

METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

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

1.2 SUMMARY

- A. This section includes the following metal fabrications:

1. Rough hardware.
2. Ladders.
3. Loose bearing and leveling plates.
4. Loose steel lintels.
5. Miscellaneous framing and supports for the following:
 - a. Overhead doors.
 - b. Applications where framing and supports are not specified in other sections.
6. Shelf and relieving angles.
7. Structural steel door frames for overhead doors.
8. Metal bar gratings.
9. Tread plate and supports.
10. Steel pipe railings.
11. Steel gate at tire drop.
12. Pipe bollards.

- B. Related Sections:

1. Section 033000 "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.
2. Section 042000 "Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
3. Section 051200 "Structural Steel Framing."

1.3 DEFINITIONS

- A. Definitions in ASTM E 985 for railing-related terms apply to this section.

1.4 SYSTEM PERFORMANCE REQUIREMENTS

- A. Structural Performance of Handrails and Railing Systems: Design, engineer, fabricate, and install handrails and railing systems to comply with requirements of ASTM E 985 for structural performance based on testing performed in accordance with ASTM E 894 and E 935.

- B. Structural Performance: Design, engineer, fabricate, and install the following metal fabrications to withstand 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 respective component of each metal fabrication.
1. Handrail and Guardrail Assemblies: Capable of withstanding the following loads applied as indicated:
 - a. Concentrated load of 200 lbs. applied at any point nonconcurrently, vertically downward, or horizontally.
 - b. Uniform load of 50 lbs. per linear ft. applied vertically and horizontally.
 - c. Concentrated and uniform loads above need not be assumed to act concurrently.
 2. Components of Handrail and Guardrail Assemblies: Capable of withstanding a horizontal concentrated load of 50 lbf applied to one sq. ft. at any point in the system including panels, intermediate rails balusters, or other elements composing the infill area.
 - a. Above load need not be assumed to act concurrently with uniform horizontal loads on top rails of railing systems in determining stress on guard.
 3. Treads of Steel Stairs: Capable of withstanding a uniform load of 100 lbf per sq. ft. or a concentrated load of 300 lbf on a area of 4 sq. inches located in the center of the tread, whichever produces the greater stress.
 4. Platforms of Steel Stairs: Capable of withstanding a uniform load of 100 lbf per sq. ft.
 5. Heavy Duty Metal Bar Gratings: Capable of withstanding a uniform load of 250 lbf per sq. ft. or a concentrated load of 8000 lbf, whichever produces the greater stress.

1.5 ACTION SUBMITTALS

- A. Product Data: For the following:
1. Paint products.
 2. Grout.
- B. Shop Drawings: Show fabrication and installation details for metal fabrications.
1. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
- C. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.6 QUALITY ASSURANCE

- A. Fabricator Qualifications: Firms experienced in successfully producing metal fabrications similar to that indicated for this Project, with sufficient production capacity to produce required units without causing delay in the Work.
- B. Installer Qualifications: Arrange for installation of metal fabrications specified in this section by same firm that fabricated them.

- C. Qualify welding processes and welding operators in accordance with AWS D1.1 "Structural Welding Code - Steel," D1.3 "Structural Welding Code - Sheet Steel", and D1.2 "Structural Welding Code - Aluminum."
 - 1. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.
- D. Engineer Qualifications: Professional engineer licensed to practice in jurisdiction where project is located and experienced in providing engineering services of the kind indicated that have resulted in the successful installation of metal fabrications similar in material, design, and extent to that indicated for this Project.

1.7 PROJECT CONDITIONS

- A. Field Measurements: Check actual locations of walls and other construction to which metal fabrications must fit, by accurate field measurements before fabrication; show recorded measurements on final shop drawings. Coordinate fabrication schedule with construction progress to avoid delay of Work.
 - 1. Where field measurements cannot be made without delaying the Work, guarantee dimensions and proceed with fabrication of products without field measurements. Coordinate construction to ensure that actual opening dimensions correspond to guaranteed dimensions. Allow for trimming and fitting.

1.8 SEQUENCING AND SCHEDULING

- A. Sequence and coordinate installation of wall handrails as follows:
 - 1. Mount handrails only on completed walls. Do not support handrails temporarily by any means not satisfying structural performance requirements.

