SECTION 05 12 00
STRUCTURAL STEEL FRAMING

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.02 SUMMARY

A. Section Includes:

1. Structural steel.
2. Prefabricated building columns.
3. Field-installed shear connectors.
4. Grout.

B. Related Requirements:

1. Section 05 31 00 "Steel Decking" for field installation of shear connectors through deck.
2. Section 05 50 00 "Metal Fabrications" for steel lintels and shelf angles not attached to structural-steel frame miscellaneous steel fabrications and other steel items not defined as structural steel.
3. Section 09 90 00 "Painting and Coating".

1.03 DEFINITIONS

A. Structural Steel: Elements of the structural frame indicated on Drawings and as described in AISC 303, "Code of Standard Practice for Steel Buildings and Bridges."

B. Seismic-Load-Resisting System: Elements of structural-steel frame designated as "SLRS" or along grid lines designated as "SLRS" on Drawings, including columns, beams, and braces and their connections.

C. Heavy Sections: Rolled and built-up sections as follows:

1. Shapes included in ASTM A 6/A 6M with flanges thicker than 1-1/2 inches (38 mm).
2. Welded built-up members with plates thicker than 2 inches (50 mm).
3. Column base plates thicker than 2 inches (50 mm).

D. Protected Zone: Structural members or portions of structural members indicated as "Protected Zone" on Drawings. Connections of structural and nonstructural elements to protected zones are limited.

E. Demand Critical Welds: Those welds, the failure of which would result in significant degradation of the strength and stiffness of the Seismic-Load-Resisting System and which are indicated as "Demand Critical" or "Seismic Critical" on Drawings.

1.04 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.

B. Coordinate installation of anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, sheet metal templates, instructions, and directions for installation.

1.05 PREINSTALLATION MEETINGS

A. Preinstallation Conference: Conduct conference at Project site.

1.06 ACTION SUBMITTALS

A. Product Data: For each type of product.

B. Shop Drawings: Show fabrication of structural-steel components.

1. Include details of cuts, connections, splices, camber, holes, and other pertinent data.
2. Include embedment Drawings.
3. Indicate welds by standard AWS symbols, distinguishing between shop and field welds, and show size, length, and type of each weld. Show backing bars that are to be removed and supplemental fillet welds where backing bars are to remain.
4. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical, high-strength bolted connections.
5. Identify members and connections of the Seismic-Load-Resisting System.
6. Indicate locations and dimensions of protected zones.
7. Identify demand critical welds.

C. Welding Procedure Specifications (WPSs) and Procedure Qualification Records (PQRs): Provide according to AWS D1.1/D1.1M, "Structural Welding Code - Steel," for each welded joint whether prequalified or qualified by testing , including the following:

1. Power source (constant current or constant voltage).
2. Electrode manufacturer and trade name, for demand critical welds.

D. Delegated-Design Submittal: For structural-steel connections indicated to comply with design loads, include analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.07 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.

C. Mill test reports for structural steel, including chemical and physical properties.

D. Product Test Reports: For the following:

1. Bolts, nuts, and washers including mechanical properties and chemical analysis.
2. Direct-tension indicators.
3. Tension-control, high-strength, bolt-nut-washer assemblies.
4. Shear stud connectors.
5. Shop primers.
6. Nonshrink grout.

E. Survey of existing conditions.

F. Source quality-control reports.

G. Field quality-control and special inspection reports.

1.08 QUALITY ASSURANCE

A. Fabricator Qualifications: A qualified fabricator that participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category STD, or is accredited by the IAS Fabricator Inspection Program for Structural Steel (AC 172).

B. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1. Welders and welding operators performing work on bottom-flange, demand-critical welds shall pass the supplemental welder qualification testing, as required by AWS D1.8/D1.8M. FCAW-S and FCAW-G shall be considered separate processes for welding personnel qualification.

C. Comply with applicable provisions of the following specifications and documents:

1. AISC 303.
2. AISC 341 and AISC 341s1.
3. AISC 360.
4. RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."

1.09 DELIVERY, STORAGE, AND HANDLING

A. Store materials to permit easy access for inspection and identification. Keep steel members off ground and spaced by using pallets, dunnage, or other supports and spacers. Protect steel members and packaged materials from corrosion and deterioration.

1. Do not store materials on structure in a manner that might cause distortion, damage, or overload to members or supporting structures. Repair or replace damaged materials or structures as directed.

B. Store fasteners in a protected place in sealed containers with manufacturer's labels intact.

1. Fasteners may be repackaged provided Owner's testing and inspecting agency observes repackaging and seals containers.
2. Clean and relubricate bolts and nuts that become dry or rusty before use.
3. Comply with manufacturers' written recommendations for cleaning and lubricating ASTM F 1852 fasteners and for retesting fasteners after lubrication.

PART 2 - PRODUCTS

2.01 PERFORMANCE REQUIREMENTS

A. Connections: Provide details of simple shear connections required by the Contract Documents to be selected or completed by structural-steel fabricator, including comprehensive engineering analysis by a qualified professional engineer, to withstand loads indicated and comply with other information and restrictions indicated.

1. Select and complete connections using schematic details indicated and AISC 360.
2. Use Load and Resistance Factor Design; data are given at factored-load level.

B. Moment Connections: Type FR, fully restrained, where shown.

2.02 STRUCTURAL-STEEL MATERIALS

A. W-Shapes: ASTM A 992/A 992M.

B. Channels, Angles, S-Shapes: ASTM A 36/A 36M.

C. Plate and Bar: ASTM A 36/A 36M.

D. Cold-Formed Hollow Structural Sections: ASTM A 500/A 500M, Grade B, structural tubing.

E. Steel Pipe: ASTM A 53/A 53M, Type E or Type S, Grade B.

1. Weight Class: as indicated.
2. Finish: Black except where indicated to be galvanized.

F. Welding Electrodes: Comply with AWS requirements.

G. Guard Posts: Fabricate guard posts from Schedule 80 steel pipe. Cap posts with 1/4-inch minimum thickness steel base plate. See Standard Detail on Drawings.

2.03 BOLTS, CONNECTORS, AND ANCHORS

A. High-Strength Bolts, Nuts, and Washers: ASTM A 325 (ASTM A 325M), Type 1, heavy-hex steel structural bolts; ASTM A 563, Grade C, (ASTM A 563M, Class 8S) heavy-hex carbon-steel nuts; and ASTM F 436 (ASTM F 436M), Type 1, hardened carbon-steel washers; all with plain finish.

1. Direct-Tension Indicators: ASTM F 959, Type 325 (ASTM F 959M, Type 8.8), compressible-washer type with plain finish.

B. Zinc-Coated High-Strength Bolts, Nuts, and Washers: ASTM A 325 (ASTM A 325M), Type 1, heavy-hex steel structural bolts; ASTM A 563, Grade DH (ASTM A 563M, Class 10S) heavy-hex carbon-steel nuts; and ASTM F 436 (ASTM F 436M), Type 1, hardened carbon-steel washers.

1. Finish: Hot-dip or mechanically deposited zinc coating.
2. Direct-Tension Indicators: ASTM F 959, Type 325 (ASTM F 959M, Type 8.8), compressible-washer type with mechanically deposited zinc coating, baked epoxy-coated finish.
3. Location: exterior applications or where supporting members are galvanized.

C. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F 1852, Type 1, heavy-hex head assemblies consisting of steel structural bolts with splined ends, heavy-hex carbon-steel nuts, and hardened carbon-steel washers.

1. Finish: Plain.

2. Location: Interior applications or where supporting members are painted.

D. Shear Connectors: ASTM A 108, Grades 1015 through 1020, headed-stud type, cold-finished carbon steel; AWS D1.1/D1.1M, Type B.

E. Unheaded Anchor Rods: ASTM F 1554, Grade 55, weldable.

1. Configuration: Straight.
2. Nuts: ASTM A 563 (ASTM A 563M) [heavy-]hex carbon steel.
3. Plate Washers: ASTM A 36/A 36M carbon steel.
4. Washers: ASTM F 436 (ASTM F 436M), Type 1, hardened carbon steel.
5. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C, for exterior applications or where columns are galvanized. Use plain for painted columns.

2.04 PRIMER

A. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Public Health's (formerly, the California Department of Health Services') "Standard Method for the Testing and Evaluation of Volatile Organic Chemical Emissions from Indoor Sources Using Environmental Chambers."

2.05 GROUT

A. Nonmetallic, Shrinkage-Resistant Grout: ASTM C 1107/C 1107M, factory-packaged, nonmetallic aggregate grout, noncorrosive and nonstaining, mixed with water to consistency suitable for application and a 30-minute working time.

2.06 FABRICATION

A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate according to AISC 303, "Code of Standard Practice for Steel Buildings and Bridges," and to AISC 360.

1. Camber structural-steel members where indicated.
2. Fabricate beams with rolling camber up.
3. Identify high-strength structural steel according to ASTM A 6/A 6M and maintain markings until structural steel has been erected.
4. Mark and match-mark materials for field assembly.
5. Complete structural-steel assemblies, including welding of units, before starting shop-priming operations.

B. Thermal Cutting: Perform thermal cutting by machine to greatest extent possible.

1. Plane thermally cut edges to be welded to comply with requirements in AWS D1.1/D1.1M.

C. Bolt Holes: Cut, drill, or punch standard bolt holes perpendicular to metal surfaces.

D. Finishing: Accurately finish ends of columns and other members transmitting bearing loads.

E. Cleaning: Clean and prepare steel surfaces that are to remain unpainted according to SSPC-SP 1, "Solvent Cleaning."

F. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.

G. Steel Wall-Opening Framing: Select true and straight members for fabricating steel wall-opening framing to be attached to structural-steel frame. Straighten as required to provide uniform, square, and true members in completed wall framing. Build up welded framing, weld exposed joints continuously, and grind smooth.

H. Welded Door Frames: Build up welded door frames attached to structural-steel frame. Weld exposed joints continuously and grind smooth. Plug-weld fixed steel bar stops to frames. Secure removable stops to frames with countersunk machine screws, uniformly spaced not more than 10 inches (250 mm) o.c. unless otherwise indicated.

I. Holes: Provide holes required for securing other work to structural steel and for other work to pass through steel members.

1. Cut, drill, or punch holes perpendicular to steel surfaces. Do not thermally cut bolt holes or enlarge holes by burning.
2. Baseplate Holes: Cut, drill, mechanically thermal cut, or punch holes perpendicular to steel surfaces.
3. Weld threaded nuts to framing and other specialty items indicated to receive other work.

2.07 SHOP CONNECTIONS

A. High-Strength Bolts: Shop install high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.

1. Joint Type: Snug tightened.

B. Weld Connections: Comply with AWS D1.1/D1.1M for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.

1. Assemble and weld built-up sections by methods that maintain true alignment of axes without exceeding tolerances in AISC 303 for mill material.

C. Steel Lintels

1. Fabricate structural steel lintels from steel angles and shapes of size indicated or scheduled for all openings and recesses in masonry walls and partitions.

2. Weld adjoining members together to form a single unit where indicated. Horizontal sections of lintels between the edge of the masonry opening and the end of the lintel shall be coped to allow for masonry joint not less than 1-inch deep measured from the interior and exterior faces of the masonry wall.

3. Size lintel lengths for equal bearing of one inch per foot of clear span and not less than 4 inches bearing at each side of openings, unless otherwise indicated.

4. See Steel Lintel Schedule on Drawings for sizes required.

5. Galvanize all lintels after fabrication.

6. Paint all lintels exposed to view.

2.08 SHOP PRIMING

A. Shop prime steel surfaces except the following:

1. Surfaces embedded in concrete or mortar. Extend priming of partially embedded members to a depth of 2 inches (50 mm).
2. Surfaces to be field welded.
3. Surfaces of high-strength bolted, slip-critical connections.
4. Surfaces to receive sprayed fire-resistive materials (applied fireproofing).
5. Galvanized surfaces.
6. Surfaces enclosed in interior construction.

B. Surface Preparation: as indicated by Section 09 90 00 "Painting and Coating"

C. Priming: Immediately after surface preparation, apply primer according to manufacturer's written instructions and at rate recommended by SSPC to provide a minimum dry film thickness of 1.5 mils (0.038 mm). Use priming methods that result in full coverage of joints, corners, edges, and exposed surfaces.

