

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. Industrial stairs with steel floor plate treads.
 - 2. Handrails attached to walls adjacent to metal stairs.

1.3 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide metal stairs capable of withstanding the following structural loads without exceeding the allowable design working stress of the materials involved, including anchors and connections. Apply each load to produce the maximum stress in each component of metal stairs.
 - 1. Treads and Platforms of Metal Stairs: Capable of withstanding a uniform load of 100 lbf/sq. ft. or a concentrated load of 300 lbf on an area of 4 sq. in., whichever produces the greater stress.
 - 2. Stair Framing: Capable of withstanding stresses resulting from loads specified above in addition to stresses resulting from railing system loads.
 - 3. Limit deflection of treads, platforms, and framing members to L/360 or 1/4 inch, whichever is less.
- B. Structural Performance of Handrails: Provide handrails complying with requirements in ASTM E 985 for structural performance, based on testing performed according to ASTM E 894 and ASTM E 935.

1.4 SUBMITTALS

- A. Product Data: For metal stairs and the following:
 - 1. Steel floor plate.
 - 2. Paint products.

- B. Shop Drawings: Show fabrication and installation details for metal stairs. Include plans, elevations, sections, and details of metal stairs and their connections. Show anchorage and accessory items. Provide templates for anchors and bolts specified for installation under other Sections.
 - 1. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
- C. Welding Certificates: Copies of certificates for welding procedures and personnel.
- D. 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.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: Arrange for metal stairs specified in this Section to be fabricated and installed by the same firm.
- B. Fabricator Qualifications: A firm experienced in producing metal stairs similar to those indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.
- C. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel," and AWS D1.3, "Structural Welding Code--Sheet Steel."

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.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. Preassembled Stairs:
 - a. Alfab, Inc.
 - b. American Metal Works, Inc.
 - c. American Stair Corp., Inc.
 - d. Florida Stairs & Rails, Inc.

- e. National Stair & Rail, Inc.
- f. Sharon Companies, Ltd. (The).

2.2 FERROUS METALS

- A. Metal Surfaces, General: Provide metal free from pitting, seam marks, roller marks, and other imperfections where exposed to view on finished units. Do not use steel sheet with variations in flatness exceeding those permitted by referenced standards for stretcher-leveled sheet.
- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- 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. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

2.3 FASTENERS

- A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 25 for exterior use, and Class Fe/Zn 5 where built into exterior walls. Select fasteners for type, grade, and class required.
- B. Plain Washers: Round, carbon steel, ASME B18.22.1.
- C. Expansion Anchors: Anchor bolt and sleeve assembly of material indicated below with capability to sustain, without failure, a load equal to six times the load imposed when installed in unit masonry and equal to four times the load imposed when installed in concrete, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.
 - 1. Material: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.

2.4 PAINT

- A. Shop Primers: Provide primers that comply with Division 9 Section "Painting."
- B. Shop Primer for Ferrous Metal: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with performance requirements in FS TT-P-664, selected for good resistance to normal atmospheric corrosion, compatibility with finish paint systems indicated, and capability to provide a sound foundation for field-applied topcoats despite prolonged exposure.

2.5 CAST ABRASIVE NOSINGS

- A. Drill for mechanical anchors and countersink. Locate not more than 4 inches from ends and not more than 12 inches o.c., evenly spaced between ends, unless otherwise indicated. Provide closer spacing if recommended by manufacturer.
- B. Provide a plain surface texture, unless fluted or cross-hatched surfaces are indicated.

2.6 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, struts, handrails, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
 - 1. Join components by welding, unless otherwise indicated.
 - 2. Use connections that maintain structural value of joined pieces.
- 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. Industrial class, where indicated.
- C. Shop Assembly: Preassemble stairs 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.
- D. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges. Shear and punch metals cleanly and accurately. Remove sharp or rough areas on exposed surfaces.
- E. Ease exposed edges to a radius of approximately 1/32 inch, unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- 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. 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-FRAMED STAIRS

- A. Stair Framing: Fabricate stringers of structural-steel channels, plates, or a combination of both, as indicated. Provide closures for exposed ends of stringers. Bolt or weld headers to stringers; bolt or weld framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.
- B. Steel Floor Plate Treads, Risers, and Platforms: Form to configurations shown in contract documents. Floor plate surface as shown on drawings with thickness necessary to support indicated loads, but not less than 1/4 inch.
 - 1. Abrasive-Surface Floor Plate: Fabricate from steel plate, with abrasive granules rolled into surface. Provide material with coefficient of friction of 0.6 or higher when tested according to ASTM C 1028.
 - 2. Form treads with integral nosing and back edge stiffener. Weld steel supporting brackets to stringers and weld treads to brackets.
 - 3. Fabricate platforms with integral nosings matching treads and weld to platform framing.

2.8 STEEL PIPE HANDRAILS AND RAILINGS

- A. General: Fabricate handrails to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness and anchorage, but not less than that needed to withstand indicated loads.
- B. Interconnect members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
 - 1. At tee and cross intersections, cope ends of intersecting members to fit contour of pipe to which end is joined, and weld all around.
- C. Form changes in direction of handrails and rails as follows:
 - 1. As detailed.
- D. Form simple and compound curves by bending members in jigs to produce uniform curvature for each repetitive configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- E. Close exposed ends of handrail and railing members with prefabricated end fittings.
- F. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated. Close ends of returns, unless clearance between end of rail and wall is 1/4 inch or less.
- G. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting railings and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.

- H. Fillers: Provide fillers made from steel plate, or other suitably crush-resistant material, where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses and to produce adequate bearing area to prevent bracket rotation and overstressing of substrate.
- I. For nongalvanized handrails, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free from rack.
- C. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete, unless otherwise indicated.
- D. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- E. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations.
- F. Field Welding: Comply with the following requirements:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.

3.2 INSTALLING STEEL TUBE HANDRAILS

- 1. Adjust handrails systems before anchoring to ensure matching alignment at abutting joints.

- 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 hollow masonry anchorage, use toggle bolts.
 3. For steel-framed gypsum board assemblies, use hanger or lag bolts set into wood backing between studs. Coordinate with stud installation to locate backing members.

3.3 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.

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