PART 2 - PRODUCTS

2.1 FERROUS METALS

- A. Metal Surfaces, General: For metal fabrications exposed to view upon completion of the Work, provide materials selected for their surface flatness, smoothness, and freedom from surface blemishes. Do not use materials whose exposed surfaces exhibit pitting, seam marks, roller marks, rolled trade names, roughness, and, for steel sheet, variations in flatness exceeding those permitted by reference standards for stretcher-leveled sheet.
- B. Steel Plates, Shapes, and Bars: ASTM A 36.
- C. Rolled Steel Floor Plates: ASTM A 786.
- D. Steel Bars for Gratings: ASTM A 569 or ASTM A 36.
- E. Wire Rod for Grating Cross Bars: ASTM A 510.
- F. Steel Tubing: Product type (manufacturing method) and as follows:
 - 1. Cold-Formed Steel Tubing: ASTM A 500, grade as indicated below:
 - a. Grade A, unless otherwise indicated or required for design loading.
 - b. Grade B, unless otherwise indicated or required for design loading.
 - 2. Hot-Formed Steel Tubing: ASTM A 501.
 - a. For exterior installations and where indicated, provide tubing with hot-dip galvanized coating per ASTM A 53.

- G. Uncoated Structural Steel Sheet: Product type (manufacturing method), quality, and grade, as follows:
 - 1. Cold-Rolled Structural Steel Sheet: ASTM A 611, grade as follows:
 - a. Grade A, unless otherwise indicated or required by design loading.
 - 2. Hot-Rolled Structural Steel Sheet: ASTM A 570, grade as follows:
 - a. Grade 30, unless otherwise indicated or required by design loading.
- H. Uncoated Steel Sheet: Commercial quality, product type (method of manufacture) as follows:
 - 1. Cold-Rolled Steel Sheet: ASTM A 366.
 - 2. Hot-Rolled Steel Sheet: ASTM A 569.
- I. Galvanized Steel Sheet: Quality as follows:
 - 1. Structural Quality: ASTM A 446; Grade A, unless another grade required for design loading, and G90 coating designation unless otherwise indicated.
 - 2. Commercial Quality: ASTM A 526, G90 coating designation unless otherwise indicated.
- J. Steel Pipe: ASTM A 53; finish, type, and weight class as follows:
 - 1. Black finish, unless otherwise indicated.
 - 2. Galvanized finish for exterior installations and where indicated.
 - 3. Type S, Grade A, standard weight (schedule 40), unless otherwise indicated, or another grade or weight or both required by structural loads.
 - 4. Schedule 80 Weight for railings and handrails, unless otherwise indicated or another weight is required by structural loads.
- K. Gray Iron Castings: ASTM A 48, Class 30.
- L. Malleable Iron Castings: ASTM A 47, grade 32510.
- M. Brackets, Flanges and Anchors: Cast or formed metal of the same type material and finish as supported rails, unless otherwise indicated.
- N. Concrete Inserts: Threaded or wedge type; galvanized ferrous castings, either malleable iron, ASTM A 47, or cast steel, ASTM A 27. Provide bolts, washers, and shims as required, hot-dip galvanized per ASTM A 153.
- O. Welding Rods and Bare Electrodes: Select in accordance with AWS

2.2 GROUT AND ANCHORING CEMENT

- A. Nonshrink Nonmetallic Grout: Premixed, factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with CE CRD-C 621. Provide grout specifically recommended by manufacturer for interior and exterior applications of type specified in this section.
- B. Products: Subject to compliance with requirements, provide one of the following:
 - 1. Nonshrink Nonmetallic Grouts:
 - a. "Bonsal Construction Grout," W.R. Bonsal Co.
 - b. "Diamond-Crete Grout," Concrete Service Materials Co.
 - c. "Euco N-S Grout," Euclid Chemical Co.
 - d. "Kemset," Chem-Masters Corp.
 - e. "Crystex," L & M Construction Chemicals, Inc.
 - f. "Masterflow 713," Master Builders.
 - g. "Sealtight 588 Grout," W.R. Meadows, Inc.
 - h. "SonogROUT," Sonneborn Building Products Div., Rexnord Chemical Products, Inc.
 - i. "Stoncrete NM1," Stonhard, Inc.
 - j. "Five Star Grout," U.S. Grout Corp.
 - k. "Vibropruf #11," Lambert Corp.