1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

2. Apply two coats of shop paint to surfaces that are inaccessible after assembly or erection. Change color of second coat to distinguish it from first.

2.09 GALVANIZING

A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process to structural steel according to ASTM A 123/A 123M.

1. Fill vent and drain holes that are exposed in the finished Work unless they function as weep holes, by plugging with zinc solder and filing off smooth.
2. Galvanize lintels shelf angles and welded door frames attached to structural-steel frame and located in exterior walls.
3. Galvanize all exterior steel and where indicated on the drawings.

2.10 SOURCE QUALITY CONTROL

A. Testing Agency: Owner will engage a qualified testing agency to perform shop tests and inspections.

1. Provide testing agency with access to places where structural-steel work is being fabricated or produced to perform tests and inspections.

B. Bolted Connections: Inspect and test shop-bolted connections according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."

C. Welded Connections: Visually inspect shop-welded connections according to AWS D1.1/D1.1M and the following inspection procedures, at testing agency's option:

1. Liquid Penetrant Inspection: ASTM E 165.
2. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration are not accepted.
3. Ultrasonic Inspection: ASTM E 164.
4. Radiographic Inspection: ASTM E 94.

D. In addition to visual inspection, test and inspect shop-welded shear connectors according to requirements in AWS D1.1/D1.1M for stud welding and as follows:

1. Perform bend tests if visual inspections reveal either a less-than-continuous 360-degree flash or welding repairs to any shear connector.
2. Conduct tests according to requirements in AWS D1.1/D1.1M on additional shear connectors if weld fracture occurs on shear connectors already tested.

E. Prepare test and inspection reports.

PART 3 - EXECUTION

3.01 EXAMINATION

A. Verify, with certified steel erector present, elevations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments for compliance with requirements.

1. Prepare a certified survey of existing conditions. Include bearing surfaces, anchor rods, bearing plates, and other embedments showing dimensions, locations, angles, and elevations.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.02 PREPARATION

A. Provide temporary shores, guys, braces, and other supports during erection to keep structural steel secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural steel, connections, and bracing are in place unless otherwise indicated.

1. Do not remove temporary shoring supporting composite deck construction until cast-in-place concrete has attained its design compressive strength.

3.03 ERECTION

A. Set structural steel accurately in locations and to elevations indicated and according to AISC 303 and AISC 360.

B. Baseplates Bearing Plates and Leveling Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting plates. Clean bottom surface of plates.

1. Set plates for structural members on wedges, shims, or setting nuts as required.
2. Weld plate washers to top of baseplate.
3. Snug-tighten anchor rods after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of plate before packing with grout.
4. Promptly pack grout solidly between bearing surfaces and plates so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for shrinkage-resistant grouts.

C. Maintain erection tolerances of structural steel within AISC 303, "Code of Standard Practice for Steel Buildings and Bridges."

D. Align and adjust various members that form part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that are in permanent contact with members. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.

1. Level and plumb individual members of structure.
2. Make allowances for difference between temperature at time of erection and mean temperature when structure is completed and in service.

E. Splice members only where indicated.

F. Do not use thermal cutting during erection unless approved by Engineer. Finish thermally cut sections within smoothness limits in AWS D1.1/D1.1M.

G. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.

H. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.

3.04 FIELD CONNECTIONS

A. High-Strength Bolts: Install high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.

1. Joint Type: Snug tightened.

B. Weld Connections: Comply with AWS D1.1/D1.1M for tolerances, appearances, welding procedure specifications, weld quality, and methods used in correcting welding work.

1. Comply with AISC 303 and AISC 360 for bearing, alignment, adequacy of temporary connections, and removal of paint on surfaces adjacent to field welds.

2. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.

3. Assemble and weld built-up sections by methods that maintain true alignment of axes without exceeding tolerances in AISC 303, "Code of Standard Practice for Steel Buildings and Bridges," for mill material.

3.05 FIELD QUALITY CONTROL

A. Special Inspections: Owner will engage a qualified special inspector to perform the following special inspections:

1. Verify structural-steel materials and inspect steel frame joint details.
2. Verify weld materials and inspect welds.
3. Verify connection materials and inspect high-strength bolted connections.

B. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.

C. Bolted Connections: Inspect and test bolted connections according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."

D. Welded Connections: Visually inspect field welds according to AWS D1.1/D1.1M.

1. In addition to visual inspection, test and inspect field welds according to AWS D1.1/D1.1M and the following inspection procedures, at testing agency's option:

a. Liquid Penetrant Inspection: ASTM E 165.

b. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration are not accepted.

c. Ultrasonic Inspection: ASTM E 164.

d. Radiographic Inspection: ASTM E 94.

E. In addition to visual inspection, test and inspect field-welded shear connectors according to requirements in AWS D1.1/D1.1M for stud welding and as follows:

1. Perform bend tests if visual inspections reveal either a less-than-continuous 360-degree flash or welding repairs to any shear connector.

2. Conduct tests according to requirements in AWS D1.1/D1.1M on additional shear connectors if weld fracture occurs on shear connectors already tested.

3.06 REPAIRS AND PROTECTION

A. Galvanized Surfaces: Clean areas where galvanizing is damaged or missing and repair galvanizing to comply with ASTM A 780/A 780M.

B. Touchup Painting: Immediately after erection, clean exposed areas where primer is damaged or missing and paint with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC-SP 3 power-tool cleaning.

C. Touchup Painting: Cleaning and touchup painting are specified in Section 09 90 00 "Painting and Coating".

D. Touchup Priming: Cleaning and touchup priming are specified in 09 90 00 "Painting and Coating".

END OF SECTION

SECTION 05 14 00
STRUCTURAL ALUMINUM

PART 1 - GENERAL

1.01 SUMMARY

A. Section Includes: Extent of structural aluminum work as shown on Drawings, including Schedules, Notes, and Details.

B. Source Quality Control: Materials and fabrication procedures are subject to inspection and tests conducted by a qualified inspection agency in mill shop and field. Such inspections and tests will not relieve CONTRACTOR of responsibility for providing materials and fabrication procedures in compliance with specified requirements.

C. Details shown are typical; similar details apply to similar conditions unless otherwise indicated. Verify dimensions at Site whenever possible without causing delay in Work.

D. Connections which are not designed shall be detailed such that the minimum connection capacity is equal to or greater than 1/2 the member capacity.

1.02 SUBMITTALS

A. Shop Drawings: Submit in accordance with Section 01 33 00, Submittal Procedures covering the items included under this Section. Shop Drawing submittals shall include:

1. Submit manufacturer's specifications and installation instructions.
2. Submit Shop Drawings prepared under supervision of a registered Professional Engineer, including complete details and schedules for fabrication and assembly of structural members, procedures, and diagrams. Include details of cuts, connections, camber, holes, welds, and other pertinent data.
3. Provide setting Drawings, templates, and directions for installation of anchor bolts and other anchorages to be installed as Work of this Section.

1.03 QUALITY ASSURANCE

A. Codes and Specifications:

1. Aluminum Association (AA), "Specifications for Aluminum Structures."
2. AA, "Specifications for Aluminum Bridge and Other Highway Structures."
3. ASTM B 221, Specification for Aluminum-Alloy Extruded Bars, Rods, Wire, Shapes and Tubes.
4. ASTM B 483, Specification for Aluminum and Aluminum-Alloy Drawn Tubes for General Purpose Applications.

5. American Welding Society (AWS) D1.0, "Code for Arc and Gas Welding."

B. Qualify welding processes and welding operators in accordance with AWS "Standard Qualification Procedure."

1. Provide certification that welders to be employed in work have satisfactorily passed AWS qualification tests.
2. If recertification of welders is required, retesting shall be CONTRACTOR's responsibility.
3. Parts shall be welded with an inert gas shielded arc or resistant welding process. No welding process that requires a welding flux shall be used.

1.04 DELIVERY, STORAGE, AND HANDLING:

A. Deliver materials to Site at such intervals to ensure uninterrupted progress of Work.

1. Deliver anchor bolts and anchorage devices, which are embedded in cast-in-place concrete or masonry, in ample time not to delay work.

B. Store materials to permit easy access for inspection and identification. Do not store materials in such a manner that would cause distortion or damage.

PART 2 - MATERIALS

2.01 PRODUCTS

A. Tubes and Shapes: Type 6061-T6.

B. Aluminum Bolts: Type 7075-T73.

C. Aluminum Nuts: Type 6061-T6.

D. Embedded Anchors: ASTM A 307 hot-dip galvanized.

E. Electrodes for Welding comply with AWS Code.

2.02 FABRICATION

A. Fabricate and assemble structural assemblies in shop to greatest extent possible. Mark and match-mark materials for field assembly.

B. Welded Construction: Comply with AWS code for procedures, appearance, and quality. Weld continuously along the entire area of contact except where tack welding is indicated.

PART 3 - ERECTION

3.01 GENERAL

A. Employ a land surveyor for accurate erection of structural members. Check elevations of concrete bearing surfaces, and locations of anchor bolts and similar devices before erection Work proceeds, and report discrepancies to ENGINEER. Do not proceed with erection until corrections have been made.

B. Temporary shoring and bracing shall be provided with sufficient strength to bear imposed loads and ensure stability.

C. Field Assembly: Set structural frames accurately to lines and elevations indicated.

D. Splice members only where indicated and accepted on Shop Drawings.

E. Do not enlarge unfit holes by burning or by use of drift pins except in secondary members. Ream holes that must be enlarged to admit bolts.

END OF SECTION

SECTION 05 21 00
STEEL JOIST FRAMING

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.02 SUMMARY

A. Section Includes:

1. K-series steel joists.
2. KCS-type K-series steel joists.
3. Joist accessories.

B. Related Requirements:

1. Section 03 30 00 "Cast-in-Place Concrete" for installing bearing plates in concrete.
2. Section 04 22 00 "Concrete Unit Masonry" for installing bearing plates in unit masonry.
3. Section 05 12 00 "Structural Steel Framing" for field-welded shear connectors.

1.03 DEFINITIONS

A. SJI's "Specifications": Steel Joist Institute's "Standard Specifications, Load Tables and Weight Tables for Steel Joists and Joist Girders."

B. Special Joists: Steel joists or joist girders requiring modification by manufacturer to support nonuniform, unequal, or special loading conditions that invalidate load tables in SJI's "Specifications."

1.04 ACTION SUBMITTALS

A. Product Data: For each type of joist, accessory, and product.

B. Shop Drawings:

1. Include layout, designation, number, type, location, and spacing of joists.
2. Include joining and anchorage details, bracing, bridging, and joist accessories; splice and connection locations and details; and attachments to other construction.

3. Indicate locations and details of bearing plates to be embedded in other construction.

1.05 INFORMATIONAL SUBMITTALS

A. Qualification Data: For manufacturer.

B. Welding certificates.

C. Manufacturer certificates.

D. Mill Certificates: For each type of bolt.

E. Comprehensive engineering analysis of special joists signed and sealed by the qualified professional engineer responsible for its preparation.

1.06 QUALITY ASSURANCE

A. Manufacturer Qualifications: A manufacturer certified by SJI to manufacture joists complying with applicable standard specifications and load tables in SJI's "Specifications"

1. Manufacturer's responsibilities include providing professional engineering services for designing special joists to comply with performance requirements.

B. Welding Qualifications: Qualify field-welding procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.07 DELIVERY, STORAGE, AND HANDLING

A. Deliver, store, and handle joists as recommended in SJI's "Specifications."

B. Protect joists from corrosion, deformation, and other damage during delivery, storage, and handling.

1.08 SEQUENCING

A. Deliver steel bearing plates to be built into cast-in-place concrete and masonry construction.

PART 2 - PRODUCTS

2.01 PERFORMANCE REQUIREMENTS

A. Structural Performance: Provide special joists and connections capable of withstanding design loads indicated.

1. Use ASD; data are given at service-load level.
2. Design special joists to withstand design loads with live-load deflections no greater than the following:

    a. Floor Joists: Vertical deflection of 1/360 of the span.
    b. Roof Joists: Vertical deflection of 1/360 of the span.

2.02 K-SERIES STEEL JOISTS

A. Manufacture steel joists of type indicated according to "Standard Specifications for Open Web Steel Joists, K-Series" in SJI's "Specifications," with steel-angle top- and bottom-chord members, underslung ends, and parallel top chord.

