of Standard Practice and in accordance with OSHA regulations.
 3. Clean bearing surfaces and other surfaces which will be in permanent contact before assembly.
 4. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 5. Splice members only where indicated and accepted on shop drawings.
 6. Do not enlarge unfair holes in members by burning or by use of drift pins, except in secondary bracing members. Ream holes that must be enlarged to admit bolts.
 7. Composite shear studs shall be installed using stud welding process with an appropriately sized insulating ferrule. Fillet welding of shear studs is not permitted. Ferrules shall be removed and discarded prior to concrete placement.
- J. Coat columns, base plates, and brace elements encased in concrete and/or below grade with coal tar epoxy. Coordinate coating with concrete work.
- K. Erection bolts: Remove erection bolts. On exposed welded construction fill holes with plug welds and grind smooth at exposed surface.
- L. Gas Cutting: Do not use gas cutting torches in field for correcting fabrication errors in primary structural framing. Cutting will be permitted only on secondary members which are not under stress, as accepted by the Engineer of Record. Finish gas-cut sections equal to a sheared appearance when permitted.
- M. Coating Damage: Touch up shop applied paint or galvanizing whenever damaged or bare. See "Coatings" sections for additional requirements.
- N. Field Cut Beam Web Penetrations:

1. Field cut beam web penetrations are not permitted without written approval from the Structural Engineer.
 2. Gas cutting torches are not permissible for cutting beam web penetrations without written approval from the Structural Engineer.
 3. Beams with field cut beam web penetrations may require reinforcement, subject to the evaluation by the Structural Engineer.
 4. The evaluation of field cut web penetrations by the Structural Engineers for Design-Build Subcontractors, including but not by limitation, Mechanical, Electrical, Plumbing and Sprinkler Subcontractors shall be compensated by the General Contractor or Design-Build Subcontractor.
 5. The cost of executing field cut web penetrations and the associated beam reinforcement for Design-Build Subcontractors, including but not by limitation, Mechanical, Electrical, Plumbing and Sprinkler Subcontractors shall be paid for by the General Contractor or Design-Build Subcontractor.
 6. Field cut beam web penetrations may not be permitted in certain locations, subject to the evaluation by the Structural Engineer.
- O. Welders shall have current evidence of passing and maintaining the AWS D1.1 Qualifications test available in the field.
- P. Welding electrodes, welding process, minimum preheat and interpass temperatures shall be in accordance with AISC and AWS specifications. Any structural steel damaged in welding shall be replaced.
- Q. Field Welded Moment Connections:
1. Welding of Moment Connections shall meet the requirements of FEMA 353.
 2. Backing materials for top and bottom flanges for field welded moment connections shall be removed, backgouge the weld root, and apply a reinforcing fillet weld.
 3. Where top flange steel backing materials are utilized, the backing may be left in place. In this case, the backing material shall be welded with a reinforcing fillet weld.

3.02 QUALITY CONTROL:

- A. General: Contractor is responsible for maintaining quality control in the field and for providing a structure that is in strict compliance with the Contract Documents.
1. Required inspection and testing services are intended to assist the Contractor in complying with the Contract Documents. These specified services, however, do not relieve the Contractor of his responsibility for compliance, nor are they intended to limit the Contractor's quality control efforts in the field.
- B. Testing: Owner shall engage an Independent Testing Agency to inspect all high-strength bolted and welded connections, to perform tests and prepare reports of their findings. All

connections must pass these inspections prior to the installation of subsequent work which they support.

1. Testing agency shall conduct tests and state in each report which specific connections were examined or tested, whether the connections comply with requirements, and specifically state any deviations therefrom.
2. Contractor shall provide access for testing agency to places where structural steel work is being fabricated, produced or erected so that required inspection and testing can be accomplished. Testing agency may inspect structural steel at plant before shipment. The Engineer, however, reserves the right, at any time before final acceptance, to reject material not complying with specified requirements.

C. Inspection Requirements (to be performed by the Independent Testing Agency):

1. Bolted Connections: Inspect all bolted connections in accordance with procedures outlined in the AISC "Specification for Structural Joints using ASTM A325 or A490 Bolts.
2. Snug Tight Bolted Connections:
 - a. The inspector shall monitor the installation of bolts to determine that all plies of connected material have been drawn together and that the selected procedure is used to tighten all bolts.
 - b. If the inspector does not monitor the installation of bolts, he shall visually inspect the connection to determine that all plies of connected material have been drawn together and conduct tests on a sampling connection bolts to determine if they have been tightened to the snug tight condition. The test sample shall consist of 10% of the bolts in the connection, but not less than two bolts, selected at random. If more than 10% of the tested bolts fail the initial inspection, the engineer reserves the right to increase the number of bolts tested.
3. Slip Critical Bolted Connections:
 - a. The inspector shall monitor the calibration of torquing equipment and the installation of bolts to determine that all plies of connected material have been drawn together and that the selected procedure is used to tighten all bolts.
 - b. If the inspector does not monitor the calibration or installation procedures, he shall test all bolts in the affected connection using a manual torque wrench to assure that the required pretension has been reached.
4. Field Welded Connections: inspect and test during fabrication of structural steel assemblies, and during erection of structural steel all welded connections in accordance with procedures outline in AWS D1.1. Record types and location of defects found in work. Record work required and performed to correct deficiencies.
 - a. Certify welders and conduct inspections and tests as required. Submit welder certifications to Engineer of Record. Perform visual inspection of all welds. Primary and secondary welds, including fillet welds, full penetration

welds, and deck puddle welds, applied in the field and/or shop, shall be visually inspected.

- b. Welds deemed questionable by visual inspection shall receive non-destructive testing. In addition, all partial and full penetration welds, and any other welds indicated on the drawings are to receive non-destructive testing. Non-destructive testing methods include the following:
 - 1. Radiographic Inspection: ASTM E 94 and ASTM E 142; minimum quality level "2-2T".
 - 2. Ultrasonic Inspection: ASTM E 164.
- c. All welds deemed unacceptable shall be repaired and retested at the Contractor's expense.

D. Composite Shear Studs/Deformed Bar Anchors:

- 1. Verify shear stud quantity and arrangement.
- 2. Visually inspect stud weld. A weld less than 360 degrees is cause for further testing by bending to 15 degrees per item 2 below. Strike all studs with a 3 pound sledge hammer with moderate force. Studs shall make a ringing sound when struck with the hammer. If a stud or studs breaks free, or fails to make a ringing sound, further testing shall be performed per item 3.
- 3. One stud in 100 shall be tested by bending to 15 degrees from vertical, and one stud in 200 shall be tested by bending to 30 degrees from vertical. Single bent studs may be left bent. Failure of stud weld during bend testing is cause for further testing per item 3.
- 4. When failure occurs during bend testing, additional bend testing shall be performed on 10 studs to either side of failed stud. Bend studs to 30 degrees from vertical. If failure occurs during additional testing, continue testing in series of 10 studs beyond failed stud until no failure occurs.
- 5. Straighten all studs that were bent in multiple stud testing. Replace all studs that fail.
- 6. Inspector shall verify that all ferrules are removed and that composite metal deck is free of debris prior to concrete placement.

E. Testing and inspection reports shall be submitted to the Owner, Architect and Engineer within 48 hours of completion of each test or inspection.

F. Nonconforming Work: Contractor shall be responsible for correcting deficiencies in structural steel work which inspections laboratory test reports have indicated to be not in compliance with requirements. Additional tests and/or surveys shall be performed, at the Contractor's expense, as may be necessary to show compliance of corrected work. Any costs associated with the Engineer's review and disposition of faulty works shall be borne by the Contractor.

END OF SECTION

STRUCTURAL STEEL
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100% Construction Documents 7/16/07

SECTION 05300 – METAL DECKING

PART 1 GENERAL

1.01 RELATED DOCUMENTS

- A. The drawings and general conditions of the contract including General and Supplementary Conditions and other Division 1 Specification sections apply to work of this section.
- B. Examine all other sections of the Specifications for requirements which affect work of this Section whether or not such work is specifically mentioned in this Section.
- C. Coordinate work with that of all trades affecting or affected by work of this Section. Cooperate with such trades to assure the steady progress of all work under the Contract.

1.02 DESCRIPTION OF WORK

- A. Extent of metal floor and roof deck is shown on the drawings and includes type VL composite floor deck, roof deck, cell closures, end plates, pour stops with vertical leg return lip, metal lath column closures, composite finish strips, welding washers and sump plates or pans.