2.3 FASTENERS

- A. General: Provide zinc-coated fasteners for exterior use or where built into exterior walls. Select fasteners for the type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon head type, ASTM A 307, Grade A.
- C. Lag Bolts: Square head type, FS FF-B-561.
- D. Machine Screws: Cadmium plated steel, FS FF-S-92.
- E. Wood Screws: Flat head carbon steel, FS FF-S-111.
- F. Plain Washers: Round, carbon steel, FS FF-W-92.
- G. Drilled-In Expansion Anchors: Expansion anchors complying with FS FF-S-325, Group VIII (anchors, expansion, [nondrilling]), Type I (internally threaded tubular expansion anchor); and machine bolts complying with FS FF-B-575, Grade 5.
- H. Toggle Bolts: Tumble-wing type, FS FF-B-588, type, class, and style as required.
- I. Lock Washers: Helical spring type carbon steel, FS FF-W-84.

2.4 PAINT

- A. Shop Primer for Ferrous Metal: Manufacturer's or fabricator's standard, fast-curing, lead-free, universal modified alkyd primer selected for good resistance to normal atmospheric corrosion, for compatibility with finish paint systems indicated, and for capability to provide a sound foundation for field-applied topcoats despite prolonged exposure complying with performance requirements of FS TT-P-664D.
- B. Galvanizing Repair Paint: High zinc dust content paint for regalvanizing welds in galvanized steel, with dry film containing not less than 94 percent zinc dust by weight, and complying with DOD-P-21035 or SSPC-Paint-20.
- C. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12 except containing no asbestos fibers.

- D. Zinc Chromate Primer: FS TT-P-645.

2.5 CONCRETE FILL AND REINFORCING MATERIALS

- A. Concrete Materials and Properties: Comply with requirements of Division 3 section "Concrete Work" for normal weight, ready-mix concrete with minimum 28-day compressive strength of 2,500 psi, 440 lb. cement per cu. ft. minimum, and W/C ratio of 0.65 maximum, unless higher strengths indicated.
- B. Reinforcing Bars: ASTM A 615, Grade 60, unless otherwise indicated.

2.6 FABRICATION, GENERAL

- A. Form metal fabrications from materials of size, thickness, and shapes indicated but not less than that needed to comply with performance requirements indicated. Work to dimensions indicated or accepted on shop drawings, using proven details of fabrication and support. Use type of materials indicated or specified for various components of each metal fabrication.
- B. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
- C. Allow for thermal movement resulting from the following maximum change (range) in ambient temperature in the design, fabrication, and installation of installed metal assemblies to prevent buckling, opening up of joints, and overstressing of welds and fasteners. Base design calculations on actual surface temperatures of metals due to both solar heat gain and nighttime sky heat loss.
 - 1. Temperature Change (Range): 100 deg F (55.5 deg C).
- D. Shear and punch metals cleanly and accurately. Remove burrs.
- 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. Remove sharp or rough areas on exposed traffic surfaces.
- G. Weld corners and seams continuously to comply with AWS recommendations and the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so that no roughness shows after finishing and contour of welded surface matches those adjacent.
- H. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners wherever possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.
- I. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to provide adequate support for intended use.

- J. 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.
- K. Cut, reinforce, drill and tap miscellaneous metal work as indicated to receive finish hardware, screws, and similar items.
- L. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.

2.7 ROUGH HARDWARE

- A. Furnish bent or otherwise custom fabricated bolts, plates, anchors, hangers, dowels, and other miscellaneous steel and iron shapes as required for framing and supporting woodwork, and for anchoring or securing woodwork to concrete or other structures. Straight bolts and other stock rough hardware items are specified in Division 6 sections.
- B. Fabricate items to sizes, shapes, and dimensions required. Furnish malleable-iron washers for heads and nuts which bear on wood structural connections; elsewhere, furnish steel washers.