    1. Joist Type: K-series steel joists and KCS-type K-series steel joists.

B. Steel Joist Substitutes: Manufacture according to "Standard Specifications for Open Web Steel Joists, K-Series" in SJI's "Specifications," with steel-angle or -channel members.

C. Provide holes in chord members for connecting and securing other construction to joists.

D. Top-Chord Extensions: Extend top chords of joists with SJI's Type S top-chord extensions where indicated, complying with SJI's "Specifications."

E. Extended Ends: Extend bearing ends of joists with SJI's Type R extended ends where indicated, complying with SJI's "Specifications."

F. Do not camber joists.

G. Camber joists according to SJI's "Specifications." .

H. Equip bearing ends of joists with manufacturer's standard beveled ends or sloped shoes if joist slope exceeds 1/4 inch per 12 inches (1:48).

2.02 COMPOSITE STEEL JOISTS

A. Manufacture steel joists according to "Standard Specifications for Composite Steel Joists, CJ-Series" in SJI's "Standard Specifications for Composite Steel Joists, Weight Tables and Bridging Tables, Code of Standard Practice," with steel-angle top- and bottom-chord members and parallel top chord, and with underslung or square ends.

2.03 PRIMERS

A. Primer: Provide shop primer that complies with Section 09 90 00, “Painting and Coating”.

2.04 JOIST ACCESSORIES

A. Bridging: Provide bridging anchors and number of rows of horizontal or diagonal bridging of material, size, and type required by SJI's "Specifications" for type of joist, chord size, spacing, and span. Furnish additional erection bridging if required for stability.

B. Fabricate steel bearing plates from ASTM A 36/A 36M steel with integral anchorages of sizes and thicknesses indicated. Shop prime paint or if indicated on drawings to be Hot-dip zinc coat according to ASTM A 123/A 123M.

C. Steel bearing plates with integral anchorages are specified in Section 055000 "Metal Fabrications."

D. Furnish ceiling extensions, either extended bottom-chord elements or a separate extension unit of enough strength to support ceiling construction. Extend ends to within 1/2 inch (13 mm) of finished wall surface unless otherwise indicated.

E. High-Strength Bolts, Nuts, and Washers: ASTM A 325 (ASTM A 325M), Type 1, heavy hex steel structural bolts. Finish: Plain or Hot-dip zinc coating, ASTM A 153/A 153M, Class C where indicated. .

F. Welding Electrodes: Comply with AWS standards.

G. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20or ASTM A 780.

H. Furnish miscellaneous accessories including splice plates and bolts required by joist manufacturer to complete joist assembly.

2.05 CLEANING AND SHOP PAINTING

A. Clean and remove loose scale, heavy rust, and other foreign materials from fabricated joists and accessories by hand-tool cleaning, SSPC-SP 2 or power-tool cleaning, SSPC-SP 3.

B. Apply one coat of shop primer to joists and joist accessories to be primed to provide a continuous, dry paint film not less than 1 mil (0.025 mm) thick.

C. Shop priming of joists and joist accessories is specified in Section 09 90 00 “Painting and Coating”

PART 3 - EXECUTION

3.01 EXAMINATION

A. Examine supporting substrates, embedded bearing plates, and abutting structural framing for compliance with requirements for installation tolerances and other conditions affecting performance.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.02 INSTALLATION

A. Do not install joists until supporting construction is in place and secured.

B. Install joists and accessories plumb, square, and true to line; securely fasten to supporting construction according to SJI's "Specifications," joist manufacturer's written recommendations, and requirements in this Section.

1. Before installation, splice joists delivered to Project site in more than one piece.
2. Space, adjust, and align joists accurately in location before permanently fastening.
3. Install temporary bracing and erection bridging, connections, and anchors to ensure that joists are stabilized during construction.
4. Delay rigidly connecting bottom-chord extensions to columns or supports until dead loads are applied.

C. Field weld joists to supporting steel bearing plates and framework. Coordinate welding sequence and procedure with placement of joists. Comply with AWS requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.

D. Bolt joists to supporting steel framework using carbon-steel bolts.

E. Bolt joists to supporting steel framework using high-strength structural bolts. Comply with Research Council on Structural Connection's "Specification for Structural Joints Using ASTM A 325 or ASTM A 490 Bolts" for high-strength structural bolt installation and tightening requirements.

F. Install and connect bridging concurrently with joist erection, before construction loads are applied. Anchor ends of bridging lines at top and bottom chords if terminating at walls or beams.

3.03 FIELD QUALITY CONTROL

A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to inspect field welds and bolted connections and to perform field tests and inspections and prepare test and inspection reports.

B. Visually inspect field welds according to AWS D1.1/D1.1M.

1. In addition to visual inspection, test field welds according to AWS D1.1/D1.1M and the following procedures, as applicable:

i. Liquid Penetrant Inspection: ASTM E 165.
ii. Magnetic Particle Inspection: ASTM E 709.
iii. Ultrasonic Testing: ASTM E 164.
iv. Radiographic Testing: ASTM E 94.

C. Visually inspect bolted connections.

D. Correct deficiencies in Work that test and inspection reports have indicated are not in compliance with specified requirements.

E. Perform additional testing to determine compliance of corrected Work with specified requirements.

3.04 PROTECTION

A. Repair damaged galvanized coatings on galvanized items with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.

B. Touchup Painting: After installation, promptly clean, prepare, and prime or reprime field connections, rust spots, and abraded surfaces of prime-painted joists, bearing plates, abutting structural steel, and accessories.

1. Cleaning and touchup painting are specified in Section 09 90 00 "Painting and Coating" Provide final protection and maintain conditions, in a manner acceptable to manufacturer and Installer, that ensure that joists and accessories are without damage or deterioration at time of Substantial Completion.

END OF SECTION

SECTION 05 31 00
STEEL DECKING

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.02 SUMMARY

A. Section Includes:

1. Roof deck.
2. Composite floor deck.
3. Noncomposite form deck.

B. Related Requirements:

1. Section 03 30 00 "Cast-in-Place Concrete" for normal-weight and lightweight structural concrete fill over steel deck.
2. Section 05 12 00 "Structural Steel Framing" for shop- and field-welded shear connectors.
3. Section 05 50 00 "Metal Fabrications" for framing deck openings with miscellaneous steel shapes.
4. Section 09 90 00 “Painting and Coating”.

1.03 ACTION SUBMITTALS

A. Product Data: For each type of deck, accessory, and product indicated.

B. Shop Drawings:

1. Include layout and types of deck panels, anchorage details, reinforcing channels, pans, cut deck openings, special jointing, accessories, and attachments to other construction.

1.04 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Product Certificates: For each type of steel deck.

C. Evaluation Reports: For steel deck.

D. Field quality-control reports.

1.05 QUALITY ASSURANCE

A. Testing Agency Qualifications: Qualified according to ASTM E 329 for testing indicated.

B. Welding Qualifications: Qualify procedures and personnel according to AWS D1.3, "Structural Welding Code - Sheet Steel."

C. FM Global Listing: Provide steel roof deck evaluated by FM Global and listed in its "Approval Guide, Building Materials" for Class 1 fire rating and Class 1-90 windstorm ratings.

1.06 DELIVERY, STORAGE, AND HANDLING

A. Protect steel deck from corrosion, deformation, and other damage during delivery, storage, and handling.

B. Stack steel deck on platforms or pallets and slope to provide drainage. Protect with a waterproof covering and ventilate to avoid condensation.

1. Protect and ventilate acoustical cellular roof deck with factory-installed insulation to maintain insulation free of moisture.

PART 2 - PRODUCTS

2.01 PERFORMANCE REQUIREMENTS

A. AISI Specifications: Comply with calculated structural characteristics of steel deck according to AISI's "North American Specification for the Design of Cold-Formed Steel Structural Members."

2.02 ROOF DECK

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Canam United States; Canam Group Inc.
2. CMC Joist & Deck.
3. Consolidated Systems, Inc.; Metal Dek Group.
4. Cordeck.
5. Epic Metals Corporation.

6. Marlyn Steel Decks, Inc.
7. New Millennium Building Systems, LLC.
8. Nucor Corp.; Vulcraft Group.
9. Verco Manufacturing Co.
10. Wheeling Corrugating Company; Div. of Wheeling-Pittsburgh Steel Corporation.

B. Roof Deck: Fabricate panels, without top-flange stiffening grooves, to comply with "SDI Specifications and Commentary for Steel Roof Deck," in SDI Publication No. 31, and with the following:

1. Galvanized-Steel Sheet: ASTM A 653/A 653M, Structural Steel (SS), Grade 33 (230), G60 (Z180) zinc coating.
2. Deck Profile: As indicated.
3. Profile Depth: 1-1/2 inches (38 mm).
4. Design Uncoated-Steel Thickness: As indicated on plans, 20ga. minimum
5. Span Condition: Three span minimum.
6. Side Laps: Overlapped.

2.03 COMPOSITE FLOOR DECK

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Canam United States; Canam Group Inc.
2. CMC Joist & Deck.
3. Consolidated Systems, Inc.; Metal Dek Group.
4. Cordeck.
5. Epic Metals Corporation.
6. Marlyn Steel Decks, Inc.
7. New Millennium Building Systems, LLC.
8. Nucor Corp.; Vulcraft Group.

B. Composite Floor Deck: Fabricate panels, with integrally embossed or raised pattern ribs and interlocking side laps, to comply with "SDI Specifications and Commentary for Composite Steel Floor Deck," in SDI Publication No. 31, with the minimum section properties indicated, and with the following:

1. Galvanized-Steel Sheet: ASTM A 653/A 653M, Structural Steel (SS), Grade 50 (230), G60 (Z180) zinc coating.
2. Profile Depth: As indicated.
3. Design Uncoated-Steel Thickness: as indicated on plans, 20ga. minimum
4. Span Condition: three span minimum.

2.04 ACCESSORIES

A. General: Provide manufacturer's standard accessory materials for deck that comply with requirements indicated.

B. Mechanical Fasteners: Corrosion-resistant, low-velocity, power-actuated or pneumatically driven carbon-steel fasteners; or self-drilling, self-threading screws.

C. Side-Lap Fasteners: Corrosion-resistant, hexagonal washer head; self-drilling, carbon-steel screws, No. 10 (4.8-mm) minimum diameter.

D. Flexible Closure Strips: Vulcanized, closed-cell, synthetic rubber.

E. Miscellaneous Sheet Metal Deck Accessories: Steel sheet, minimum yield strength of 33,000 psi (230 MPa), not less than 0.0359-inch (0.91-mm) design uncoated thickness, of same material and finish as deck; of profile indicated or required for application.

F. Pour Stops and Girder Fillers: Steel sheet, minimum yield strength of 33,000 psi (230 MPa), of same material and finish as deck, and of thickness and profile indicated.

G. Column Closures, End Closures, Z-Closures, and Cover Plates: Steel sheet, of same material, finish, and thickness as deck unless otherwise indicated.

H. Piercing Hanger Tabs: Piercing steel sheet hanger attachment devices for use with floor deck.

I. Weld Washers: Uncoated steel sheet, shaped to fit deck rib, 0.0747 inch (1.90 mm) thick, with factory-punched hole of 3/8-inch (9.5-mm) minimum diameter.

J. Recessed Sump Pans: Single-piece steel sheet, 0.0747 inch (1.90 mm) thick, of same material and finish as deck, with 3-inch- (76-mm-) wide flanges and sloped recessed pans of 1-1/2-inch (38-mm) minimum depth. For drains, cut holes in the field.

K. Galvanizing Repair Paint: ASTM A 780 or SSPC-Paint 20 or MIL-P-21035B, with dry film containing a minimum of 94 percent zinc dust by weight.

L. Repair Paint: Manufacturer's standard rust-inhibitive primer of same color as primer.

PART 3 - EXECUTION

3.01 EXAMINATION

A. Examine supporting frame and field conditions for compliance with requirements for installation tolerances and other conditions affecting performance.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.02 INSTALLATION, GENERAL

A. Install deck panels and accessories according to applicable specifications and commentary in SDI Publication No. 31, manufacturer's written instructions, and requirements in this Section.