1.03 RELATED WORK

- 1. Section 05120 - Structural Steel
- 2. Section 05500 - Metal Fabrications

1.04 QUALITY STANDARDS

- A. Codes and Standards: Comply with provisions of the following codes and standards, except where more stringent requirements are indicated or specified:
 - 1. AISI "Specification for the Design of Cold Formed Steel Structural Members".
 - 2. AWS D1.1 "Structural Welding Code" - Steel
 - 3. AWS D1.3 "Structural Welding Code" - Sheet Steel
 - 4. Steel Deck Institute (SDI) " Design Manual for Floor Decks and Roof Decks".
 - 5. "Code of Federal Regulations, Part 1926" per the Occupational Safety and Health Administration (OSHA), Department of Labor (Latest Revision).
- B. Qualification of field welding: Qualify welding process and welding operators in accordance with AWS D1.1 "Standard Qualification Procedure."

1.05 SUBMITTALS

- A. Unless otherwise specified, submittals required in this section shall be submitted for review. Submittals shall be prepared and submitted in accordance with this section and Division 1.
- B. General Contractor shall submit a Submittal Schedule to the engineer within 30 days after they have received the Owner's Notice to Proceed.
- C. All submittals shall be reviewed and returned to the Architect within 10 working days.
- D. Incomplete submittals will not be reviewed.
- E. Submittals not reviewed by the General Contractor prior to submission to the Engineer will not be reviewed. Include on the submittal statement or stamp of approval by Contractor, representing that the Contractor has seen and examined the submittal and that all requirements listed in Division 1 have been complied with.
- F. Engineer will review submittals a maximum of two review cycles as part of their normal services. If submittals are incomplete or otherwise unacceptable and re-submitted, General Contractor shall compensate Engineer for additional review cycles.
- G. Product Data: Submit manufacturer's specifications and installation instructions for each type of decking and accessories. Include manufacturer's certification as may be required to show compliance with these specifications.
- H. Shop Drawings:
 - 1. Shop Drawing Review: Electronic files of structural drawings **will not** be provided to the contractor for preparation of shop drawings.
 - a. Submit detailed drawings showing layout and types of deck panels, galvanizing, shop paint, anchorage details, and conditions requiring closure panels, supplementary framing, sump pans, cant strips, cut openings, special jointing, and all other accessories. Conformance of the Shop Drawings to the Contract Drawings remains the responsibility of the General Contractor. Engineer's review in no way relieves the General Contractor of this responsibility. Submit one print and one reproducible. Print will be reviewed and a reproducible will be returned to Contractor for printing and distribution. Multiple copies will not be marked by Engineer.
 - b. Shop drawings will not be reviewed as partial submittals. A complete submittal shall be provided and shall include; erection and piece drawings. Incomplete submittals will not be reviewed.

1.06 DELIVERY, STORAGE AND HANDLING:

- A. Deliver materials to site at such intervals to insure uninterrupted progress of work.

- B. Store materials to permit easy access for inspection and identification. Keep deck sheets off ground, using pallets, platforms, or other supports. Protect deck sheets and packaged materials from corrosion and deterioration.
- C. Do not store materials on structure in a manner that might cause distortion or damage to members or supporting structures. Materials shall be stored in a manner to avoid ponding of precipitation on members. Repair or replace damaged materials or structures as directed.

PART 2 PRODUCTS

2.01 GENERAL:

- A. Acceptable Manufacturers: Subject to compliance with requirements, manufacturers offering products which may be incorporated in the work include, but are not limited to, the following:
 - 1. United Steel Deck
 - 2. Wheeling Corrugating Co.
 - 3. Epic Metals Corporation
 - 4. Vulcraft
- B. Materials:
 - 1. Steel for Metal Deck Units:
 - a. Floor Deck Units: ASTM A611, Grade C, D or ASTM 653-94, Structural Quality, grade 40 or higher
 - b. Roof Deck Units: ASTM A611, Grade C, D, or E, or ASTM 653-94, Structural Quality, grade 33 or higher.
 - 2. Miscellaneous Steel Shapes: ASTM A36 minimum.
 - 3. Sheet metal Accessories: ASTM A526, commercial quality, galvanized.
- C. Galvanizing: Conform to ASTM 924-94 with minimum coating class of G60 (Z180) as defined in ASTM A653-94.
- D. Paint: Manufacturer's baked on, rust inhibitive paint, for application to metal surfaces which have been chemically cleaned and phosphate chemical treated.
- E. Flexible closure Strips: Manufacturer standard vulcanized, closed-cell, synthetic rubber.

2.02 FABRICATION:

- A. General: Form deck units in lengths to span 3 or more supports, unless otherwise noted on the drawings, with flush, telescoped or nested 2" laps at ends and interlocking or nested side laps, unless otherwise indicated. For roof deck units, provide deck configurations complying with SDI "Roof Deck Specifications," of metal thickness, depth and width as shown.
- B. Metal Cover Plates: Fabricate metal cover plates for end-abutting floor deck units of not less than same thickness as decking. Form to match contour of deck units and approximately 6" wide.
- C. Metal Closure Strips: Fabricate metal closure strips, cell closures, "Z" closures, column closures, pour stops, girder fillers and openings between decking and other construction, of not less than 0.045" min. (18 gage) sheet steel or as indicated on the drawings. Form to provide tight fitting closures at open ends of cells or flutes and sides of decking.
- D. Pour Stops: Minimum material thickness shall be 18 gage or as indicate on drawings.. Fabricate vertical leg to accommodate specified slab thickness. Fabricate horizontal leg to minimize field cuts. Provide welded attachment sufficient to resist forces during concrete placement.
- E. Roof Sump Pans: Fabricate from a single piece of 0.071" min. (14 gage) galvanized sheet steel with level bottoms and sloping sides to direct water flow to the drains, unless otherwise shown. Provide sump pans of adequate size to receive roof drains and with bearing flanges not less than 3" wide. Recess pans not less than 1 1/2" below roof deck surface, unless otherwise shown or required by deck configuration. Holes for drains will be cut in the field.
- F. Provide all pour stops and accessories necessary to contain concrete for poured concrete surfaces.

PART 3 EXECUTION

3.01 INSTALLATION:

- A. Install deck units and accessories in accordance with manufacturer's recommendations and final shop drawings, and as specified herein.
- B. Place deck units on supporting steel framework and adjust to final position with ends accurately aligned and bearing on supporting members before permanently fastened. Deck shall be in full contact with members parallel to ribs and attached as indicated. Do not stretch or contact side lap interlocks.
- C. Place deck units in straight alignment for entire length of run of cells and with close alignment between cells at ends of abutting units.
- D. Place deck units flat and square, secured to adjacent framing without warp or excessive deflection.

- E. Coordinate and cooperate with the structural steel erector in locating decking bundles to prevent overloading of structural members.
- F. Do not use decking units for storage or working platforms until permanently installed.

3.02 FASTENING:

- A. Floor Deck: Fasten metal deck to supporting steel members as indicated on the Design Drawings: Each deck is to be fastened with a minimum of 5/8" diameter puddle welds spaced not more than 12" o.c. with a minimum of 2 welds per unit at each support. Secure deck units at 6" oc along brace lines, edge of building or at the edge of openings or deck discontinuity. Secure deck to each supporting member in ribs where sidelaps occur. Use welding washers where recommended by the deck manufacturer. Deck units shall bear over the ends of supports by a minimum of 1.5. Sidelaps: #10 Tek screws, 5/8" arc puddle welds or 1" long fillet welds, intervals not exceeding 36 inches. Crimped or button punched sidelaps are not permitted.
- B. Roof Deck: Each deck is to be fastened with a minimum of 5/8" diameter puddle welds spaced in a 24/4 pattern (3N deck) or 36/7 pattern (1.5B deck) with a minimum of 2 welds per unit at each support if incomplete sheet is utilized. Where support is parallel to support, at edge of building, at brace lines, at edge of opening or deck discontinuity provide puddle welds at 6" o.c. Secure deck to each supporting member in ribs where sidelaps occur. Deck units shall bear over the ends of supports by a minimum of 1.5". Sidelaps: #10 Tek screws, 5 per span for N deck.
- C. Welding: Comply with AWS requirements and procedures for manual shielded metal arc welding, appearance and quality of welds, and methods used in correcting welding work.
- D. Uplift loading: Floor deck units are not required to resist uplift loads. Decking units used at the roof level shall be designed for a net uplift of 25 psf.
- E. Cutting and Fitting: Cut and neatly fit deck units and accessories around other work projecting through or adjacent to the decking.
- F. Reinforcement at openings: Provide additional metal reinforcement and closures pieces as required for strength, continuity of decking and support of other work shown.
 - 1. Deck penetrations affecting no more than (1) deck rib need not be reinforced.
 - 2. For deck penetration affecting more than (1) deck rib, but less than 10", reinforce the opening with a 0.057" thick plate spanning between unaffected ribs, unless otherwise shown on the Design Drawings or supporting a piece of mechanical equipment (see item 3).
 - 3. Reinforce deck penetrations larger than 10" with the structural frame described in the Design Drawings.
- G. Joint Covers: Provide metal joint covers at abutting ends and changes in direction of floor deck units.