2.8 STEEL LADDERS

- A. General: Fabricate ladders for the locations shown, with dimensions, spacings, details and anchorages as indicated. Comply with requirements of ANSI A14.3.
- B. Siderails: Continuous steel flat bars, 1/4 inch x 2 inches, with eased edges, spaced 18 inches apart.
- C. Bar Rungs: Round steel bars, 3/4-inch diameter, spaced 12 inches o.c.
- D. Fit rungs in centerline of side rails, plug weld and grind smooth on outer rail faces.
- E. Support each ladder at top and bottom and at intermediate points spaced not more than 5'-0" o.c. by means of welded or bolted steel brackets.
 - 1. Size brackets to support design dead and live loads indicated and to hold centerline of ladder rungs clear of the wall surface by not less than 7 inches.
- F. Provide non-slip surface on top of each rung, either by coating the rung with aluminum oxide granules set in epoxy resin adhesive, or by using a type of manufactured rung which is filled with aluminum oxide grout.
- G. Galvanize ladders, including brackets and fasteners, in the following locations:
 - 1. Exterior locations.

2.9 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction, made flat, free from warps or twists, and of required thickness and bearing area. Drill plates to receive anchor bolts and for grouting as required.

2.10 LOOSE STEEL LINTELS

- A. Fabricate loose structural steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.

- B. Weld adjoining members together to form a single unit where indicated.
- C. Size loose lintels for equal bearing of one inch per foot of clear span but not less than 8 inches bearing at each side of openings, unless otherwise indicated.
 - 1. Loose lintels where indicated or required, and not included with structural steel, shall be as follows: (Galvanize loose steel lintels located in exterior walls.)
 - a. Openings up to 4'-0": One angle 3-1/2" x 3-1/2" x 5/16" for each 4" width of masonry.
 - b. Openings 4'-1" to 7'-0": One angle 5" x 3-1/2" x 5/16" for each 4" width of masonry.
 - c. Openings 7'-1" to 10'-0": One beam W8x10 plus 5/16" thick plate; 1/2" narrower than up to 12" thick wall.
 - d. Openings 10'-1" to 12'-0": One beam W8x18 plus 5/16" thick plate; 1/2" narrower than up to 12" thick wall.

2.11 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports for applications indicated or which are not a part of structural steel framework, as required to complete work.
 - 1. Metal shapes, and assemblies indicated on the Architectural Drawings and not specified in other sections of the specifications or not indicated on the Structural Drawings, and framing supporting other components of the construction shall be provided in accordance with the provisions of this section and STRUCTURAL STEEL Section.
- B. Fabricate units to sizes, shapes, and profiles indicated and required to receive adjacent other construction retained by framing and supports. Fabricate from structural steel shapes, plates, and steel bars of welded construction using mitered joints for field connection. Cut, drill, and tap units to receive hardware, hangers, and similar items.
 - 1. Equip units with integrally welded anchors for casting into concrete or building into masonry. Furnish inserts if units must be installed after concrete is placed.
 - 2. Except as otherwise indicated, space anchors 24 inches o.c. and provide minimum anchor units in the form of steel straps 1-1/4 inches wide x 1/4 inch x 8 inches long.
- C. Frames fabricated from structural steel shapes
 - 1. Provide structural steel frames for door openings, exterior wall supports, ceiling hung toilet partition supports, frames around curbs, pits and other openings in floors and walls and at slab edges as indicated.
 - 2. Construction frames to sizes indicated, of steel channels, bent plates, steel angles, steel plate or combinations of shapes as detailed. Frames shall be accurately squared, mitered, butted or coped as necessary and shall be full welded with all welds on exposed surfaces ground smooth. Concealed clip angles shall be welded or flush-riveted to the bottom of steel jamb members and provided with two (2) 1/2" diameter floor bolts for each clip angle. Provide sill members and slab edge angles where indicated.
 - 3. Provide steel strap anchors of sizes and spacing indicated, welded to back of frames for anchoring into masonry, concrete or to steel as necessary. Where size and spacing of anchors are not shown, use 1/4" x 2" x 8" straps turned 2". Space anchors not more than 16" apart.