B. Install temporary shoring before placing deck panels if required to meet deflection limitations.

C. Locate deck bundles to prevent overloading of supporting members.

D. Place deck panels on supporting frame and adjust to final position with ends accurately aligned and bearing on supporting frame before being permanently fastened. Do not stretch or contract side-lap interlocks.

1. Align cellular deck panels over full length of cell runs and align cells at ends of abutting panels.

E. Place deck panels flat and square and fasten to supporting frame without warp or deflection.

F. Cut and neatly fit deck panels and accessories around openings and other work projecting through or adjacent to deck.

G. Provide additional reinforcement and closure pieces at openings as required for strength, continuity of deck, and support of other work.

H. Comply with AWS requirements and procedures for manual shielded metal arc welding, appearance and quality of welds, and methods used for correcting welding work.

I. Mechanical fasteners may be used in lieu of welding to fasten deck. Locate mechanical fasteners and install according to deck manufacturer's written instructions.

3.03 ROOF-DECK INSTALLATION

A. Fasten roof-deck panels with puddle welds or TEK screws at a minimum spacing of 12 inches on center or as indicated on the drawings.

B. Side-Lap and Perimeter Edge Fastening: Fasten side laps and perimeter edges of panels between supports, at intervals not exceeding the lesser of 1/2 of the span or 18 inches (457 mm) with puddle welds or TEK screws, or as indicated on the drawings.

C. End Bearing: Install deck ends over supporting frame with a minimum end bearing of 1-1/2 inches (38 mm), with end joints as follows:

1. End Joints: Lapped 2 inches (51 mm) minimum.

D. Roof Sump Pans and Sump Plates: Install over openings provided in roof deck and mechanically fasten flanges to top of deck. Space mechanical fasteners not more than 12 inches (305 mm) apart with at least one fastener at each corner.

1. Install reinforcing channels or zees in ribs to span between supports and mechanically fasten.

E. Miscellaneous Roof-Deck Accessories: Install ridge and valley plates, finish strips, end closures, and reinforcing channels according to deck manufacturer's written instructions. Mechanically fasten to substrate to provide a complete deck installation.

1. Weld cover plates at changes in direction of roof-deck panels unless otherwise indicated.

F. Flexible Closure Strips: Install flexible closure strips over partitions, walls, and where indicated. Install with adhesive according to manufacturer's written instructions to ensure complete closure.

3.04 FLOOR-DECK INSTALLATION

A. Side-Lap and Perimeter Edge Fastening: Fasten side laps and perimeter edges of panels between supports, at intervals not exceeding the lesser of half of the span or 36 inches (914 mm), and as follows:

1. Mechanically fasten with self-drilling, No. 10 (4.8-mm-) diameter or larger, carbon-steel screws.
2. Mechanically clinch or button punch.
3. Or as indicated on the drawings.

B. End Bearing: Install deck ends over supporting frame with a minimum end bearing of 1-1/2 inches (38 mm) , with end joints as follows:

1. End Joints: Lapped

C. Pour Stops and Girder Fillers: Weld steel sheet pour stops and girder fillers to supporting structure according to SDI recommendations unless otherwise indicated.

D. Floor-Deck Closures: Weld steel sheet column closures, cell closures, and Z-closures to deck, according to SDI recommendations, to provide tight-fitting closures at open ends of ribs and sides of deck.

E. Install piercing hanger tabs at 14 inches (355 mm) apart in both directions, within 9 inches (228 mm) of walls at ends, and not more than 12 inches (305 mm) from walls at sides unless otherwise indicated.

3.05 FIELD QUALITY CONTROL

A. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.

B. Field welds will be subject to inspection.

C. Testing agency will report inspection results promptly and in writing to Contractor and Architect.

D. Remove and replace work that does not comply with specified requirements.

E. Additional inspecting, at Contractor's expense, will be performed to determine compliance of corrected work with specified requirements.

3.06 PROTECTION

A. Galvanizing Repairs: Prepare and repair damaged galvanized coatings on both surfaces of deck with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.

B. Repair Painting: Wire brush and clean rust spots, welds, and abraded areas on both surfaces of prime-painted deck immediately after installation, and apply repair paint.

1. Apply repair paint, of same color as adjacent shop-primed deck, to bottom surfaces of deck exposed to view.
2. Wire brushing, cleaning, and repair painting of bottom deck surfaces are included in Section 09 90 00 "Painting and Coating".

C. Repair Painting: Wire brushing, cleaning, and repair painting of rust spots, welds, and abraded areas of both deck surfaces are included in Section 09 90 00 "Painting and Coating".

D. Provide final protection and maintain conditions to ensure that steel deck is without damage or deterioration at time of Substantial Completion.

END OF SECTION

SECTION 05 44 00
COLD-FORMED METAL TRUSSES

PART 1 - GENERAL

1.01 SUMMARY

A. Section Includes:

1. Cold-formed steel trusses for roofs.

1.02 ACTION SUBMITTALS

A. Product Data: For each type of product.

B. Shop Drawings:

1. Include layout, spacings, sizes, thicknesses, and types of cold-formed steel trusses; fabrication; and fastening and anchorage details, including mechanical fasteners.

2. Indicate reinforcing channels, opening framing, supplemental framing, strapping, bracing, bridging, splices, accessories, connection details, and attachment to adjoining work.

C. Delegated-Design Submittal: For cold-formed steel trusses.

1.03 INFORMATIONAL SUBMITTALS

A. Qualification Data: For testing agency.

B. Welding certificates.

C. Product test reports.

D. Field quality-control reports.

1.04 QUALITY ASSURANCE

A. Testing Agency Qualifications: Qualified according to ASTM E 329 for testing indicated.

B. Product Tests: Mill certificates or data from a qualified testing agency indicating steel sheet complies with requirements, including base-metal thickness, yield strength, tensile strength, total elongation, chemical requirements, and metallic-coating thickness.

C. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
2. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."

PART 2 - PRODUCTS

2.01 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Aegis Metal Framing.
2. Nuconsteel, a Nucor Company.
3. TrusSteel; an ITW company.

2.02 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer, to design cold-formed steel framing.

B. Structural Performance: Provide cold-formed steel trusses capable of withstanding design loads within limits and under conditions indicated.

1. Design Loads: As indicated on structural drawings.
2. Deflection Limits: Design trusses to withstand design loads without deflections greater than the following:
   a. Roof Trusses: Vertical deflection of 1/360 of the span.
3. Design framing systems to provide for movement of framing members located outside the insulated building envelope 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.

C. Cold-Formed Steel Framing Design Standards:

1. Floor and Roof Systems: Design according to AISI S210.
2. Lateral Design: Design according to AISI S213.
3. Roof Trusses: Design according to AISI S214.

D. Fire-Resistance Ratings: Comply with ASTM E 119; testing by a qualified testing agency. Identify products with appropriate markings of applicable testing agency.

2.03 COLD-FORMED STEEL TRUSS 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, minimum, or as required by structural performance.
2. Coating: G60, A60, AZ50, or GF30.

2.04 ROOF TRUSSES

A. Roof Truss Members: Manufacturer's standard steel sections.

1. Connecting Flange Width: 1-5/8 inches, minimum at top and bottom chords connecting to sheathing or other directly fastened construction.
2. Minimum Base-Metal Thickness: 0.0346 inch.

2.05 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 truss members.

B. Provide accessories of manufacturer's standard thickness and configuration unless otherwise indicated.

2.06 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 allowable load or strength design capacities calculated according to ICC-ES AC193 and Appendix D in ACI 318, greater than or equal to the design load, as determined by testing per ASTM E 488 conducted by a qualified testing agency.

C. Power-Actuated Fasteners: Fastener system of type suitable for application indicated, fabricated from corrosion-resistant materials, with capability to sustain, without failure, allowable load capacities calculated according to ICC-ES AC70, greater than or equal to the design load, as determined by testing per ASTM E 1190 conducted by a qualified testing agency.

D. 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.

E. Welding Electrodes: Comply with AWS standards.

2.07 MISCELLANEOUS MATERIALS

A. Galvanizing Repair Paint: ASTM A 780.

B. Shims: Load bearing, of high-density multimonomer plastic, nonleaching, or of cold-formed steel of same grade and coating as framing members supported by shims.

2.08 FABRICATION

A. Fabricate cold-formed steel trusses 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 trusses using jigs or templates.
2. Cut truss members by sawing or shearing; do not torch cut.
3. Fasten cold-formed steel truss members by welding, screw fastening, clinch fastening, pneumatic pin fastening, or riveting as standard with fabricator.
   a. Comply with AWS D1.3/D1.3M requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
4. Fasten other materials to cold-formed steel trusses by welding, bolting, pneumatic pin fastening, or screw fastening, according to Shop Drawings.

B. Reinforce, stiffen, and brace trusses to withstand handling, delivery, and erection stresses. Lift fabricated trusses 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

3.01 INSTALLATION

A. Install, bridge, and brace cold-formed steel trusses according to AISI S200, AISI S214, AISI's "Code of Standard Practice for Cold-Formed Steel Structural

Framing," and manufacturer's written instructions unless more stringent requirements are indicated.

B. Install cold-formed steel trusses and accessories plumb, square, and true to line, and with connections securely fastened.

1. Fasten cold-formed steel trusses by welding or mechanical fasteners.

a. Comply with AWS D1.3/D1.3M 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; comply with requirements for spacing, edge distances, and screw penetration.

C. Install temporary bracing and supports. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to framing are secured.

D. Truss Spacing: As indicated on structural drawings or 4'-0" o.c., maximum.

E. Do not alter, cut, or remove framing members or connections of trusses.

F. Erect trusses with plane of truss webs plumb and parallel to each other, align, and accurately position at spacings indicated.

G. Erect trusses without damaging framing members or connections.

H. Coordinate with wall framing to align webs of bottom chords and load-bearing studs or continuously reinforce track to transfer loads to structure. Anchor trusses securely at all bearing points.

I. Install continuous bridging and permanently brace trusses as indicated on Shop Drawings and designed according to CFSEI's TechNote 551e, "Design Guide: Permanent Bracing of Cold-Formed Steel Trusses.".

J. Erection Tolerances: Install cold-formed steel 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 trusses 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.

3.02 FIELD QUALITY CONTROL

A. Special Inspections: Owner will engage a qualified special inspector to perform inspections.

B. Prepare test and inspection reports.

3.03 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 trusses are without damage or deterioration at time of Substantial Completion.

END OF SECTION

SECTION 05 50 00
METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section Includes:

1. Steel framing and supports for overhead doors and grilles.
2. Steel framing and supports for mechanical and electrical equipment.
3. Steel framing and supports for applications where framing and supports are not specified in other Sections.
4. Elevator machine beams, hoist beams,.
5. Steel shapes for supporting elevator door sills.
6. Shelf angles.
7. Metal ladders.
8. Ladder safety cages.
9. Metal floor plate and supports.
10. Structural-steel door frames.
11. Miscellaneous steel trim including steel angle corner guards steel edgings and loading-dock edge angles.
12. Metal bollards.
13. Downspout guards.
14. Abrasive metal nosings treads and thresholds.
15. Metal downspout boots.
16. Loose bearing and leveling plates for applications where they are not specified in other Sections.

B. Products furnished, but not installed, under this Section:

1. Loose steel lintels.
2. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
3. Steel weld plates and angles for casting into concrete for applications where they are not specified in other Sections.

C. Related Sections:

1. Section 03 30 00 "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 04 22 00 "Concrete Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
3. Section 05 12 00 "Structural Steel Framing."
4. Section 05 51 13 "Metal Pan Stairs."
5. Section 05 52 10 "Pipe and Tube Railings."
6. Section 05 53 13 "Bar Gratings."

1.3 PERFORMANCE REQUIREMENTS

A. Delegated Design: Design ladders and stairs, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

B. Structural Performance of Aluminum Ladders: Aluminum ladders, stairs, and landings, shall withstand the effects of loads and stresses within limits and under conditions specified in ANSI A14.3 and the International Building Code.

C. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.

1. Temperature Change: 120 deg F ambient; 180 deg F material surfaces.

1.4 ACTION SUBMITTALS

A. Product Data: For the following:

1. Nonslip aggregates and nonslip-aggregate surface finishes.
2. Metal nosings and treads.
3. Paint products.
4. 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.

1.5 INFORMATIONAL SUBMITTALS

A. Qualification Data: For qualified professional engineer.

B. Mill Certificates: Signed by manufacturers of stainless-steel certifying that products furnished comply with requirements.