- H. Roof Sump Pans: Place over openings provided in roof decking and weld to top decking surface. Space welds not more than 12" on center with at least 1 weld in each corner. Cut opening in roof sump bottom to accommodate drain size indicated.
- I. Closure Strips: Provide metal closure strips at open uncovered ends and edges of roof decking, and in voids between decking and other construction. Weld into position to provide a complete decking installation.
- J. Touch-Up Painting:
 - 1. Painted Deck: After decking installation, wire brush, clean and paint scarred areas, welds and rust spots on top and bottom surfaces of decking units and supporting steel members.
 - a. Touch up painted surfaces with same type paint used on adjacent surfaces.
 - b. In areas where shop-painted surfaces are to be exposed, apply touch-up paint to blend into adjacent surfaces.

3.03 QUALITY CONTROL:

- A. General: Contractor is responsible for maintaining quality control in the field and for providing a structure that is in strict compliance with the Contract Documents.
- B. Required inspection and testing services are intended to assist the Contractor in complying with the Contract Documents. These specified services, however, do not relieve the Contractor of his responsibility for compliance, nor are they intended to limit the Contractor's quality control efforts in the field.
- C. Testing: Owner shall engage an Independent Testing Agency to inspect all puddle welded connections, to perform tests and prepare reports of their findings. All connections must pass these inspections prior to the installation of subsequent work which they support.
- D. Deck Testing Requirements (to be performed by the Independent Testing Agency):
 - 1. Deck and accessory welding and/or attachments subject to inspection and testing. Work found to be defective will be removed and replaced at the Contractor's expense.
 - 2. Provide certification that welders to be employed in work have satisfactorily passed AWS qualification tests. If re-certification of welders is required, re-testing will be the Contractor's responsibility.

END OF SECTION

SECTION 05400 - COLD-FORMED METAL FRAMING

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. Exterior non-load-bearing wall framing.
 2. Exterior ceiling and soffit framing.
- B. Related Sections include the following:
1. Division 9 Section "Gypsum Board Assemblies" for interior non-load-bearing, metal-stud framing and ceiling-suspension assemblies.
 2. Division 7 Section "Metal Wall Panels" for framing outboard of gypsum sheathing at metal wall panel surfaces.

1.3 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide cold-formed metal framing capable of withstanding design loads within limits and under conditions indicated.
1. Design Loads: As follows:
 - a. Dead Loads for Ceiling and Soffit Framing: Weights of materials and construction.
 - b. Basic Wind Speed: 100 mph
 - c. Components and Cladding Pressure on System (including internal pressure): 22 psf at center of building elevations. Adjust analysis to account for higher pressures at building corners.
 - d. Importance Factor: 1.0.
 - e. Exposure Category: B.
 - f. Design Seismic Story Drift (with amplification factor): 2.5".
 2. Deflection Limits: Design framing systems to withstand design loads without deflections greater than the following:
 - a. Exterior Non-Load-Bearing Framing: Horizontal deflection of 1/360 of the wall height.
 3. Design framing systems to provide for movement of framing members without damage or overstressing, sheathing failure, connection failure, undue strain on fasteners and

anchors, or other detrimental effects when subject to a maximum ambient temperature change of 120 deg F.

4. Design framing system to maintain clearances at openings, to allow for construction tolerances, and to accommodate live load deflection of primary building structure as follows:

- a. Upward and downward movement of 1 inch.

- B. Cold-Formed Steel Framing, General: Design according to AISI's "Standard for Cold-Formed Steel Framing - General Provisions."

1. Headers: Design according to AISI's "Standard for Cold-Formed Steel Framing - Header Design."
2. Design exterior non-load-bearing wall framing to accommodate horizontal deflection without regard for contribution of sheathing materials.

1.4 SUBMITTALS

- A. Product Data: For each type of cold-formed metal framing product and accessory indicated.

- B. Shop Drawings: Show layout, spacings, sizes, thicknesses, and types of cold-formed metal framing; fabrication; and fastening and anchorage details, including mechanical fasteners. Show reinforcing channels, opening framing, supplemental framing, strapping, bracing, bridging, splices, accessories, connection details, and attachment to adjoining work.

1. For cold-formed metal framing, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation. Indicate required gauges for framing necessary to resist design loads.

- C. Welding certificates.

- D. Qualification Data: For professional engineer.

- E. Product Test Reports: From a qualified testing agency, unless otherwise stated, indicating that each of the following complies with requirements, based on evaluation of comprehensive tests for current products:

1. Steel sheet.
2. Expansion anchors.
3. Power-actuated anchors.
4. Mechanical fasteners.
5. Vertical deflection clips.
6. Horizontal drift deflection clips
7. Miscellaneous structural clips and accessories.

1.5 QUALITY ASSURANCE

- A. Engineering Responsibility: Preparation of Shop Drawings, design calculations, and other structural data by a qualified professional engineer.

- B. 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 cold-formed metal framing that are similar to those indicated for this Project in material, design, and extent.
- C. Testing Agency Qualifications: An independent testing agency, acceptable to authorities having jurisdiction, qualified according to ASTM E 329 to conduct the testing indicated.
- D. Product Tests: Mill certificates or data from a qualified independent testing agency, or in-house testing with calibrated test equipment indicating steel sheet complies with requirements, including base-metal thickness, yield strength, tensile strength, total elongation, chemical requirements, ductility, and metallic-coating thickness.
- E. Welding: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code--Steel," and AWS D1.3, "Structural Welding Code--Sheet Steel."
- F. Fire-Test-Response Characteristics: Where indicated, provide cold-formed metal framing identical to that of assemblies tested for fire resistance per ASTM E 119 by a testing and inspecting agency acceptable to authorities having jurisdiction.
- G. AISI Specifications and Standards: Comply with AISI's "North American Specification for the Design of Cold-Formed Steel Structural Members" and its "Standard for Cold-Formed Steel Framing - General Provisions."

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Available Manufacturers: Subject to compliance with requirements, manufacturers offering cold-formed metal framing that may be incorporated into the Work include, but are not limited to, the following:
 - 1. Allied Studco.
 - 2. AllSteel Products, Inc.
 - 3. California Expanded Metal Products Company.
 - 4. Clark Steel Framing.
 - 5. Consolidated Fabricators Corp.; Building Products Division.
 - 6. Craco Metals Manufacturing, LLC.
 - 7. Custom Stud, Inc.
 - 8. Dale/Incor.
 - 9. Design Shapes in Steel.
 - 10. Dietrich Metal Framing; a Worthington Industries Company.
 - 11. Formetal Co. Inc. (The).
 - 12. Innovative Steel Systems.
 - 13. MarinoWare; a division of Ware Industries.
 - 14. Quail Run Building Materials, Inc.
 - 15. SCAFCO Corporation.
 - 16. Southeastern Stud & Components, Inc.
 - 17. Steel Construction Systems.

18. Steeler, Inc.
19. Super Stud Building Products, Inc.
20. United Metal Products, Inc.
21. Or Approved Equal.

2.2 MATERIALS

- A. Steel Sheet: ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of grade and coating weight as follows:
 1. Grade: ST33H.
 2. Coating: G90 or equivalent.
- B. Steel Sheet for Vertical Deflection Clips: ASTM A 653/A 653M, structural steel, zinc coated, of grade and coating as follows:
 1. Grade: 50, Class 1.
 2. Coating: G90.

2.3 EXTERIOR NON-LOAD-BEARING WALL FRAMING

- A. Steel Studs: Manufacturer's standard C-shaped steel studs, of web depths indicated, punched, with stiffened flanges, and as follows:
 1. Minimum Base-Metal Thickness: 0.0428 inch.
- B. Steel Track: Manufacturer's standard U-shaped steel track, of web depths indicated, unpunched, with unstiffened flanges, and as follows:
 1. Minimum Base-Metal Thickness: 0.0428 inch.
- C. Vertical Deflection Clips: Manufacturer's standard head clips, capable of accommodating upward and downward vertical displacement of primary structure through positive mechanical attachment to stud web.
 1. Available Manufacturers: Subject to compliance with requirements, manufacturers offering vertical deflection clips that may be incorporated into the Work include, but are not limited to, the following:
 - a. Dietrich Metal Framing; a Worthington Industries Company.
 - b. MarinoWare, a division of Ware Industries.
 - c. SCAFCO Corporation
 - d. The Steel Network, Inc.
 - e. Or Approved Equal.
- D. Single Deflection Track: Manufacturer's single, deep-leg, U-shaped steel track; unpunched, with unstiffened flanges, of web depth to contain studs while allowing free vertical movement, with flanges designed to support horizontal and lateral loads and transfer them to the primary structure, and as follows:

1. Minimum Base-Metal Thickness: 0.0428 inch.
- E. Double Deflection Tracks: Manufacturer's double, deep-leg, U-shaped steel tracks, consisting of nested inner and outer tracks; unpunched, with unstiffened flanges.
1. Outer Track: Of web depth to allow free vertical movement of inner track, with flanges designed to support horizontal and lateral loads and transfer them to the primary structure, and as follows:
 - a. Minimum Base-Metal Thickness: 0.0428 inch.
 2. Inner Track: Of web depth indicated, and as follows:
 - a. Minimum Base-Metal Thickness: 0.0428 inch.
- F. Drift Clips: Manufacturer's standard bypass or head clips, capable of isolating wall stud from upward and downward vertical displacement and lateral drift of primary structure.
- 2.4 CEILING FRAMING
- A. Manufacturer's standard C-shaped steel sections, of web depths indicated, unpunched, with stiffened flanges, and as follows:
1. Minimum Base-Metal Thickness: As indicated.
 2. Flange Width: As indicated.
- 2.5 FRAMING ACCESSORIES
- A. Fabricate steel-framing accessories from steel sheet, ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of same grade and coating weight used for framing members.
- B. Provide accessories of manufacturer's standard thickness and configuration, unless otherwise indicated, as follows:
1. Supplementary framing.
 2. Bracing, bridging, and solid blocking.
 3. Web stiffeners.
 4. Anchor clips.
 5. End clips.
 6. Foundation clips.
 7. Gusset plates.
 8. Stud kickers, knee braces, and girts.
 9. Hole reinforcing plates.
 10. Backer plates.
- 2.6 ANCHORS, CLIPS, AND FASTENERS
- A. Steel Shapes and Clips: ASTM A 36/A 36M, zinc coated by hot-dip process according to ASTM A 123/A 123M.

- B. Expansion Anchors: Fabricated from corrosion-resistant materials, with capability to sustain, without failure, a load equal to 5 times design load, as determined by testing per ASTM E 488 conducted by a qualified independent testing agency.
- C. Mechanical Fasteners: ASTM C 1513, corrosion-resistant-coated, self-drilling, self-tapping steel drill screws.
 - 1. Head Type: Low-profile head beneath sheathing, manufacturer's standard elsewhere.
- D. Welding Electrodes: Comply with AWS standards.

2.7 MISCELLANEOUS MATERIALS

- A. Galvanizing Repair Paint: [SSPC-Paint 20 or DOD-P-21035] [ASTM A 780].
- B. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, and plasticizing and water-reducing agents, complying with ASTM C 1107, with fluid consistency and 30-minute working time.
- C. Shims: Load bearing, high-density multimonomer plastic, nonleaching.
- D. Sealer Gaskets: Closed-cell neoprene foam, 1/4 inch thick, selected from manufacturer's standard widths to match width of bottom track or rim track members.

2.8 FABRICATION

- A. Fabricate cold-formed metal framing and accessories plumb, square, and true to line, and with connections securely fastened, according to referenced AISI's specifications and standards, manufacturer's written instructions, and requirements in this Section.
 - 1. Fabricate framing assemblies using jigs or templates.
 - 2. Cut framing members by sawing or shearing; do not torch cut.
 - 3. Fasten cold-formed metal framing members by welding, screw fastening, clinch fastening, or riveting as standard with fabricator. Wire tying of framing members is not permitted.
 - a. Comply with AWS D1.3 requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners and install according to Shop Drawings, with screw penetrating joined members by not less than three exposed screw threads.
- B. Reinforce, stiffen, and brace framing assemblies to withstand handling, delivery, and erection stresses. Lift fabricated assemblies to prevent damage or permanent distortion.
- C. Fabrication Tolerances: Fabricate assemblies level, plumb, and true to line to a maximum allowable tolerance variation of 1/8 inch in 10 feet and as follows:
 - 1. Spacing: Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.

2. Squareness: Fabricate each cold-formed metal framing assembly to a maximum out-of-square tolerance of 1/8 inch.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting substrates and abutting structural framing for compliance with requirements for installation tolerances and other conditions affecting performance.
 1. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Install sealer gaskets to isolate the underside of wall bottom track or rim track and the top of foundation wall or slab at stud locations.

3.3 INSTALLATION, GENERAL

- A. Cold-formed metal framing may be shop or field fabricated for installation, or it may be field assembled.
- B. Install cold-formed metal framing according to AISI's "Standard for Cold-Formed Steel Framing - General Provisions" and to manufacturer's written instructions unless more stringent requirements are indicated.
- C. Install shop- or field-fabricated, cold-formed framing and securely anchor to supporting structure.
 1. Screw, bolt, or weld wall panels at horizontal and vertical junctures to produce flush, even, true-to-line joints with maximum variation in plane and true position between fabricated panels not exceeding 1/16 inch.
- D. Install cold-formed metal framing and accessories plumb, square, and true to line, and with connections securely fastened.
 1. Cut framing members by sawing or shearing; do not torch cut.
 2. Fasten cold-formed metal framing members by welding, screw fastening, clinch fastening, or riveting. Wire tying of framing members is not permitted.
 - a. Comply with AWS D1.3 requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners and install according to Shop Drawings, and complying with requirements for spacing, edge distances, and screw penetration.
- E. Install framing members in one-piece lengths unless splice connections are indicated for track or tension members.

- F. Install temporary bracing and supports to secure framing and support loads comparable in intensity to those for which structure was designed. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to framing are secured.
- G. Do not bridge building expansion and control joints with cold-formed metal framing. Independently frame both sides of joints.
- H. Fasten hole reinforcing plate over web penetrations that exceed size of manufacturer's standard punched openings.
- I. Erection Tolerances: Install cold-formed metal framing level, plumb, and true to line to a maximum allowable tolerance variation of 1/8 inch in 10 feet and as follows:
 - 1. Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.

3.4 EXTERIOR NON-LOAD-BEARING WALL INSTALLATION

- A. Install continuous tracks sized to match studs. Align tracks accurately and securely anchor to supporting structure as indicated.
- B. Fasten both flanges of studs to top and bottom track, unless otherwise indicated. Space studs as follows:
 - 1. Stud Spacing: 16 inches.
- C. Set studs plumb, except as needed for diagonal bracing or required for nonplumb walls or warped surfaces and similar requirements.
- D. Isolate non-load-bearing steel framing from building structure to prevent transfer of vertical loads while providing lateral support.
 - 1. Install single-leg or double deep-leg deflection tracks as required.
 - 2. Install single-leg deflection tracks and anchor to building structure.
 - 3. Install double deep-leg deflection tracks and anchor outer track to building structure.
 - 4. Connect vertical deflection clips to infill studs and anchor to building structure.
 - 5. Connect drift clips to cold formed metal framing and anchor to building structure.
- E. Install horizontal bridging in wall studs, spaced in rows indicated on Shop Drawings but not more than 48 inches apart. Fasten at each stud intersection.
 - 1. Top Bridging for Single Deflection Track: Install row of horizontal bridging within 12 inches of single deflection track. Install a combination of flat, taut, steel sheet straps of width and thickness as required by design and stud or stud-track solid blocking of width and thickness matching studs. Fasten flat straps to stud flanges and secure solid blocking to stud webs or flanges.
 - a. Install solid blocking at centers indicated on Shop Drawings.

2. Install required bridging. Bridging may be as follows:
 - a. Cold-rolled steel channel, welded or mechanically fastened to webs of punched studs.
 - b. Combination of flat, taut, steel sheet straps of width and thickness indicated and stud-track solid blocking of width and thickness to match studs. Fasten flat straps to stud flanges and secure solid blocking to stud webs or flanges.
 - c. Proprietary bridging bars installed according to manufacturer's written instructions.
- F. Install miscellaneous framing and connections, including stud kickers, web stiffeners, clip angles, continuous angles, anchors, fasteners, and stud girts, to provide a complete and stable wall-framing system.

3.5 INSTALLING STEEL SUSPENDED CEILING AND SOFFIT FRAMING

- A. Install suspended steel framing components in sizes and spacings required by the referenced steel framing and installation standards and as required to meet live and dead loads and requirements of 2003 International Building Code.
- B. Suspend ceiling hangers from building structure as follows:
 1. Install hangers plumb and free from contact with insulation or other objects within ceiling plenum that are not part of supporting structural or ceiling suspension system. Splay hangers only where required to miss obstructions and offset resulting horizontal forces by bracing, countersplaying, or other equally effective means.
 2. Where width of ducts and other construction within ceiling plenum produces hanger spacings that interfere with the location of hangers required to support standard suspension system members indicated, install supplemental suspension members. Size supplemental suspension members, spacings and hangers to support ceiling loads within performance limits established by referenced standards.
 3. Secure wire hangers by looping and wire-tying, either directly to structures or to inserts, or other devices and fasteners that are secure and appropriate for substrate, and in a manner that will not cause them to deteriorate or otherwise fail.
 4. Secure hangers to structure, including intermediate framing members, by attaching to inserts, or other devices and fasteners that are secure and appropriate for structure and hanger, and in a manner that will not cause hangers to deteriorate or otherwise fail.
 5. Do not connect or suspend steel framing from ducts, pipes, or conduit.
- C. Installation Tolerances: Install steel framing components for suspended ceilings so members for panel attachment are level to within 1/8 inch in 12 feet measured lengthwise on each member and transversely between parallel members.
- D. Sway-brace suspended steel framing.