4. Provide spreaders between the bottom of steel jamb members and elsewhere as necessary. Remove spreaders after frames are properly set and securely anchored.
- D. Roof Openings:
1. Where not otherwise shown, provide steel framing for roof openings.
 2. Support steel framing by extending to primary framing or purlins as required for support at both ends as acceptable to Architect.
 3. Size steel framing not less than the following for spans indicated:
 - a. Up to 5'-0", Channel C3 x 4.1.
 - b. Up to 7'-0", Channel C5 x 6.8.
 - c. Up to 10'-0", Channel C6 x 8.2.
- E. Fabricate support for suspended toilet partitions as follows:
1. Beams: Continuous steel shapes of size required to limit deflection to L/360 between hangers, but use not less than C 8 x 11.5 channels or another shape with equivalent structural properties.
 2. Hangers: Steel rods, 1/2 inch in diameter, spaced not more than 36 inches o.c. Thread rods to receive anchor and stop nuts. Fit hangers with wedge shape washers for full bearing on sloping flanges of support beam.
 3. Braces and Angles: Steel angles of size required for rigid support of beam and for secure anchorage.
- F. Galvanize miscellaneous framing and supports in the following locations:
1. Exterior locations.
 2. Interior locations where indicated.

2.12 MISCELLANEOUS STEEL TRIM

- A. Provide shapes and sizes indicated for profiles shown. Unless otherwise indicated, fabricate units from structural steel shapes, plates, and steel bars, with continuously welded joints and smooth exposed edges. Use concealed field splices wherever possible. Provide cutouts, fittings, and anchorages as required for coordination of assembly and installation with other work.
- B. Galvanize miscellaneous framing and supports in the following locations:
1. Exterior locations.
 2. Interior locations where indicated.

2.13 SHELF AND RELIEVING ANGLES

- A. Fabricate shelf and relieving angles from steel angles of sizes indicated and for attachment to concrete framing. Provide slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and not more than 24 inches o.c., unless otherwise indicated.
- B. For cavity walls, provide vertical channel brackets to support shelf/relieving angles from back-up masonry and concrete. Align expansion joints in angles with indicated expansion joints in cavity wall exterior wythe.

- C. Galvanize shelf angles to be installed on exterior concrete framing.
- D. Furnish wedge-type concrete inserts, complete with fasteners, for attachment of shelf angles to cast-in-place concrete.

2.14 STRUCTURAL STEEL DOOR FRAMES FOR OVERHEAD DOORS

- A. Fabricate steel door frames from structural shapes and bars of size and to dimensions indicated, fully welded together, with 5/8 inch x 1-1/2 inch steel bar stops, unless otherwise indicated. Plug weld built-up members and continuously weld exposed joints. Secure removable stops to frame with countersunk machine screws, uniformly spaced at not more than 10 inches o.c. Reinforce frames and drill and tap as required to accept finish hardware.
- B. Provide steel strap anchors for securing door frames into adjoining concrete or masonry, using 1/8 inch x 2 inch straps of the length required for a minimum 8 inch embedment, unless otherwise indicated. Weld anchors to frame jambs no more than 12 inches from both bottom and head of frame and space anchors not more than 30 inches apart.
- C. Extend bottom of frames to floor elevation indicated with steel angle clips welded to frames for anchoring frame to floor with expansion shields and bolts.
- D. Galvanize frames and anchors in the following locations:

- 1. Exterior locations.

2.15 STRUCTURAL-STEEL DOOR FRAMES FOR TIRE DROPE GATE

- 1. Fabricate structural-steel door frames from steel shapes, plates, and bars of size and to dimensions indicated, fully welded together, with steel angles and channels as indicated on drawings.. Plug-weld built-up members and continuously weld exposed joints. Secure removable stops to frame with countersunk machine screws, uniformly spaced at not more than 10 inches (250 mm) o.c. Reinforce frames and drill and tap as necessary to accept finish hardware.
 - a. Provide with integrally welded steel strap anchors for securing door frames into adjoining concrete or masonry.
- 2. Steel gate to be provided by owner.

2.16 METAL BAR GRATINGS

- A. General: Produce metal bar gratings of description indicated per NAAMM marking system that comply with the following:
 - 1. Metal Bar Grating Standard "Standard Specifications for Metal Bar Grating and Metal Bar Grating Treads" published in ANSI/NAAMM A201 "Metal Bar Grating Manual."
 - 2. Heavy Duty Metal Bar Grating Standard: "Guide Specifications for Heavy Duty Metal Bar Grating" published in NAAMM "Heavy Duty Metal Bar Grating Manual."
- B. Fabricate welded steel gratings to comply with requirements indicated below:
 - 1. Mark/Size: W-15-4 (welded with bearing bars 15/16 inch o.c. and cross bars 4 inches o.c.)/bearing bar sizes as indicated.
 - 2. Dust shield: Provide and install 26 gauge sheet metal dust shield under steel grating where indicated on drawings