C. Welding certificates.

D. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.6 QUALITY ASSURANCE

A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

B. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
2. AWS D1.2/D1.2M, "Structural Welding Code - Aluminum."
3. AWS D1.6, "Structural Welding Code - Stainless Steel."

1.7 PROJECT CONDITIONS

A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication.

1.8 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.

B. Coordinate installation of anchorages and steel weld plates and angles for casting into concrete. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

PART 2 - PRODUCTS

2.1 METALS, GENERAL

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

2.2 FERROUS METALS

A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

B. Stainless-Steel Sheet, Strip, and Plate: ASTM A 240/A 240M or ASTM A 666, Type 316L.

C. Stainless-Steel Bars and Shapes: ASTM A 276, Type 316L.

D. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.

E. Rolled-Stainless-Steel Floor Plate: ASTM A 793.

F. Abrasive-Surface Floor Plate: Steel plate with abrasive granules rolled into surface or with abrasive material metallically bonded to steel.

G. Steel Tubing: ASTM A 500, cold-formed steel tubing.

H. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40) unless otherwise indicated.

I. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.

1. Size of Channels: As indicated.
2. Material: Galvanized steel, ASTM A 653/A 653M, structural steel, Grade 33 with G90coating; 0.079-inchnominal thickness.

J. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

2.3 NONFERROUS METALS

A. Aluminum Plate and Sheet: ASTM B 209 Alloy 6061-T6.

B. Aluminum Extrusions: ASTM B 221 Alloy 6063-T6.

C. Aluminum-Alloy Rolled Tread Plate: ASTM B 632/B 632M, Alloy 6061-T6.

D. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

E. Bronze Plate, Sheet, Strip, and Bars: ASTM B 36/B 36M, Alloy UNS No. C28000 (muntz metal, 60 percent copper).

F. Bronze Extrusions: ASTM B 455, Alloy UNS No. C38500 (extruded architectural bronze).

G. Bronze Castings: ASTM B 584, Alloy UNS No. C83600 (leaded red brass) or No. C84400 (leaded semired brass).

H. Nickel Silver Extrusions: ASTM B 151/B 151M, Alloy UNS No. C74500.

I. Nickel Silver Castings: ASTM B 584, Alloy UNS No. C97600 (20 percent leaded nickel bronze).

2.4 FASTENERS

A. General: Unless otherwise indicated, provide Type 316 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.

1. Provide stainless-steel fasteners for fastening aluminum.
2. Provide stainless-steel fasteners for fastening stainless steel.
3. Provide stainless-steel fasteners for fastening nickel silver.
4. Provide bronze fasteners for fastening bronze.

B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A with hex nuts, ASTM A 563 and, where indicated, flat washers.

C. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 325, Type 3 with hex nuts, ASTM A 563, Grade C3 and, where indicated, flat washers.

D. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593 with hex nuts, ASTM F 594 and, where indicated, flat washers; Alloy Group 1 (A1).

E. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; and, where indicated, flat washers.

1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.

F. Eyebolts: ASTM A 489.

G. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).

H. Lag Screws: ASME B18.2.1 (ASME B18.2.3.8M).

I. Wood Screws: Flat head, ASME B18.6.1.

J. Plain Washers: Round, ASME B18.22.1 (ASME B18.22M).

K. Lock Washers: Helical, spring type, ASME B18.21.1 (ASME B18.21.2M).

L. Anchors, General: Anchors capable of sustaining, 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.

M. Cast-in-Place Anchors in Concrete: Either threaded type or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A 47/A 47M malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F 2329.

N. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors.

1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.
2. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

O. Slotted-Channel Inserts: Cold-formed, hot-dip galvanized-steel box channels (struts) complying with MFMA-4, 1-5/8 by 7/8 inches (41 by 22 mm) by length indicated with anchor straps or studs not less than 3 inches (75 mm) long at not more than 8 inches (200 mm) o.c. Provide with temporary filler and tee-head bolts, complete with washers and nuts, all zinc-plated to comply with ASTM B 633, Class Fe/Zn 5, as needed for fastening to inserts.

2.5 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 Section 09 90 00 "Paintings and Coatings."

C. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.

1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.

D. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.

E. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

F. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.

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

H. 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.

I. Concrete: Comply with requirements in Section 03 30 00 "Cast-in-Place Concrete" for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa).

2.6 FABRICATION, GENERAL

A. Shop Assembly: Preassemble items in the shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.

B. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch (1 mm) unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.

C. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.

D. Form exposed work with accurate angles and surfaces and straight edges.

E. Weld corners and seams continuously to comply with the following:

1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
2. Obtain fusion without undercut or overlap.
3. Remove welding flux immediately.
4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing.

F. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners or welds where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) fasteners unless otherwise indicated. Locate joints where least conspicuous.

G. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

H. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.

I. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.

1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches (3.2 by 38 mm), with a minimum 6-inch (150-mm) embedment and 2-inch (50-mm) hook, not less than 8 inches (200 mm) from ends and corners of units and 24 inches (600 mm) o.c., unless otherwise indicated.

2.7 MISCELLANEOUS FRAMING AND SUPPORTS

A. General: Provide steel framing and supports not specified in other Sections as needed to complete the Work.

B. Fabricate units from steel shapes, plates, and bars of welded construction unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction.

1. Fabricate units from slotted channel framing where indicated.
2. Furnish inserts for units installed after concrete is placed.

C. Galvanize miscellaneous framing and supports where indicated.

D. Prime miscellaneous framing and supports with primer specified in Section 09 90 00 "Painting and Coatings" where indicated.

2.8 SHELF ANGLES

A. Fabricate shelf angles from steel angles of sizes indicated and for attachment to concrete framing. Provide horizontally slotted holes to receive 3/4-inch (19-mm) bolts, spaced not more than 6 inches (150 mm) from ends and 24 inches (600 mm) o.c., unless otherwise indicated.

1. Provide mitered and welded units at corners.
2. Provide open joints in shelf angles at expansion and control joints. Make open joint approximately 2 inches (50 mm) larger than expansion or control joint.

B. For cavity walls, provide vertical channel brackets to support angles from backup masonry and concrete.

C. Galvanize all shelf angles.

D. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.

2.9 METAL LADDERS

A. General:

1. Comply with ANSI A14.3 unless otherwise indicated.
2. For elevator pit ladders, comply with ASME A17.1.

B. Steel Ladders:

1. Space siderails 16 inches (406 mm) apart unless otherwise indicated.
2. Space siderails of elevator pit ladders 12 inches (300 mm) apart.
3. Siderails: Continuous, minimum of 1/2-by-2-1/2-inch (12.7-by-64-mm) steel flat bars, with eased edges.
4. Rungs: minimum 3/4-inch- (19-mm-) diameter steel bars.
5. Fit rungs in centerline of siderails; plug-weld and grind smooth on outer rail faces.
6. 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.
7. Provide nonslip surfaces on top of each rung by coating with abrasive material metallically bonded to rung.
8. Provide platforms as indicated fabricated from welded or pressure-locked steel bar grating, supported by steel angles. Limit openings in gratings to no more than 1/2 inch (12 mm) in least dimension.
9. Support each ladder at top and bottom and not more than 60 inches (1500 mm) o.c. with welded or bolted steel brackets.
10. Galvanize exterior ladders, including brackets and fasteners.
11. Prime interior ladders, including brackets and fasteners, with primer specified in Section 099000 "Painting and Coatings."

C. Aluminum Ladders:

1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
   a. ACL Industries, Inc.
   b. Alco-Lite Industrial Products.
   c. Halliday Products.
   d. O'Keeffe's Inc.
   e. Precision Ladders, LLC.
   f. Royalite Manufacturing, Inc.
   g. Thompson Fabricating, LLC.
2. Space siderails 16 inches (406 mm) apart unless otherwise indicated.
3. Siderails: Continuous extruded-aluminum channels or tubes, not less than 2-1/2 inches (64 mm) deep, 3/4 inch (19 mm) wide, and 1/8 inch (3.2 mm) thick.

4. Rungs: Extruded-aluminum tubes, not less than 3/4 inch (19 mm) deep and not less than 1/8 inch (3.2 mm) thick, with ribbed tread surfaces.
5. Fit rungs in centerline of siderails; fasten by welding or with stainless-steel fasteners or brackets and aluminum rivets.
6. Provide platforms as indicated fabricated from pressure-locked aluminum bar grating, supported by extruded-aluminum framing. Limit openings in gratings to no more than 1/2 inch (12 mm) in least dimension.
7. Support each ladder at top and bottom and not more than 60 inches (1500 mm) o.c. with welded or bolted aluminum brackets.
8. Provide minimum 72-inch- (1830-mm-) high, hinged security door with padlock hasp at foot of ladder to prevent unauthorized ladder use.

2.10 LADDER SAFETY CAGES

A. General:

1. Fabricate ladder safety cages to comply with ANSI A14.3. Assemble by welding or with stainless-steel fasteners.
2. Provide primary hoops at tops and bottoms of cages and spaced not more than 20 feet (6 m) o.c. Provide secondary intermediate hoops spaced not more than 48 inches (1200 mm) o.c. between primary hoops.
3. Fasten assembled safety cage to ladder rails and adjacent construction by welding or with stainless-steel fasteners unless otherwise indicated.

B. Steel Ladder Safety Cages:

1. Primary Hoops: 1/4-by-4-inch (6.4-by-100-mm) flat bar hoops.
2. Secondary Intermediate Hoops: 1/4-by-2-inch (6.4-by-50-mm) flat bar hoops.
3. Vertical Bars: 3/16-by-1-1/2-inch (4.8-by-38-mm) flat bars secured to each hoop.
4. Galvanize ladder safety cages, including brackets and fasteners.

C. Aluminum Ladder Safety Cages:

1. Primary Hoops: 1/4-by-4-inch (6.4-by-100-mm) flat bar hoops.
2. Secondary Intermediate Hoops: 1/4-by-2-inch (6.4-by-50-mm) flat bar hoops.
3. Vertical Bars: 1/4-by-2-inch (6.4-by-50-mm) flat bars secured to each hoop.

2.11 METAL FLOOR PLATE

A. Provide angle supports as indicated.

B. Include angle stiffeners, and fixed and removable sections as indicated.

C. Provide flush bar drop handles for lifting removable sections, one at each end of each section.

2.12 STRUCTURAL-STEEL DOOR FRAMES

A. Fabricate structural-steel door frames from steel shapes, plates, and bars of size and to dimensions indicated, fully welded together, with 5/8-by-1-1/2-inch (16-by-38-mm) steel channel 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 (250 mm) o.c. Reinforce frames and drill and tap as necessary to accept finish hardware.

1. Provide with integrally welded steel strap anchors for securing door frames into adjoining concrete or masonry.

B. 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.

C. Galvanize exterior steel frames.

D. Prime steel frames with primer specified in Section 09 90 00 "Paintings and Coatings."

2.13 MISCELLANEOUS STEEL TRIM

A. Unless otherwise indicated, fabricate units from 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.

1. Provide with integrally welded steel strap anchors for embedding in concrete or masonry construction.

C. Galvanize exterior miscellaneous steel trim.

D. Prime miscellaneous steel trim with primer specified in Section 09 90 00 "Paint and Coatings."

2.14 METAL BOLLARDS

A. Fabricate metal bollards from steel shapes, as indicated.

1. Cap bollards with 1/4-inch- (6.4-mm-) thick steel plate.
2. Where bollards are indicated to receive controls for door operators, provide necessary cutouts for controls and holes for wire.

3. Where bollards are indicated to receive light fixtures, provide necessary cutouts for fixtures and holes for wire.

B. Fabricate bollards with 3/8-inch- (9.5-mm-) thick steel baseplates for bolting to concrete slab. Drill baseplates at all four corners for 3/4-inch (19-mm) anchor bolts.

1. Where bollards are to be anchored to sloping concrete slabs, angle baseplates for plumb alignment of bollards.

C. Fabricate sleeves for bollard anchorage from steel pipe with 1/4-inch- (6.4-mm-) thick steel plate welded to bottom of sleeve. Make sleeves not less than 8 inches (200 mm) deep and 3/4 inch (19 mm) larger than OD of bollard.