3.6 FIELD QUALITY CONTROL

- A. Testing: Owner will engage a qualified independent testing and inspecting agency to perform field tests and inspections and prepare test reports.
- B. Field and shop welds will be subject to testing and inspecting.

- C. Testing agency will report test results promptly and in writing to Contractor and Architect.
- D. Remove and replace work where test results indicate that it does not comply with specified requirements.
- E. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of replaced or additional work with specified requirements.

3.7 REPAIRS AND PROTECTION

- A. Galvanizing Repairs: Prepare and repair damaged galvanized coatings on fabricated and installed cold-formed metal framing with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Provide final protection and maintain conditions, in a manner acceptable to manufacturer and Installer, that ensure that cold-formed metal framing is without damage or deterioration at time of Substantial Completion.

END OF SECTION

SECTION 05501 - 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. Steel ladders at elevator pits and roofs.
 2. Metal fence and posts at top of retaining wall.
 3. Loose steel lintels (lintels not attached to other steel structure but simply bearing on masonry), furnished in of this Section for installation as a part of Division 4 Section "Unit Masonry Assemblies."
 4. Shelf angles.
 5. Support angles for elevator door sills.
 6. Elevator machine beams.
 7. Steel framing and supports for countertops.
 8. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 9. Steel channels, angles, metal trim and framing for applications where framing and supports are indicated in the Architectural drawings but not indicated in the Structural Drawings or specified in sections of the specifications other than this one.
- 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 metal-framed stairs.
 3. Division 5 Section "Ornamental Metal" for ornamental metal items fabricated from custom components.
 4. Division 5 Section "Formed Metal Fabrications" for custom formed aluminum.
 5. Division 6 Section "Rough Carpentry" for metal framing anchors and other rough hardware.
 6. Division 6 Section "Interior Architectural Woodwork" for reinforcing angles built into countertops.
 7. Division 9 Section "Painting" for priming of galvanized metal fabrications and finish painting of ferrous and galvanized metal fabrications.

1.3 SUBMITTALS

- A. Product Data: For the following:
1. Grout.

2. Paint.

- 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. Welding Certificates: Copies of certificates for welding procedures and personnel.

- D. 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 D1.3, "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.

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.

1.6 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.

1.7 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.

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. Steel Tubing: Cold-formed steel tubing complying with ASTM A 500.
- F. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- G. Malleable-Iron Castings: ASTM A 47, Grade 32510 (ASTM A 47M, Grade 22010).
- H. Gray-Iron Castings: ASTM A 48, Class 30 (ASTM A 48M, Class 200), unless another class is indicated or required by structural loads.
- I. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

2.3 PAINT

- A. Shop Primer for Ferrous Metal: Organic zinc-rich primer, complying with SSPC-Paint 20 and compatible with topcoat.
 1. Products: Subject to compliance with requirements, provide one of the following or approved equal:
 - a. Carboline 621; Carboline Company.

- b. Aquapon Zinc-Rich Primer 97-670; PPG Industries, Inc.
 - c. Tneme-Zinc 90-97; Tnemec Company, Inc.
- B. Galvanizing Repair Paint: High-zinc-dust-content paint for galvanizing 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.
- J. Toggle Bolts: FS FF-B-588, tumble-wing type, class and style as needed.

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.

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 STEEL LADDERS

- A. General: Fabricate ladders for locations shown, with dimensions, spacings, details, and anchorages as indicated.
 - 1. Comply with ANSI A14.3, unless otherwise indicated.
 - 2. For elevator pit ladders, comply with ASME A17.1.
- B. Siderails: Continuous, 3/8-by-2-1/2-inch steel flat bars, with eased edges, spaced 16 inches apart.
- C. Bar Rungs: 3/4-inch-square steel bars, spaced 12 inches o.c.
- D. Fit rungs in centerline of side rails; plug-weld and grind smooth on outer rail faces.
- E. Galvanize exterior ladders, including fasteners, after fabrication.
- F. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted steel brackets. Size brackets to support design loads specified in ANSI A14.3.
- G. Provide nonslip surfaces on top of each rung, either by coating rung with aluminum-oxide granules set in epoxy-resin adhesive or by using a type of manufactured rung filled with aluminum-oxide grout.

2.8 LOOSE STEEL LINTELS

- A. Loose steel lintels are lintels not attached to other steel structure but simply bearing on masonry. Sizes of loose lintels may be indicated in the structural drawings, but shall be provided as part of the work of this Section. Openings in masonry veneer walls requiring loose steel lintels shall have 8" x 8" x 1/2" galvanized steel angle loose lintels unless otherwise indicated. Provide loose lintels to the masonry subcontractor for installation. Steel angles attached to structural steel or structural steel studs are not loose lintels and are a part of the work of Section 05100 - "Structural Steel." Provide new loose steel lintels at all locations where the work requires the relocation of existing masonry openings. Do not re-use existing loose steel lintels.
- B. Fabricate loose lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.
- C. Weld adjoining members together to form a single unit where indicated.
- D. 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, unless otherwise indicated. Where loose lintels occur at horizontal masonry control joints indicated in the elevations, run loose lintels continuously, including at masonry areas between windows.
- E. Galvanize loose steel lintels located in exterior walls.

2.9 SHELF ANGLES

- A. Fabricate shelf angles from steel angles of sizes indicated and for attachment to framing. Provide horizontally slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and no more than 24 inches o.c., unless otherwise indicated.
- B. For cavity walls, provide vertical channel brackets to support angles from backup masonry and concrete. Align expansion joints in angles with indicated control and expansion joints in cavity-wall exterior wythe.
- C. Galvanize shelf angles to be installed in exterior walls.
- D. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.

2.10 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. 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 wide by 1/4 inch thick by 8 inches long at 24 inches o.c., unless otherwise indicated.
 - 3. Furnish inserts if units must be installed after concrete is placed.
- C. Galvanize miscellaneous framing and supports where indicated.

2.11 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 from each end, 6 inches from corners, and 24 inches o.c., unless otherwise indicated.
- C. Galvanize miscellaneous steel trim in the following locations:
 - 1. Exterior, including steel fence and posts.

2.12 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.

2.13 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.

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.

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, if any.

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 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

SECTION 05511 - METAL STAIRS

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. Preassembled steel stairs with concrete-filled treads.
 - 2. Guards and railings attached to metal stairs.
 - 3. Handrails attached to walls adjacent to metal stairs.
 - 4. Railing gates at the level of exit discharge.
- B. Related Sections include the following:
 - 1. Division 3 Section "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
 - 2. Division 6 Section "Rough Carpentry" for wood blocking for anchoring railings.
 - 3. Division 6 Section "Interior Architectural Woodwork" for wood portions of handrails for ornamental steel-framed stairs.
 - 4. Division 9 Section "Gypsum Board Assemblies" for metal backing for anchoring railings.
 - 5. Division 9 Section "Tile" for treads at stairs.

1.3 PERFORMANCE REQUIREMENTS

- A. Provide stairs and railings capable of meeting the requirements of governing authorities and the State of Maine Building Code, but no less than the following:
- B. Structural Performance of Stairs: Provide metal stairs capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Uniform Load: 100 lbf/sq. ft.
 - 2. Concentrated Load: 300 lbf applied on an area of 4 sq. in.
 - 3. Uniform and concentrated loads need not be assumed to act concurrently.
 - 4. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
 - 5. Limit deflection of treads, platforms, and framing members with cement treads to L/360 or 1/4 inch, whichever is less.
 - 6. Limit deflection of treads, platforms, and framing members with stone treads to L/720 or 1/4 inch, whichever is less.
- C. 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/ ft. applied in any direction.
 - b. Concentrated load of 200 lbf 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. applied horizontally and concurrently with 100 lbf/ ft. applied vertically downward.
 - b. Concentrated load of 200 lbf applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 3. Infill of Guards:
 - a. Concentrated load of 200 lbf applied horizontally on an area of 1 sq. ft.
 - b. Uniform load of 25 lbf/sq. ft. 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."

1.4 SUBMITTALS

- A. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
 1. Provide templates for anchors and bolts specified for installation under other Sections.
 2. 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.
- B. Samples for Initial Selection: For products involving selection of color, texture, or design.
- C. Welding certificates.
- D. Qualification Data: For professional engineer and testing agency.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for stairs and railings.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: Fabricator of products.
- 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. Preassembled Stairs: Commercial class.