3. Mark/Size: As indicated.
- C. Traffic Surface for Steel Bar Gratings: As follows:
1. Plain.
- D. Steel Finish: As follows:
1. Shop prime paint applied in accordance with manufacturer's standard practice.
 2. Hot-dip galvanized with a coating weight of not less than 1.8 oz. per sq. ft. of coated surface.
- E. Attach toe plates to grating by welding, unless otherwise indicated.
- F. Furnish toe plates for attachment in field.
1. Toe plate height: 4 inches, unless a greater height indicated.
- G. Fabricate cutouts in grating sections for penetrations indicated. Arrange layout of cutouts to permit grating removal without disturbing items penetrating gratings.
1. Edge band openings in grating that interrupt 4 or more bearing bars with bars of same size and material as bearing bars.
 2. Do not notch bearing bars at supports to maintain elevation.
- H. Manufacturers: Subject to compliance with requirements, provide metal bar gratings by one of the following:
1. Alabama Metal Industries Corp.
 2. Barnett/Bates Corp.
 3. Blaw-Knox Grating Div., Blaw-Knox Corp.
 4. IKG Industries
 5. Klemp Corp.
 6. Ohio Gratings, Inc.
 7. Reliance Steel Products, Inc.
 8. Seidelhuber Metal Products, Inc.
 9. Truweld, Inc.

2.17 FLOOR PLATE

- A. Fabricate raised pattern floor plates from rolled steel floor plate of thickness and in pattern indicated below:
1. Thickness: As indicated.
 2. Pattern: As indicated; if not indicated, as selected from manufacturers standard patterns.

- B. Abrasive Surface Floor Plate: Manufacturer's standard abrasive granules, rolled into surface of steel plate.
- C. Include steel angle stiffeners and fixed sections as indicated.

2.18 TREAD PLATE

- A. Metal Floor Plate Stairs: Form treads and platforms to configurations shown from [rolled-steel] [abrasive-surface] floor plate of thickness [needed to comply with performance requirements, but not less than **1/4 inch (6.4 mm)**] [needed to comply with performance requirements, Retain one of first three subparagraphs below.
 - 1. Form treads with integral nosing and back edge stiffener. Form risers of same material as treads
 - 2. Form treads with integral nosing and back edge stiffener. Form risers from steel sheet not less than 0.097 inch (2.5 mm) thick, welded to tread nosings and stiffeners and to platforms.
 - 3. Form treads with integral nosing and back edge stiffener, and with open risers.
 - 4. Weld steel supporting brackets to stringers and weld treads to brackets
 - 5. Fabricate platforms with integral nosings matching treads and weld to platform framing

2.19 STEEL PIPE RAILINGS AND HANDRAILS

- A. General: Fabricate pipe railings and handrails to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of pipe, post spacings, and anchorage, but not less than that required to support structural loads.
- B. Interconnect railing and handrail members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
 - 1. At tee and cross intersections, notch ends of intersecting members to fit contour of pipe to which end is joined and weld all around.
- C. Form changes in direction of railing members as follows:
 - 1. By bending.
- D. Form simple and compound curves by bending pipe in jigs to produce uniform curvature for each repetitive configuration required; maintain cylindrical cross-section of pipe throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of pipe.
- E. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated.
- F. Close exposed ends of pipe by welding 3/16-inch thick steel plate in place or by use of prefabricated fittings, except where clearance of end of pipe and adjoining wall surface is 1/4 inch or less.
- G. Woven-Wire Mesh Infill Panels: Fabricate infill panels from woven-wire mesh crimped into 1-by-1/2-by-1/8-inch (25-by-13-by-3-mm) metal channel frames. Make wire mesh and frames from same metal as railings in which they are installed.
 - 1. Orient wire mesh with wires perpendicular and parallel to treads.