D. Fabricate internal sleeves for removable bollards from Schedule 40 steel pipe or 1/4-inch (6.4-mm) wall-thickness steel tubing with an OD approximately 1/16 inch (1.5 mm) less than ID of bollards. Match drill sleeve and bollard for 3/4 inch (19 mm) steel machine bolt.

E. Prime bollards with primer specified in Section 09 90 00 "Paint and Coatings."

2.15 LOOSE BEARING AND LEVELING PLATES

A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts and for grouting.

B. Galvanize plates.

2.16 LOOSE STEEL LINTELS

A. Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated. Fabricate in single lengths for each opening unless otherwise indicated. Weld adjoining members together to form a single unit where indicated.

B. Size loose lintels to provide bearing length at each side of openings equal to 1/12 of clear span but not less than 8 inches (200 mm) unless otherwise indicated.

C. Galvanize loose steel lintels located in exterior walls.

2.17 STEEL WELD PLATES AND ANGLES

A. Provide steel weld plates and angles not specified in other Sections, for items supported from concrete construction as needed to complete the Work. Provide each unit with no fewer than two integrally welded steel strap anchors for embedding in concrete.

2.18 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.

C. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.19 STEEL AND IRON FINISHES

A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.

B. Shop prime iron and steel items not indicated to be galvanized unless they are to be embedded in concrete, sprayed-on fireproofing, or masonry, or unless otherwise indicated.

1. Shop prime with universal shop primer unless indicated.

C. Preparation for Shop Priming: Prepare surfaces to comply with SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."

1. Exterior Items: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
2. Items Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
3. Items Indicated to Receive Primers Specified in Section 09 90 00 "Paint and Coatings": SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."

D. Shop Priming: Apply shop primer to 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.

2.20 ALUMINUM FINISHES

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

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

C. 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.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

A. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.

B. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.

C. Field Welding: Comply with the following requirements:

1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
2. Obtain fusion without undercut or overlap.
3. Remove welding flux immediately.
4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.

D. Fastening to In-Place Construction: Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction. Provide threaded fasteners for use with concrete and masonry inserts, toggle bolts, through bolts, lag screws, wood screws, and other connectors.

E. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.

F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with the following:

1. Cast Aluminum: Heavy coat of bituminous paint.
2. Extruded Aluminum: Two coats of clear lacquer.

3.2 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings.

B. Anchor supports for operable partitions securely to and rigidly brace from building structure.

C. Support steel girders on solid grouted masonry, concrete, or steel pipe columns. Secure girders with anchor bolts embedded in grouted masonry or concrete or with bolts through top plates of pipe columns.

1. Where grout space under bearing plates is indicated for girders supported on concrete or masonry, install as specified in "Installing Bearing and Leveling Plates" Article.

D. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified in "Installing Bearing and Leveling Plates" Article.

1. Grout baseplates of columns supporting steel girders after girders are installed and leveled.

3.3 INSTALLING METAL BOLLARDS

A. Fill metal-capped bollards solidly with concrete and allow concrete to cure seven days before installing.

1. Do not fill removable bollards with concrete.

B. Anchor bollards to existing construction with anchor bolts. Provide four 3/4-inch (19-mm) bolts at each bollard unless otherwise indicated.

1. Embed anchor bolts at least 6 inches in concrete.

C. Anchor bollards in place with concrete footings. Center and align bollards in holes 3 inches (75 mm) above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace bollards in position until concrete has cured.

D. Fill bollards solidly with concrete, mounding top surface to shed water.

1. Do not fill removable bollards with concrete.

3.4 INSTALLING PIPE GUARDS

A. Provide pipe guards at exposed vertical pipes in parking garage where not protected by curbs or other barriers. Install by bolting to wall or column with expansion anchors. Provide four 3/4-inch (19-mm) bolts at each pipe guard. Mount pipe guards with top edge 26 inches (660 mm) above driving surface.

3.5 INSTALLING BEARING AND LEVELING PLATES

A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of plates.

B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.

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

3.6 ADJUSTING AND CLEANING

A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (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 05 51 13
METAL PAN STAIRS

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.02 SUMMARY

A. Section Includes:

1. Preassembled steel stairs with concrete-filled treads.

B. Related Requirements:

1. Section 03 30 00 "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
2. Section 05 52 10 "Pipe and Tube Railings" for pipe and tube railings.

1.03 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.

B. 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.

C. Coordinate locations of hanger rods and struts with other work so that they do not encroach on required stair width and are within the fire-resistance-rated stair enclosure.

1.04 ACTION SUBMITTALS

A. Product Data: For metal pan stairs and the following:

1. Prefilled metal-pan-stair treads.
2. Abrasive nosings.
3. Paint products.

B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

C. Samples for Verification: For each type and finish of nosing.

D. Delegated-Design Submittal: For stairs and railings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.05 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.06 QUALITY ASSURANCE

A. Installer Qualifications: Fabricator of products.

B. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
2. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."

PART 2 - PRODUCTS

2.01 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Alfab, Inc.
2. American Stair, Inc.
3. Lapeyre Stair, Inc.
4. Pacific Stair Corporation
5. Worthington Metal Fabrications

2.02 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer to design stairs and railings.

B. Structural Performance of Stairs: Metal stairs shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Uniform Load: 100 lbf/sq. ft. (4.79 kN/sq. m).
2. Concentrated Load: 300 lbf (1.33 kN) applied on an area of 4 sq. in. (2580 sq. mm).
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 to L/360 or 1/4 inch (6.4 mm), whichever is less.

C. Structural Performance of Railings: Railings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Handrails and Top Rails of Guards:

   a. Uniform load of 50 lbf/ft. (0.73 kN/m) applied in any direction.
   b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
   c. Uniform and concentrated loads need not be assumed to act concurrently.

2. Infill of Guards:

   a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
   b. Infill load and other loads need not be assumed to act concurrently.

D. Seismic Performance of Stairs: Metal stairs shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.

1. Component Importance Factor: 1.5.

2.03 METALS

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.

B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

C. Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513.

D. 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.

E. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, either commercial steel, Type B, or structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.

F. Aluminum Extrusions: ASTM B 221 (ASTM B 221M), Alloy 6063-T6.

G. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

H. Bronze Extrusions: ASTM B 455, Alloy UNS No. C38500 (extruded architectural bronze).

I. Bronze Castings: ASTM B 584, Alloy UNS No. C83600 (leaded red brass) or No. C84400 (leaded semired brass).

J. Nickel Silver Castings: ASTM B 584, Alloy UNS No. C97600 (20 percent leaded nickel bronze).

2.04 ABRASIVE NOSINGS

A. Cast-Metal Units: Cast aluminum, with an integral abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.

1. Configuration: Cross-hatched units, 3 inches (75 mm) wide without lip.

B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.

C. Apply bituminous paint to concealed surfaces of cast-metal units set into concrete.

D. Apply clear lacquer to concealed surfaces of extruded units set into concrete.

2.05 FASTENERS

A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 12 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 (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, of dimensions indicated; with nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.

1. Provide mechanically deposited or hot-dip, zinc-coated anchor bolts for exterior stairs or stairs indicated to be galvanized.

D. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors capable of sustaining, 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/E 488M, conducted by a qualified independent testing agency.

1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.
2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

2.06 MISCELLANEOUS MATERIALS

A. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Public Health's (formerly, the California Department of Health Services') "Standard Method for the Testing and Evaluation of Volatile Organic Chemical Emissions from Indoor Sources Using Environmental Chambers."

B. Shop Primers: Provide primers that comply with Section 09 90 00 “Painting and Coating”

C. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

D. Concrete Materials and Properties: Comply with requirements in Section 03 30 00 "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa) unless otherwise indicated.

E. Nonslip-Aggregate Concrete Finish: Factory-packaged abrasive aggregate made from fused, aluminum-oxide grits or crushed emery; rustproof and nonglazing; unaffected by freezing, moisture, or cleaning materials.

F. Welded Wire Reinforcement: ASTM A 185/A 185M, 6 by 6 inches (152 by 152 mm), W1.4 by W1.4, unless otherwise indicated.

2.07 FABRICATION, GENERAL

A. Provide complete stair assemblies, including metal framing, hangers, struts, 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 (1 mm) 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 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 to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 4 welds: good quality, uniform undressed weld with minimal splatter.

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.

2.08 STEEL-FRAMED STAIRS

A. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," Commercial Class, unless more stringent requirements are indicated.

B. Stair Framing:

1. Fabricate stringers of steel channels.
   a. Provide closures for exposed ends of channel stringers.

2. Construct platforms of steel channel headers and miscellaneous framing members as needed to comply with performance requirements indicated.
3. Weld or bolt stringers to headers; weld or bolt framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.
4. Where stairs are enclosed by gypsum board shaft-wall assemblies, provide hanger rods or struts to support landings from floor construction above or below. Locate hanger rods and struts where they do not encroach on required stair width and are 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.

C. 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 0.067 inch (1.7 mm) indicated.

1. Steel Sheet: Uncoated cold or hot-rolled steel sheet unless otherwise indicated.
2. Steel Sheet: Galvanized-steel sheet, where indicated.
3. Directly weld metal pans to stringers; locate welds on top of subtreads where they are concealed by concrete fill. Do not weld risers to stringers.
4. Attach risers and subtreads to stringers with brackets made of steel angles or bars. Weld brackets to stringers and attach metal pans to brackets by welding, riveting, or bolting.
5. Shape metal pans to include nosing integral with riser.
6. Attach abrasive nosings to risers.
7. At Contractor's option, provide stair assemblies with metal pan subtreads filled with reinforced concrete during fabrication.
8. Provide epoxy-resin-filled treads, reinforced with glass fibers, with slip-resistant, abrasive surface.
9. 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 flat metal under surfaces to produce smooth soffits.

2.09 STAIR RAILINGS: Refer to Specification 05 52 10, “Pipe and Tube Railings”

A. 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.

1. Finish welds to comply with NOMMA's "Voluntary Joint Finish Standards" for For exposed steel framing in the admin / office building, Type 2 welds: completely sanded joint, some undercutting and pinholes are okay All other locations: Type 4 welds: good quality, uniform undressed weld with minimal splatter as shown in NAAMM AMP 521.

B. Form changes in direction of railings as follows:

1. As detailed.
2. By bending or inserting prefabricated bends.
3. By flush bends.
4. By radius bends of radius indicated.

C. For changes in direction made by bending, use 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.

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. Connect posts to stair framing by direct welding unless otherwise indicated.

G. 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. For galvanized railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
2. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
3. Provide type of bracket with flange tapped for concealed anchorage to threaded hanger bolt with predrilled hole for exposed bolt anchorage and that provides 1-1/2-inch (38-mm) clearance from inside face of handrail to finished wall surface.

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.

2.10 FINISHES

A. Finish metal stairs after assembly.

B. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.
2. Fill vent and drain holes that are exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.

C. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with SSPC-SP 3, "Power Tool 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.

PART 3 - EXECUTION

3.01 INSTALLING METAL PAN STAIRS

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 requirements for welding in "Fabrication, General" Article.

G. Place and finish concrete fill for treads and platforms to comply with Section 03 30 00 "Cast-in-Place Concrete."

1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.

H. Install precast concrete treads with adhesive supplied by manufacturer.

3.02 INSTALLING RAILINGS: Refer to Specification 05 52 10, "Pipe and Tube Railings"

3.03 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 same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in Section 09 90 00, "Painting and Coating"

C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

END OF SECTION

SECTION 05 51 19
METAL GRATING STAIRS

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

B. Section 05 52 10 Pipe and Tube Railings.

1.02 SUMMARY

A. Section includes industrial-type, straight-run stairs with steel-grating treads and railings attached to metal grating stairs.

1.03 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible with one another.

B. 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.

1.04 ACTION SUBMITTALS

A. Product Data: For metal grating stairs and the following:

1. Paint products.
2. Grout.

B. Shop Drawings: Include plans, elevations, sections, details, and attachments.

C. Delegated-Design Submittal: For stairs, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.05 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.

1.06 QUALITY ASSURANCE

A. Installer Qualifications: Fabricator of products.

B. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

PART 2 - PRODUCTS

2.01 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer to design stairs and railings.