C. 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."

1.6 COORDINATION

- A. Coordinate installation of anchorages for metal stairs. 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 locations of hanger rods and struts with other work so that they will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.

PART 2 - PRODUCTS

2.1 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces, unless otherwise indicated. For components exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.

2.2 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513, Type 5 (mandrel drawn).
- C. 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.

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; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Anchor Bolts: ASTM F 1554, Grade 36.
- D. Machine Screws: ASME B18.6.3.

- E. Lag Bolts: ASME B18.2.1.
- F. Plain Washers: Round, ASME B18.22.1.
- G. Lock Washers: Helical, spring type, ASME B18.21..
- H. 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. Material for Anchors in Interior Locations: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.

2.4 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Shop Primers: Provide primers that comply with Division 9 painting Sections.
- C. 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).
- D. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.
- E. 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, unless otherwise indicated.

2.5 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, struts, 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.
- B. Preassembled Stairs: Assemble stairs in shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.
- C. 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.

- D. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- E. Form exposed work true to line and level with accurate angles and surfaces and straight edges.
- F. 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.
- G. 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.

2.7 STEEL-FRAMED STAIRS

- A. Stair Framing:
 - 1. Fabricate stringers of steel plates or channels as indicated.
 - a. Provide closures for exposed ends of channel stringers.
 - 2. Construct platforms of steel plate or channel headers and miscellaneous framing members as needed to comply with performance requirements.
 - 3. Weld stringers to headers; weld framing members to stringers and headers.
 - 4. Where stairs are enclosed by gypsum board assemblies, provide hanger rods or struts to support landings from floor construction above or below. Locate hanger rods and struts where they will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.
 - 5. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.
- B. Metal-Pan Stairs: Form risers, subtread pans, and subplatforms to configurations shown from steel sheet of thickness needed to comply with performance requirements but not less than 0.0677 inch.
 - 1. Steel Sheet: Uncoated cold-rolled steel sheet.
 - 2. Directly weld metal pans to stringers; locate welds on top of subtreads where they will be concealed by concrete fill. Do not weld risers to stringers.
 - 3. Shape metal pans to include nosing integral with riser.
 - 4. At Contractor's option, provide stair assemblies with metal-pan subtreads filled with reinforced concrete during fabrication.

5. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.
 - a. Smooth Soffit Construction: Construct subplatforms with smooth soffits.

2.8 STEEL RAILINGS

- A. General: Fabricate railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including post spacings, and anchorage, but not less than that needed to withstand indicated loads.
 1. Configuration: Top and bottom rails and posts with infill panels of vertical steel pickets as indicated.
 2. Gates: Form gates from steel tube of same size and shape as top rails, with infill to match guards. Provide with cam-type self-closing hinges for fastening to wall and overlapping stop with rubber bumper to prevent gate from opening in direction opposite egress.
- B. Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.
- C. Form changes in direction of railings as follows:
 1. As detailed.
- D. Close exposed ends of railing members with prefabricated end fittings.
- E. 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.
- F. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
 1. Connect posts to stair framing by direct welding, unless otherwise indicated.
 2. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
- G. 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.

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. 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. Interior Stairs (SSPC Zone 1A): SSPC-SP 3, "Power Tool Cleaning."
 - 2. Interior Stairs(SSPC Zone 1A): SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
- D. Apply shop primer to uncoated surfaces of metal stair components, 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.
 - 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 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 of 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.

- G. Place and finish concrete fill for treads and platforms to comply with Division 3 Section "Cast-in-Place Concrete."

3.2 INSTALLING RAILINGS AND GUARDS

- A. Adjust railing systems and guards 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 rail ends to building construction as follows:
 - 1. Anchor posts to steel by welding directly to steel supporting members.
- B. Attach handrails to wall with wall brackets. Provide bracket with 1-1/2-inch 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 flange tapped for concealed anchorage to threaded hanger bolt.
 - 2. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger bolts.
 - 3. For steel-framed gypsum board assemblies, use hanger bolts set into wood backing between studs. Coordinate with stud installation to locate backing members.
- C. Welded Connections: Use fully welded joints for permanently connecting railing components by welding. Cope or butt components to provide 100 percent contact or use fittings designed for this purpose.
- D. Anchor railing ends into concrete or masonry with fittings designed for this purpose.
- E. Anchor railing ends to metal surfaces by welding.
- F. Expansion Joints: Provide expansion joints at locations indicated or, if not indicated, at intervals not to exceed 40 feet. Provide slip-joint internal sleeve extending 2 inches beyond joint on either side, fasten internal sleeve securely to one side, and locate joint within 6 inches of post.

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 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. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in Division 9 painting Sections.

END OF SECTION

SECTION 05580 - FORMED-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. Aluminum panels at south side of library curtainwall.
 - 2. Aluminum panels at mechanical penthouse north and west wall.
 - 3. Custom-formed aluminum cornice and soffits at curtainwall.
 - 4. Other aluminum panels or formed metal fabrications indicated on the drawings and not specified elsewhere.
 - 5. Metal framing, extrusions, clips, channels and other support members for aluminum formed-metal fabrications outboard of building sheathing.
- B. Related Sections include the following:
 - 1. Division 7 Section "Exposed Fastener Metal Wall Panels" for factory-formed and field-assembled lap-seam metal wall panels.
 - 2. Division 7 Section "Sheet Metal Flashing and Trim" for items made of formed metal for flashing purposes.
 - 3. Division 7 Section "Self-Adhering Waterproofing" for rubberized asphalt flashing.
 - 4. Division 7 Section "Building Insulation" for rigid insulation installed behind aluminum panels.
 - 5. Division 7 Section "Joint Sealants," for sealants at joints between fabrications.
 - 6. Division 8 Section "Structural-Sealant-Glazed Curtainwalls" and "Aluminum Windows" for window systems adjoining fabrications.

1.3 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide formed-metal fabrications capable of withstanding the following structural loads without exceeding the allowable design working stress of materials involved, including anchors and connections, and without exhibiting permanent deformation in any components making up enclosures:
 - 1. 100 lbf/sq. ft. or a concentrated load of 300 lbf on an area of 4 sq. in., whichever produces the greater stress.
- B. Corrosion Control: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.

1.4 SUBMITTALS

- A. Product Data: For the following:
 - 1. Structural anchors.
 - 2. Nonstructural anchors.
- B. Shop Drawings: Detail fabrication and installation of the following formed-metal fabrications. Include plans, elevations, sections, and details of components and their connections. Show anchorage and accessory items.
- C. Coordination Drawings: For formed-metal fabrications housing items specified in other Sections. Show dimensions of housed items, including locations of housing penetrations and attachments, and necessary clearances.
- D. Samples for Verification: For each type of exposed finish required, prepared on 6-inch- square samples of metal of same thickness, finish and material indicated for the Work. If finishes involve normal color and texture variations, include sample sets showing the full range of variations expected.

1.5 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 that are similar to those indicated for this Project in material, design, and extent.
- B. Fabricator Qualifications: A firm experienced in producing formed-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.
- C. Source Limitations: Obtain formed-metal fabrications through one source from a single manufacturer.

1.6 DELIVERY, STORAGE, AND HANDLING

- A. Deliver formed-metal fabrications wrapped in protective coverings and strapped together in suitable packs or in heavy-duty cartons. Remove protective coverings before they stain or bond to finished surfaces.
- B. Store products on elevated platforms in a dry location.

1.7 PROJECT CONDITIONS

- A. Field Measurements: Where formed-metal fabrications are indicated to fit to other construction, verify dimensions of other construction 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 formed-metal fabrications without field measurements. Coordinate construction to ensure that actual dimensions correspond to established dimensions.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Available Manufacturers: Provide products of one of the following or approved equal:
 1. Embury Company
169 Oakdale Road Toronto
Ontario M3N 1W4
416-742-1212
 2. Kanalco Ltd.
345 Lake Road, Bowmanville,
Ontario, Canada, L1C 4P8
800-268-8139
 3. Pittcon Industries
6409 Rhode Island Ave.
Riverdale, MD 20737
301-927-1000
 4. SAF Metal Fabrication
8370 Highway 78
Villa Rica, GA 30180
770-942-1207SHEET METAL
- B. General: Provide sheet metal without pitting, seam marks, roller marks, stains, discolorations, or other imperfections where exposed to view on finished units.
- C. Aluminum Sheet: Flat sheet complying with ASTM B 209, alloy and temper recommended by aluminum producer and finisher for type of use and finish indicated, and with not less than strength and durability properties of alloy 5005-H15.