- H. Toe Boards: Where indicated, provide toe boards at railings around openings and at the edge of open-sided floors and platforms. Fabricate to dimensions and details indicated, or if not indicated, use 4 inches high x 1/8 inch steel plate welded to, and centered between, each railing post.
- I. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnections of pipe and attachment of railings and handrails to other work. Furnish inserts and other anchorage devices for connecting railings and handrails to concrete or masonry work.
 - 1. For railing posts set in concrete fabricate sleeves from steel pipe not less than 6 inches long and with an inside diameter not less than 1/2 inch greater than the outside diameter of post, with steel plate closure welded to bottom of sleeve.
 - a. Provide friction fit, removable covers designed to keep sleeves clean and hold top edge of sleeve 1/2 inch below finished surface of concrete.
 - 2. For removable railing posts, fabricate slip-fit sockets from steel pipe whose inside diameter is sized for a close fit with posts and to limit deflection of post without lateral load, measured at top, to not more than 1/12 of post height. Provide socket covers designed and fabricated to resist accidental dislodgement.
- J. Fillers: Provide steel sheet or plate fillers of thickness and size indicated or required to support structural loads of handrails where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses. Size fillers to produce adequate bearing to prevent bracket rotation and overstressing of substrate.
- K. For interior steel railings and handrails formed from steel pipe with galvanized finish, galvanize fittings, brackets, fasteners, sleeves, and other ferrous components.
- L. For interior steel railings formed from steel pipe with black finish, provide nongalvanized ferrous metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.

2.20 STEEL FRAMED STAIRS

- A. General: Construct stairs to conform to sizes and arrangements indicated. Join pieces together by welding, unless otherwise indicated. Provide complete stair assemblies, including metal framing, hangers, columns, railings, newels, balusters, struts, clips, brackets, bearing plates, and other components necessary for the support of stairs and platforms, and as required to anchor and contain the stairs on the supporting structure.
 - 1. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM "Metal Stair Manual" for class of stair designated, except where more stringent requirements are indicated:
 - a. Commercial class, unless otherwise indicated.
- B. Stair Framing: Fabricate stringers of structural steel channels, or plates, or a combination thereof, as indicated. Provide closures for exposed ends of stringers. Construct platforms of structural steel channel headers and miscellaneous framing members as indicated. Bolt or weld headers to strings, newels, and framing members to strings and headers; fabricate and join so that bolts, if used, do not appear on finish surfaces.
 - 1. Where masonry walls support steel stairs, provide temporary supporting struts designed for erection of steel stair components before installation of masonry.

- C. Steel Floor Plate Treads and Platforms: Provide raised pattern steel floor plate in pattern indicated or, if not indicated, as selected from manufacturer's standard patterns.
 - 1. Form treads of 1/4-inch thick raised pattern steel floor plate with integral nosing and back edge stiffener. Weld steel supporting brackets to stringers and treads to brackets.
 - 2. Fabricate platforms of raised pattern steel floor plate of thickness indicated. Provide nosing matching that on treads at all landings. Secure to platform framing members with welds.
- D. Stair Railings and Handrails: Comply with applicable requirements specified elsewhere in this section for steel pipe railings and handrails, and as follows:
 - 1. Fabricate newels of steel tubing and provide newel caps of gray-iron castings, as shown.
 - 2. Railings may be bent at corners, rail returns, and wall returns, instead of using prefabricated fittings.
 - 3. Connect railing posts to stair framing by direct welding, unless otherwise indicated.

2.21 PIPE BOLLARDS

- A. Fabricate pipe bollards from Schedule 80 steel pipe. Cap bollards with 1/4-inch minimum thickness steel base plate.
- B. Fabricate sleeves for bollard anchorage from steel pipe with 1/4-inch thick steel plate welded to bottom of sleeve.

2.22 STEEL AND IRON FINISHES

- A. Galvanizing: For those items indicated for galvanizing, apply zinc-coating by the hot-dip process compliance with the following requirements:
 - 1. ASTM A 153 for galvanizing iron and steel hardware.
 - 2. ASTM A 123 for galvanizing both fabricated and unfabricated iron and steel products made of uncoated rolled, pressed, and forged shapes, plates, bars, and strip 0.0299 inch thick and heavier.
- 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-SP6 "Commercial Blast Cleaning."
 - 2. Interiors (SSPC Zone 1A): SSPC-SP3 "Power Tool Cleaning."
- C. Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finish or to be embedded in concrete, sprayed-on fireproofing, or masonry, unless otherwise indicated. Comply with requirements of SSPC-PA1 "Paint Application Specification No. 1" for shop painting.
 - 1. Stripe paint all edges, corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 PREPARATION

- A. Coordinate and furnish anchorages, setting drawings, diagrams, templates, instructions, and directions for installation of anchorages, including concrete inserts, sleeves, anchor bolts, and miscellaneous items having integral anchors that are to be embedded in concrete or masonry construction. Coordinate delivery of such items to project site.
- B. Set sleeves in concrete with tops flush with finish surface elevations; protect sleeves from water and concrete entry.