B. Structural Performance of Stairs: Metal stairs shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Uniform Load: 100 lbf/sq. ft. (4.79 kN/sq. m).
2. Concentrated Load: 300 lbf (1.33 kN) applied on an area of 4 sq. in. (2580 sq. mm).
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 to L/360.

C. Seismic Performance of Stairs: Metal stairs shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.

1. Component Importance Factor: 1.5.

2.02 METALS

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.

B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

C. 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.

D. Steel Bars for Grating Treads: ASTM A 36/A 36M or steel strip, ASTM A 1011/A 1011M or ASTM A 1018/A 1018M.

E. Wire Rod for Grating Crossbars: ASTM A 510 (ASTM A 510M).

F. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

G. Cast-Abrasive Nosings: Cast iron, with an integral abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both.

2.03 FASTENERS

A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 12 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 (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, of dimensions indicated; with nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.

1. Provide mechanically deposited or hot-dip, zinc-coated anchor bolts for exterior stairs or stairs indicated to be galvanized.

D. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors capable of sustaining, 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/E 488M, conducted by a qualified independent testing agency.

1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.

2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

2.04 MISCELLANEOUS MATERIALS

A. Shop Primers: Provide primers that comply with Section 09 90 00 "Painting and Coating".

B. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

C. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107/C 1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.

2.05 FABRICATION, GENERAL

A. Provide complete stair assemblies, including metal framing, hangers, 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. Form exposed work with accurate angles and surfaces and straight edges.

C. 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 to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 4 welds: good quality, uniform undressed weld with minimal splatter.

D. Fabricate joints that are exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

2.06 STEEL-FRAMED STAIRS

A. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," Industrial Class, unless more stringent requirements are indicated.

B. Stair Framing:

1. Fabricate stringers of steel channels.
   i. Provide closures for exposed ends of channel stringers.

2. Construct platforms of steel channel headers and miscellaneous framing members as needed to comply with performance requirements indicated.
3. Weld or bolt stringers to headers; weld or bolt framing members to stringers and headers.

2.07 Metal Bar-Grating Stairs: Form treads and platforms to configurations shown from metal bar grating; fabricate to comply with NAAMM MBG 531, "Metal Bar Grating Manual."

1. Fabricate treads and platforms from welded steel grating designed to meet the required loadings.
2. Fabricate treads and platforms from welded steel grating with openings in gratings no more than 1/2 inch (12 mm) in least dimension.

3. Surface: Serrated.
4. Finish: As indicated.
5. Fabricate grating treads with cast-abrasive nosing and with steel angle or steel plate carrier at each end for stringer connections. Secure treads to stringers with bolts.
6. Fabricate grating platforms with nosing matching that on grating treads. Provide toeplates at open-sided edges of grating platforms. Weld grating to platform framing.

2.08 STAIR RAILINGS: Refer to Section 05 52 10, "Pipe and Tube Railings"

2.09 FINISHES

A. Finish metal stairs after assembly.

B. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.
2. Fill vent and drain holes that are exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.

C. Preparation for Shop Priming: as indicated by Section 09 90 00, "Painting and Coating"

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

3.01 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. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.

3.02 INSTALLING METAL STAIRS WITH GROUTED BASEPLATES

A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of baseplates.

B. Set steel-stair baseplates on wedges, shims, or leveling nuts. After stairs have been positioned and aligned, tighten anchor bolts. Do not remove wedges or shims, but if protruding, cut off flush with edge of bearing plate before packing with grout.

1. Use nonmetallic, nonshrink grout unless otherwise indicated.
2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.03 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 same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in as indicated by Section 09 90 00, “Painting and Coating”

C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

END OF SECTION

SECTION 05 52 10
PIPE AND TUBE RAILINGS

PART 1 - GENERAL

1.01 SUMMARY

A. Section includes the following:

1. Aluminum pipe and tube handrails and railing systems.
2. FRP handrails and railing system.
3. Aluminum ladders, safety cages, and safety devices.

B. Related Documents: Drawings and general provisions of Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to work of this Section.

1.02 DEFINITIONS

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

1.03 SYSTEM PERFORMANCE REQUIREMENTS

A. In engineering handrail and railing systems to withstand structural loads indicated, determine allowable design working stresses of railing materials based on the following:

1. Aluminum: AA Specifications for Aluminum Structures. Fabricate all pipe railings and handrails from 1-1/2-inch aluminum pipe using not less than Schedule 40 for all rails and Schedule 80 for all posts. Posts and handrail brackets shall not be spaced over 5 feet apart unless specifically called for otherwise.
2. FRP: ASTM F 1092 standard specification for fiberglass pultruded, open-weather storm and guard square handrails for materials and fabrication methods. Fabricate all railings from 2-inch square by 2-inch FRP tubes. Posts and handrail brackets shall not be spaced more than 5 feet apart unless specifically called for otherwise.

1.04 SUBMITTALS

A. Shop Drawings: Submit in accordance with Section 01 33 00, Submittal Procedures covering the items included under this Section. Shop Drawing submittals shall include:

1. Drawings showing fabrication and installation of handrails and railings, including plans, elevations, sections, details of components, and attachments to other units of Work.
2. Where installed products are indicated to comply with certain design loadings, include structural computations, material properties, and other information needed for structural analysis that has been signed and sealed by a qualified Professional Engineer, licensed in the state of Alabama, responsible for their preparation.
3. Product Data for each type of product specified.
4. Samples for verification purposes of each type of exposed finish required, prepared on components indicated below that are of the same thickness and metal indicated for final unit of Work. Where finishes involve normal color and texture variations, include sample sets showing full range of variations expected.
    a. 6-inch-long sections of each distinctly different linear railing member including handrails, top rails, posts, balusters, and ladder rungs.
    b. Fittings and brackets.
    c. Welded connections.

B. Product Test Reports:

1. Based on tests performed by qualified independent testing laboratory evidencing compliance of railing components and systems with requirements based on comprehensive testing of current products.

C. Quality Assurance Submittals:

1. Qualification data for firms and persons specified in Quality Assurance Article to demonstrate their capabilities and experience. Include list of completed projects with project names, addresses, names of Engineers and Owners, plus other information specified.

1.05 QUALITY ASSURANCE

A. Single Source Responsibility: Obtain handrails and railing systems of each type and material from a single manufacturer.

B. Engineering Responsibility: Engineer handrails and railing systems by qualified Professional Engineer legally authorized to practice in jurisdiction where Project is located.

1.06 STORAGE

A. Store handrails and railing systems in clean, dry location, away from uncured concrete and masonry, protected against damage of any kind. Cover with waterproof paper, tarpaulin, or polyethylene sheeting; allow for air circulation inside the covering.

1.07 PROJECT CONDITIONS

A. Field Measurements: Where handrails and railings are indicated to fit to other construction, check actual dimensions of other construction 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 Work, warranty dimensions and proceed with fabrication of products without field measurements. Coordinate other construction to ensure that actual dimensions correspond to warranted dimensions.

1.08 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.
2. Mount handrails only on gypsum board assemblies reinforced to receive anchors and where the location of concealed anchor plates has been clearly marked for benefit of Installer.

PART 2 - PRODUCTS

2.01 MANUFACTURERS

A. Subject to compliance with specified requirements, manufacturers offering products which may be incorporated in Work include:

1. Aluminum Pipe and Tube Railing Systems:
   a. Blum, Julius Blum and Co., Inc.
   b. Braun, J.G. Braun Co.
   c. CraneVeyor Corp.
   d. Moultrie Manufacturing Co.

e. Newman Bros., Inc.
f. Sterling Factories, Inc.
g. Superior Aluminum Products, Inc.
h. Wagner, R&B Wagner, Inc.

2. FRP Railing System:
   a. Chemgrate Corp.
   b. Fibergrate Corp.
   c. IKG Industries.
   d. IMCO Reinforced Plastics, Inc.
   e. International Grating, Inc.

3. Nonshrink, Nonmetallic Grouts:
   a. "Bonsal Construction Grout," W.R. Bonsal Co.
   b. "Kemset," Chem-Masters Corp.
   c. "Diamond-Crete Grout," Concrete Service Materials Co.
   d. "Sure-Grip High-Performance Grout," Dayton Superior Corp.
   e. "Crystex," L&M Construction Chemicals, Inc.
   f. "Vibropruf No. 11," Lambert Corp.
   g. "Masterflow 713," Master Builders.
   h. "Sealtight 588 Grout," W.R. Meadows, Inc.
   i. "Sonogrout," Sonneborn Building Products Division, ChemRex, Inc.
   j. "Stoncrete NM1," Stonhard, Inc.
   k. "Five Star Grout," U.S. Grout Corp.

4. Erosion-Resistant Anchoring Cement:
   a. "Super Por-Rok," Minwax Construction Products Division.

2.02 METALS

A. Provide metal forms and types that comply with requirements of referenced standards and that are free from surface blemishes where exposed to view in the finished unit. Exposed-to-view surfaces exhibiting pitting, seam marks, roller marks, stains, discolorations, or other imperfections on finished units are not acceptable.Aluminum: Alloy and temper recommended by aluminum producer and finisher for type of use and finish indicated, with not less than the strength and durability properties of the alloy and temper designated below for each aluminum form required:

1. Extruded Bar and Tube: ASTM B 221, Alloy 6063T5/T52.
2. Extruded Structural Pipe & Tube: ASTM B 429, 6063-T5/T52.
3. Drawn Seamless Tube: ASTM B 210, 6063-T832.
4. Plate and Sheet: ASTM B 209, 6061-T6.
5. Die and Hand Forgings: ASTM B 247, 6061-T6.
6. Castings: ASTM B 26, A356-T6.

B. Brackets, Flanges, and Anchors: Cast or formed metal of the same type material and finish as supported rails, unless otherwise indicated.

2.03 FRP TUBE RAILING COMPONENTS

A. FRP Railing Components: Manufacturer's Standard 42 inches high, 3-rail (Type 1F) pultruded 2-inch FRP system with solid FRP bar or laminated FRP sheet, internal reinforced, adhesively adhered and riveted at all joints. Railing shall comply with ASTM F 1092-87 standard specification for FRP pultruded open weather storm and guard square handrails.

B. FRP resin shall be an integrally colored, corrosion resistant, fire resistant pultruded type premium grade, isophthalic polyester or vinylester. Vinylester shall be used in all areas where FRP may come in contact with the following chemicals:

1. Caustic: Sodium Hydroxide (NaOH).
2. Fluorosilicic Acid (H_2SF_6).
3. Chlorinated gas or water.
4. Sodium Hypochlorite (NaOCl).
5. Sulfuric Acid (less than 30 percent concentrations).

C. Shop Drawings shall indicate resin type and location.

D. FRP Pultruded Square Tube shall be 2 by 1/4 inch (51 by 6.4 mm) with the outside corner radius 3/32 inch (2.4 mm). A synthetic surface veil shall be the outermost layer of reinforcement covering the entire exterior surface. The resin used throughout the part shall be either flame retardant isophthalic polyester, or flame retardant vinylester resin containing an ultraviolet (UV) radiation inhibitor. The FRP pultruded square tube shall achieve a 25 or less rating in accordance with Test Method E 84. The exterior of the pultruded square tubing shall have a 1 mil (0.025 mm) minimum polyurethane protective coating for added UV protection. The FRP pultruded square tubing shall meet the properties specified in Section 06 61 00, and dimensional tolerances shall be in accordance with Specification D 3917.

E. FRP sheet or solid FRP bar shall be used to fabricate the internal connectors of the square tube. The internal connectors will be 1-1/2 by 1-1/2-inch (38.1 by 38.1 mm) with length and angularity variable to meet the requirements of each connection. Angular connections shall be fabricated from fiberglass sheet bonded together using a bisphenol A/epichlorohydrin epoxy resin with an amine curing agent to give a minimum thickness of 1-1/2 inches. The angular connections will be fabricated to the proper dimension from the fiberglass sheets that have been bonded together.

1. Fiberglass sheet used for angular connections shall meet the properties specified in Section 06 61 00.
2. Fiberglass solid bar, 1-1/2 by 1-1/2-inch, shall be used for the straight connections and shall meet the properties specified in Section 06 61 00.

F. Rivets shall be nickel copper or nonmetallic.

G. Bolts shall be 3/8 inch (9.5 mm) diameter, Type 316 stainless steel.

H. Adhesive used to bond internal connectors to fiberglass pultruded square tube shall be a bisphenol A/epichlorohydrin epoxy resin with an amine-curing agent.