2.3 MISCELLANEOUS MATERIALS

- A. Filler Metal and Electrodes: Provide type and alloy of filler metal and electrodes as recommended by producer of metal to be welded and as necessary for strength, corrosion resistance, and compatibility in fabricated items.
- B. Fasteners: Use fasteners fabricated from same basic metal and alloy as fastened metal, unless otherwise indicated. Do not use metals that are corrosive or incompatible with materials joined.
 1. Provide concealed fasteners for interconnecting formed-metal fabrications and for attaching them to other work, unless exposed fasteners are unavoidable and have been indicated and approved in the shop drawings..
 2. Provide Phillips flat-head machine screws for exposed fasteners, unless otherwise indicated.

- C. Structural Anchors: For applications indicated to comply with certain design loads, provide anchors with capability to sustain, without failure, a load equal to six times the required design load.
- D. Nonstructural Anchors: For applications not indicated to comply with design loads, provide anchors of type, size, and material necessary for type of load and installation indicated, as recommended by the manufacturer from options listed below, unless otherwise indicated. Use stainless steel anchors for exterior installations and elsewhere as needed for corrosion resistance.
- 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, for use in separating dissimilar metals.

2.4 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble formed-metal fabrications in shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.
- B. Coordinate dimensions and attachment methods of formed-metal fabrications with those of adjoining construction to produce integrated assemblies with closely fitting joints and with edges and surfaces aligned, unless otherwise indicated.
- C. Form metal to profiles indicated, in maximum lengths to minimize joints. Produce flat, flush surfaces without cracking or grain separation at bends. Ease exposed edges of unsupported sheet metal to a radius of approximately 1/32 inch and support with concealed stiffeners.
- D. Increase metal thickness or reinforce with concealed stiffeners, backing materials, or both, as needed to provide surface flatness specified for stretcher-leveled sheet metal and sufficient strength for indicated use.
 - 1. Support joints with concealed stiffeners as needed to hold exposed faces of adjoining sheets in flush alignment.
- E. Build in straps, plates, and brackets as needed to support and anchor fabricated items to adjoining construction. Reinforce formed-metal units as needed to attach and support other construction.
- F. Provide support framing, mounting and attachment clips, splice sleeves, fasteners, and accessories needed to install formed-metal fabrications.
- G. Where welding is indicated, weld joints and seams continuously. Grind, fill, and dress to produce smooth, flush, exposed surfaces in which joints are not visible after finishing is completed.
 - 1. Use welding procedures that will blend with and not cause discoloration of metal being joined.

2.5 FORMED-METAL FABRICATIONS

- A. Form from metal of type and thickness indicated below. Fabricate to fit tightly to adjoining construction.
 - 1. Metal for Exterior Installations: Aluminum sheet, 0.1 inch, with weathertight joints.
- B. Form bends at the tightest possible radius without grain separation or damage. Miter or cope and weld seams and connections, unless otherwise indicated and other methods are necessary for installation and have been approved in the shop drawings. Grind and polish exposed surfaces prior to finishing.
- C. Conceal fasteners where possible; otherwise, locate where they will be as inconspicuous as possible. Size fasteners to support formed metal, with fasteners spaced to prevent buckling or waviness in finished surfaces.
- D. Install sub-framing, zee clips, channels and other necessary framing to structure behind sheathing. At dissimilar materials, coat surfaces with bituminous paint and employ stainless steel fasteners.

2.6 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Complete mechanical finishes of flat sheet metal surfaces before fabrication where possible. After fabrication, finish all joints, bends, abrasions, and other surface blemishes to match sheet finish.
- C. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.
- D. Apply shop finishes to formed metal after fabrication, unless otherwise indicated.

2.7 ALUMINUM FINISHES

- A. High-Performance Organic Finish: Four-coat fluoropolymer finish complying with AAMA 2605 and containing not less than 70 percent PVDF resin by weight in both color coat and clear topcoat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.
 - 1. Color and Gloss: Metallic "Pewter" color matching UC51713 XL "Duranar XL" Coating by PPG. Color of panels are intended to match exterior color of curtainwalls and aluminum windows.

PART 3 - EXECUTION

3.1 PREPARATION

- A. Clean substrates of substances harmful to installation.

- B. Install rubberized-asphalt flashings to comply with requirements specified in Division 7 Section "Self-Adhering Sheet Waterproofing" where such flashings are required to integrate installation with other systems.

3.2 FORMED-ALUMINUM INSTALLATION

- A. General: Install formed-aluminum in orientation, sizes, and locations indicated on Drawings. Anchor metal panels and other components of the Work securely in place, with provisions for thermal and structural movement.
 - 1. Field cutting of formed metal panels is not permitted.
 - 2. Shim or otherwise plumb substructure receiving metal fabrications.
 - 3. Install self-adhering, rubberized-asphalt composite strips necessary in order to integrate metal framing with self-adhering waterproofing installed as part of Division 7 Section "Self-Adhering Waterproofing." Clean, prepare, and treat substrates according to asphalt membrane manufacturer's written instructions. Prime surfaces recommended by the membrane manufacturer for priming. Complete installation in order to integrate framing and metal panel accessories into the building's air and water barrier systems.
 - 4. Allow required free movement to accommodate thermal expansion and contraction. Pre-drill panels.
 - 5. Flash and seal metal fabrications with weather closures at parapets, panel ends or corners, and at perimeter of all openings. Do not begin installation until weather barrier, insulation and flashings that will be concealed by metal wall panels are installed.
 - 6. Install exposed flat-head screw fasteners in countersunk pre-drilled holes.
 - 7. Install flashing and trim as metal wall panel work proceeds.
- B. Fasteners:
 - 1. Aluminum Panels: Use stainless-steel fasteners.
- C. Metal Protection: Where dissimilar metals will contact each other or corrosive substrates, protect against galvanic action by painting contact surfaces with bituminous coating, by applying rubberized-asphalt underlayment to each contact surface, or by other permanent separation as recommended by metal panel manufacturer.
 - 1. Coat back side of aluminum wall panels with bituminous coating where panels will contact wood, ferrous metal, galvanized metal, or cementitious construction.
- D. Joint Sealers: Install gaskets, joint fillers, and sealants where indicated and where required for weatherproof performance of assemblies.

3.3 ADJUSTING

- A. Restore finishes damaged during installation and construction period so no evidence remains of correction work. Return items that cannot be refinished in the field to the shop; make required alterations and refinish entire unit or provide new units.

3.4 PROTECTION

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- A. Protect finishes of formed-metal fabrications from damage during construction period. Remove temporary protective coverings at time of Substantial Completion.

END OF SECTION

SECTION 05811 - ARCHITECTURAL JOINT SYSTEMS

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. Architectural joint systems for building interiors.
 - 2. Architectural joint systems for building exteriors.
- B. Related Sections include the following:
 - 1. Division 3 Section "Cast-in-Place Concrete."
 - 2. Division 4 Section "Unit Masonry Assemblies."
 - 3. Division 7 Section "Sheet Metal Flashing and Trim" for sheet metal wall joint systems.
 - 4. Division 7 Section "Joint Sealants" for liquid-applied joint sealants.

1.3 DEFINITIONS

- A. Maximum Joint Width: Widest linear gap a joint system tolerates and in which it performs its designed function without damaging its functional capabilities.
- B. Minimum Joint Width: Narrowest linear gap a joint system tolerates and in which it performs its designed function without damaging its functional capabilities.
- C. Movement Capability: Value obtained from the difference between widest and narrowest widths of a joint opening typically expressed in numerical values (mm or inches) or a percentage (plus or minus) of nominal value of joint width.
- D. Nominal Joint Width: The width of the linear opening specified in practice and in which the joint system is installed.

1.4 SUBMITTALS

- A. Shop Drawings: Provide the following for each joint system specified:
 - 1. Placement Drawings: Include line diagrams showing plans, elevations, sections, details, splices, blockout or cutout requirement, entire route of each joint system, and attachments to other work. Where joint systems change planes, provide isometric or clearly detailed drawing depicting how components interconnect.

2. Architectural Joint System Schedule: Prepared by or under the supervision of the supplier. Include the following information in tabular form:

- a. Manufacturer and model number for each joint system.
- b. Joint system location cross-referenced to Drawings.
- c. Nominal joint width.
- d. Movement capability.
- e. Classification as thermal or seismic.
- f. Materials, colors, and finishes.
- g. Product options.
- h. Fire-resistance ratings.

B. Samples for Initial Selection: For each type of joint system indicated.

1. Include manufacturer's color charts showing the full range of colors and finishes available for each exposed metal and elastomeric seal material.

C. Samples for Verification: For each type of architectural joint system indicated.

1. Full width by 6 inches long, for each system required.

D. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for current products.