3.2 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing miscellaneous 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 as required.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installation of miscellaneous metal fabrications. Set metal fabrication 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 the surfaces of exterior units which have been hot-dip galvanized after fabrication, and are intended for bolted or screwed field connections.
- E. Field Welding: Comply with AWS Code for procedures of manual shielded metal-arc welding, appearance and quality of welds made, methods used in correcting welding work, and the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so that no roughness shows after finishing and contour of welded surface matches those adjacent.
- F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with a heavy coat of bituminous paint or zinc chromate primer.

3.3 SETTING LOOSE PLATES

- A. Clean concrete and masonry bearing surfaces of any bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of bearing plates.
- B. Set loose leveling and bearing plates on wedges, or other adjustable devices. After the bearing members have been positioned and plumbed, tighten the anchor bolts. Do not

remove wedges or shims, but if protruding, cut off flush with the edge of the bearing plate before packing with grout.

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

3.4 INSTALLATION OF METAL BAR GRATINGS

- A. General: Install gratings to comply with recommendations of NAAMM grating standard referenced under Part 2 that apply to grating types and bar sizes indicated, including installation clearances and standard anchoring details.
- B. Secure removable units to supporting members with type and size of clips and fasteners indicated, or if not indicated as recommended by grating manufacturer for type of installation conditions shown.
- C. Secure nonremovable units to supporting members by welding where both materials are the same; otherwise, fasten by bolting as indicated above.
- D. Attach toe plates to gratings by welding, at locations indicated.

3.5 INSTALLATION OF STEEL PIPE RAILINGS AND HANDRAILS

- A. Adjust railings prior to anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated, or if not indicated, as required by design loadings. Plumb posts in each direction. Secure posts and railing ends to building construction as follows:
 1. Anchor posts in concrete by means of pipe sleeves preset and anchored into concrete. After posts have been inserted into sleeves, fill annular space between post and sleeve solid with the following anchoring material, mixed and placed to comply with anchoring material manufacturer's directions.
 2. Anchor posts to steel with steel oval flanges, angle type or floor type as required by conditions, welded to posts and bolted to steel supporting members.
 3. Anchor rail ends into concrete and masonry with steel round flanges welded to rail ends and anchored into wall construction with lead expansion shields and bolts.
 4. Anchor rail ends to steel with steel oval or round flanges welded to rail ends and bolted to structural steel members, unless otherwise indicated.
 5. Install removable railing sections where indicated in slip-fit metal sockets cast into concrete. Accurately locate sockets to match post spacing.
- B. Secure handrails to wall with wall brackets and end fittings. Provide bracket with not less than 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 and wall return fittings to building construction as follows:
 1. Use type of bracket with pre-drilled hole for exposed bolt anchorage.
 2. For concrete and solid masonry anchorage, use drilled-in expansion shield and either concealed hanger bolt or exposed lag bolt, as applicable.
 3. For hollow masonry anchorage, use toggle bolts having square heads.

4. For steel framed gypsum board assemblies, fasten brackets directly to steel framing or concealed anchors using self-tapping screws of size and type required to support structural loads.

3.6 INSTALLATION OF BOLLARDS

- A. Anchor bollards in concrete by means of pipe sleeves preset and anchored into concrete. After bollards have been inserted into sleeves, fill annular space between bollard and sleeve solid with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's directions.

3.7 ADJUSTING AND CLEANING

- A. Touch-Up Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting to comply with SSPC-PA 1 requirements for touch-up of field painted surfaces.
 1. Apply by brush or spray to provide a minimum dry film thickness of 2.0 mils.
- B. Touch-Up Painting: Cleaning and touch-up painting of field welds, bolted connections, and abraded areas of the shop paint on miscellaneous metal is specified in Division 9 Section "Painting" of these specifications.
- C. For galvanized surfaces clean welds, bolted connections and abraded areas and apply galvanizing repair paint to comply with ASTM A 780.

****END OF SECTION****

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