1.5 QUALITY ASSURANCE

A. Installer Qualifications: An employer of workers trained and approved by manufacturer.

B. Source Limitations: Obtain architectural joint systems through one source from a single manufacturer.

C. Product Options: Drawings indicate size, profiles, and dimensional requirements of architectural joint systems and are based on the specific systems indicated. Refer to Division 1 Section "Product Requirements."

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

D. Accessibility Requirements: Comply with applicable provisions in the U.S. Architectural & Transportation Barriers Compliance Board's "Americans with Disabilities Act (ADA), Accessibility Guidelines (ADAAG)" and other regulatory authorities.

E. Fire-Test-Response Characteristics: Where indicated, provide architectural joint system and fire-barrier assemblies identical to those of assemblies tested for fire resistance per UL 2079 or ASTM E 1966 by a testing and inspecting agency acceptable to authorities having jurisdiction.

1.6 COORDINATION

- A. Coordinate installation of exterior wall and soffit joint systems with roof expansion assemblies to ensure that wall transitions are watertight.

PART 2 - PRODUCTS

2.1 MATERIALS

- A. Aluminum: ASTM B 221, Alloy 6063-T5 for extrusions; ASTM B 209, Alloy 6061-T6 for sheet and plate.
 - 1. Apply manufacturer's standard protective coating on aluminum surfaces to be placed in contact with cementitious materials.
 - 2. Class I, Clear Anodic Finish: AA-M12C22A41 (Mechanical Finish: nonspecular as fabricated; Chemical Finish: etched, medium matte; Anodic Coating: Architectural Class I, clear coating 0.018 mm or thicker) complying with AAMA 611.
- B. Stainless Steel: ASTM A 666, Type 304 for plates, sheet, and strips.
 - 1. Remove tool and die marks and stretch lines or blend into finish.
 - 2. Finish: No. 4, directional satin.
 - a. Grind and polish surfaces to produce uniform, directionally textured, polished finish indicated, free of cross scratches. Run grain with long dimension of each piece.
 - b. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.
- C. Elastomeric Seals: Preformed elastomeric membranes or extrusions to be installed in metal frames.
- D. Compression Seals: ASTM E 1612; preformed rectangular elastomeric extrusions having internal baffle system and designed to function under compression.
- E. Strip Seals: ASTM E 1783; preformed elastomeric membrane or tubular extrusions having an internal baffle system and secured in or over a joint by a metal locking rail.
- F. Cellular Foam Seals: Extruded, compressible foam designed to function under compression.
- G. Elastomeric Concrete: Modified epoxy or polyurethane extended into a prepackaged aggregate blend, specifically designed for bonding to concrete substrates.
- H. Fire Barriers: Any material or material combination, when fire tested after cycling, designated to resist the passage of flame and hot gases through a movement joint and to meet performance criteria for required rating period.
- I. Moisture Barrier: Flexible elastomeric material.

- J. Accessories: Manufacturer's standard anchors, clips, fasteners, set screws, spacers, and other accessories compatible with material in contact, as indicated or required for complete installations.

2.2 ARCHITECTURAL JOINT SYSTEMS, GENERAL

- A. General: Provide architectural joint systems of design, basic profile, materials, and operation indicated. Provide units with capability to accommodate variations in adjacent surfaces.
 - 1. Furnish units in longest practicable lengths to minimize field splicing. Install with hairline mitered corners where joint changes direction or abuts other materials.
 - 2. Include factory-fabricated closure materials and transition pieces, tee-joints, corners, curbs, cross-connections, and other accessories as required to provide continuous and aligned joint systems.
- B. Design architectural joint systems for the following size and movement characteristics:
 - 1. Nominal Joint Width: As indicated on Drawings and scheduled.
- C. Complete Systems: The intention of the specification is to require complete architectural joint systems on walls, floors, ceilings and such other surfaces as are required to form a completely integrated joint control system. Provide joint control systems that fully finish and control the indicated architectural joints whether shown in their entirety or not.

2.3 ARCHITECTURAL JOINT SYSTEMS

- A. Basis-of-Design Product: Basis of Design Products are specified for Construction Specialties Company Inc. Subject to compliance with requirements, provide the products specified or a comparable product by one of the following or approved equal:
 - 1. Architectural Art Mfg., Inc.
 - 2. Balco, Inc.
 - 3. Construction Specialties, Inc.
 - 4. JointMaster/InPro Corporation.
 - 5. Nystrom, Inc.
 - 6. Watson Bowman Acme Corp.

2.4 BASIS OF DESIGN PRODUCTS

- A. The following Basis of Design Products are specified for Construction Specialties Company Inc. See drawings for additional information and dimensions.
- B. Exterior Wall Joint:
 - 1. Joint Size: 2".
 - 2. Joint System Model: SF200.
- C. Roof Joint:

1. Joint Size: 2".
2. Joint System Model: RJ-28.

D. Interior Floor Joints:

1. Joint Size: 2".
2. Joint System Models: GFT200 and GFTW200.

E. Interior Wall and Ceiling Joints:

1. Joint Size: 2".
2. Joint System Models: FCF200 and FCFC200.

2.5 FIRE-RESISTANCE RATINGS

- A. The following Basis of Design Products are specified for Construction Specialties Company Inc. and the accompanying UL Ratings. At interior joints provide joint system and fire-barrier assembly with ratings of not less than 2 hours. See drawings for additional information and dimensions.
- B. Floor Systems: C/S Group Ultra Block used in conjunction with GE Silicone Products Div., Pensil 300 or Pensil 300 S/L Sealants. UL SYSTEM NO. FF-S-1009.
- C. Wall Systems: C/S Group GFX 2W. UL SYSTEM NO. FF-D-0051 and UL SYSTEM NO. FF-D-0061.

2.6 FINISHES

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.
- C. Appearance of Finished Work: Noticeable variations in same piece are not acceptable.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine surfaces where architectural joint systems will be installed for installation tolerances and other conditions affecting performance of work.
 1. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Prepare substrates according to architectural joint system manufacturer's written instructions.
- B. Repair concrete slabs using manufacturer's recommended repair grout of compressive strength adequate for anticipated structural loadings.
- C. Coordinate and furnish anchorages, setting drawings, and instructions for installing joint systems. Provide fasteners of metal, type, and size to suit type of construction indicated and to provide for secure attachment of joint systems.

3.3 INSTALLATION

- A. Comply with manufacturer's written instructions for storing, handling, and installing architectural joint assemblies and materials unless more stringent requirements are indicated.
- B. Metal Frames: Perform cutting, drilling, and fitting required to install joint systems.
 - 1. Install in true alignment and proper relationship to joints and adjoining finished surfaces measured from established lines and levels.
 - 2. Adjust for differences between actual structural gap and nominal design gap due to ambient temperature at time of installation. Notify Architect where discrepancies occur that will affect proper joint installation and performance.
 - 3. Cut and fit ends to accommodate thermal expansion and contraction of metal without buckling of frames.
 - 4. Locate in continuous contact with adjacent surfaces.
 - 5. Standard-Duty Systems: Shim to level where required. Support underside of frames continuously to prevent vertical deflection when in service.
 - 6. Heavy-Duty Systems: Repair or grout blockout as required for continuous frame support and to bring frame to proper level. Shimming is not allowed.
 - 7. Locate anchors at interval recommended by manufacturer, but not less than 3 inches from each end and not more than 24 inches o.c.
- C. Seals in Metal Frames: Install elastomeric seals and membranes in frames to comply with manufacturer's written instructions. Install with minimum number of end joints.
 - 1. Provide in continuous lengths for straight sections.
 - 2. Seal transitions according to manufacturer's written instructions. Vulcanize or heat-weld field-spliced joints as recommended by manufacturer.
 - 3. Installation: Mechanically lock seals into frames or adhere to frames with adhesive or pressure-sensitive tape as recommended by manufacturer.
- D. Compression Seals: Apply adhesive or lubricant adhesive as recommended by manufacturer before installing compression seals.
- E. Foam Seals: Install with adhesive recommended by manufacturer.
- F. Epoxy-Bonded Seals: Pressurize seal for time period and to pressure recommended by manufacturer. Do not overpressurize.
- G. Terminate exposed ends of joint assemblies with field- or factory-fabricated termination devices.

H. Fire-Resistance-Rated Assemblies: Coordinate installation of architectural joint assembly materials and associated work so complete assemblies comply with assembly performance requirements.

1. Fire Barriers: Install fire barriers to provide continuous, uninterrupted fire resistance throughout length of joint, including transitions and field splices.

3.4 PROTECTION

A. Do not remove protective covering until finish work in adjacent areas is complete. When protective covering is removed, clean exposed metal surfaces to comply with manufacturer's written instructions.

B. Protect the installation from damage by work of other Sections. Where necessary due to heavy construction traffic, remove and properly store cover plates or seals and install temporary protection over joints. Reinstall cover plates or seals prior to Substantial Completion of the Work.

END OF SECTION