2.04 GROUT AND ANCHORING CEMENT

A. Nonshrink, Nonmetallic Grout: Pre-mixed, 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. Interior Anchoring Cement: Factory pre-packaged, nonshrink, nonstaining, hydraulic controlled expansion cement formulation for mixing with water at Site to create pourable anchoring, patching, and grouting compound. Use for interior applications only.

C. Erosion Resistant Anchoring Cement: Factory pre-packaged, nonshrink, nonstaining, hydraulic controlled expansion cement formulation for mixing with water at Site to create pourable anchoring, patching, and grouting compound. Provide formulation that is resistant to erosion from water exposure without need for protection by a sealer or waterproof coating and is recommended for exterior use by manufacturer.

2.05 LADDER

A. Fabricate ladders for locations shown, with dimensions, spacings, materials, details, and anchorages as indicated on Drawings. Comply with requirements of ANSI A14.3 and OSHA regulations.

B. Fixed Wall Ladders: Extruded aluminum; serrated rungs 1-1/8 inches (29 mm) in diameter, connected to side rail channels with cast aluminum rung connectors, each secured to rails by means of four solid aircraft rivets.

1. Capacity: 500 lbs (225 kg).
2. 24" Wide.

2.06 LADDER SAFETY DEVICES

A. Ladder climbing safety devices shall be provided for ladder lengths of 20 feet or greater. Certification that the equipment meets the requirements of Federal specifications, in lieu of testing as provided in the Federal specification, shall be submitted. Material of carrier rail and ladder rung clamps shall match ladder material. Ladder safety climbing device shall be SAF-T-CLIMB as manufactured by North Safety Products or approved equal. Provide 2 ladder safety harnesses to OWNER for use with device.

2.08 WELDING MATERIALS, FASTENERS, AND ANCHORS

A. Welding Electrodes and Filler Metal: Provide type and alloy of filler metal and electrodes as recommended by producer of metal to be welded and as required for color match, strength, and compatibility in fabricated items.

B. Fasteners for Anchoring Railings to other Construction: Select fasteners of the type, grade, and class required to produce connections that are suitable for anchoring railing to other types of construction indicated and capable of withstanding design loadings.

1. For aluminum railings provide fasteners fabricated from Type 304 stainless steel.

C. Fasteners for Interconnecting Railing Components: Use fasteners of same basic metal as the fastened metal, unless otherwise indicated. Do not use metals that are corrosive or incompatible with materials joined.

1. Provide concealed fasteners for interconnection of handrail and railing components and for their attachment to other work, except where exposed fasteners are unavoidable or are the standard fastening method for handrail and railing system indicated.

D. Cast-In-Place and Post-Installed Anchors in Concrete: Anchors of type indicated below, fabricated from corrosion-resistant materials with capability to sustain, without failure, load imposed within a safety factor of 4 as determined by testing per ASTM E 488, conducted by a qualified independent testing laboratory.

1. Cast-in-place anchors.
2. Chemical anchors.
3. Expansion anchors.

2.09 FABRICATION

A. Fabricate ladders for the locations shown, with dimensions, spacings, details, and anchorages as indicated on Drawings. Comply with requirements of ANSI A14.3.

1. Provide nonslip 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.

B. Pre-assemble railing systems 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. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.

C. Welded Connections for Aluminum Pipe: Fabricate pipe handrails and railing systems for connection of members by concealed internal welds, which eliminate surface grinding, using manufacturer's standard system of sleeve and socket fittings.

D. Brackets, Flanges, Fittings, and Anchors: Provide manufacturer's standard wall brackets, flanges, miscellaneous fittings, and anchors for interconnection of handrail and railing members to other construction.

1. Provide inserts and other anchorage devices for connecting handrails and railing systems to concrete or masonry work. Fabricate anchorage devices capable of withstanding loadings imposed by handrails and railing systems. Coordinate anchorage devices with supporting structure.

E. For removable railing posts, fabricate slip-fit sockets from FRP fabrications for FRP posts and from steel pipe for steel posts 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.

1. Provide chain with eye, snap hook, and staple across gaps formed by removable railing sections at locations indicated. Fabricate from same metal as railings.

F. Shear and punch metals cleanly and accurately. Remove burrs from exposed cut edges.

G. 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.

H. Cut, reinforce, drill, and tap miscellaneous metal work as indicated to receive finish hardware, screws, and similar items.

I. For handrails and railing systems that are exposed to exterior or to moisture from condensation or other sources, provide weepholes or other means for evacuation of entrapped water in hollow sections of railing members.

J. Fabricate joints that will be exposed to weather in a manner to exclude water.

K. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated.

L. Toe Boards: Provide toe boards at railings around openings and at the edge of open-sided floors and platforms unless otherwise indicated. Fabricate to dimensions and details indicated for connection to, and centered between, each railing post.

M. 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 to produce adequate bearing to prevent bracket rotation and overstressing of substrate.

2.10 FINISHES

A. Comply with NAAMM Metal Finishes Manual for recommendations relative to application and designations of finishes.

B. Protect mechanical finishes on exposed surfaces from damage by application of strippable, temporary protective covering prior to shipment.

C. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are not acceptable if they are within 1/2 of the range of approved samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within range of approved samples and they are assembled or installed to minimize contrast.

D. Aluminum Finishes:

1. Finish designations prefixed by "AA" conform to the system established by the Aluminum Association for designating aluminum finishes.

2. Mechanical Finish: AA-M12 (Mechanical Finish: as fabricated, nonspecular).
3. Class I Clear Anodized Finish: AA-M12C22A41 (Mechanical Finish: as fabricated, nonspecular; Chemical Finish: etched, medium matte; Anodic Coating: Class I Architectural, clear film thicker than 0.7 mil) complying with AAMA 607.1.
4. Class I Color Anodized Finish: AA-M12C22A42/A44 (Mechanical Finish: as fabricated, nonspecular; Chemical Finish: etched, Medium Matte; Anodic Coating: Class I Architectural, film thicker than 0.7 mil with integral color or electrolytically deposited color) complying with AAMA 606.1 or AAMA 608.1.
5. Color:
    a. As selected by ENGINEER from within standard industry colors and color density range.

E. Galvanized Finish:

1. Hot-dip galvanize items indicated to be galvanized to comply with applicable standard listed below:
    a. ASTM A 153 for galvanizing iron and steel hardware.
    b. ASTM A 123 for galvanizing iron and steel products made from rolled, pressed, and forged steel shapes, castings, plates, bars, and strips.
2. For exterior steel railings and handrails formed from steel pipe with galvanized finish, galvanize fittings, brackets, fasteners, sleeves, and other ferrous components.
3. For interior steel railings and handrails formed from steel pipe with galvanized finish, galvanize fittings, brackets, fasteners, sleeves, and other ferrous components.
4. 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.
5. Factory-Primed Finish: Apply air-dried primer immediately following cleaning and pre-treatment, to provide a minimum dry film thickness of 2.0 mils per applied coat, to surfaces that will be exposed after assembly and installation and to concealed, nongalvanized surfaces.

PART 3 - EXECUTION

3.01 PREPARATION

A. Coordinate setting Drawings, diagrams, templates, instructions, and directions for installation of anchorages, such as sleeves, concrete inserts, anchor bolts, and

miscellaneous items having integral anchors, which are to be embedded in concrete as masonry construction. Coordinate delivery of such items to Site.

3.02 INSTALLATION

A. Fit exposed connections accurately together to form tight, hairline joints.

B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installation of handrails and railings. Set handrails and railings accurately in location, alignment, and elevation, measured from established lines and levels and free from rack.

1. Do not weld, cut, or abrade surfaces of handrails and railing components that have been coated or finished after fabrication and are intended for field connection by mechanical or other means without further cutting or fitting.
2. Set posts plumb within a tolerance of 1/4 inch in 12 feet.
3. Align rails so that variations from level for horizontal members and from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.

C. Field Welding: Comply with the following requirements:

1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
2. Obtain fusion without undercut or overlap.
3. Remove welding flux immediately.
4. At exposed connections, finish exposed welds and surfaces smooth and blended so that no roughness shows after finishing and contour of welded surface matches those adjacent.

D. Install FRP tube handrails and railing systems to comply with railing manufacturer's instructions and the following:

1. All cut edges and holes shall be sealed with a compatible resin system containing a UV inhibitor.
2. All connections shall be made using a one-piece solid internal connector (in accordance with "FRP Sheet or Solid FRP Bar," as described under FRP components, Part 2 of this Specification), bonded to the interior of the square tube using an epoxy adhesive, and riveted. The following types of connections are defined:
   a. All bolted connections shall have a one-piece solid internal connector (in accordance with "FRP Sheet or Solid FRP Bar," as described under FRP components, Part 2 of this Specification), bonded to the interior of the square tube through which connector

holes will be drilled. A minimum 1-inch (26 mm) length of the solid internal connector will be on each side of the drilled hole.

b. Additional solid internal connector pieces can be bonded with epoxy adhesive to the interior of the square tube as desired.

E. 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.

F. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing handrails and railings to in-place construction.

3.03 ANCHORING POSTS

A. Adjust handrails and railing systems prior to anchoring to ensure matching alignment at abutting joints. Space posts at interval indicated but not less than that required by design loadings.

B. Anchor posts to concrete with circular or rectangular flanges, floor or wall type, as required by conditions, connected to posts and secured to concrete with expansion anchors.

C. Anchor posts to metal surfaces with oval flanges, angle type or floor type, as required by conditions, connected to posts and to metal supporting members as follows:

1. For aluminum pipe railings, attach posts as indicated using manufacturer's standard fittings designed and engineered for this purpose.

3.04 RAILING CONNECTIONS

A. Expansion Joints: Install expansion joints at locations indicated but not further apart than required to accommodate thermal movement. Provide slip-joint internal sleeve extending 2 inches beyond joint on either side; fasten internal sleeve securely to one side; locate joint within 6 inches of post.

3.05 ANCHORING RAIL ENDS

A. Anchor rail ends into concrete and masonry with round flanges connected to rail ends and anchored into wall construction with post-installed anchors and bolts.

B. Anchor rail ends to metal surfaces with oval or round flanges.

1. Connect flanges to rail ends using nonwelded connections.
2. Bolt flanges to metal surfaces.

C. Install removable railing sections where indicated in slip-fit sockets of same material surface mounted to concrete. Accurately locate sockets to match post spacing.

3.06 ATTACHMENT OF HANDRAILS TO WALLS

A. Attach 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.

B. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads.

C. Secure wall brackets and wall return fittings to building construction as follows:

1. Use type of bracket with flange tapped for concealed anchorage to threaded hanger bolt.
2. Use type of bracket with pre-drilled hole for exposed bolt anchorage.
3. For concrete and solid masonry anchorage, use drilled-in expansion shield and either concealed hanger bolt or exposed lag bolt, as applicable.
4. For hollow masonry anchorage, use toggle bolts with square heads.
5. For wood stud partitions, use lag bolts set into wood backing between studs. Coordinate with stud installations for accurate location of backing members.
6. 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.

3.07 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.

B. Touch-Up Painting: Cleaning and touch-up painting of field welds, bolted connections, and abraded areas of shop paint are specified in Division 9 of these specifications.

C. For galvanized surfaces: Clean field welds, bolted connections, and abraded areas and apply galvanizing repair paint to comply with ASTM A 780.

D. Clean the following metals by washing thoroughly with clean water and soap, following by rinsing with clean water.

1. Aluminum.

3.08 PROTECTION

A. Restore finishes damaged during installation and construction period so that 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.

END OF SECTION

SECTION 05 53 13
BAR GRATINGS

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.02 SUMMARY

A. Section includes metal bar gratings and metal frames and supports for gratings.

B. Related Requirements:

1. Section 05 12 00 "Structural Steel Framing" for structural-steel framing system components.
2. Section 05 51 19 "Metal Grating Stairs" for grating treads and landings of steel-framed stairs.
3. Section 05 52 10 "Pipe and Tube Railings" for metal pipe and tube handrails and railings.

1.03 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible with one another.

B. Coordinate installation of anchorages for gratings, grating frames, and supports. 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.

1.04 ACTION SUBMITTALS

A. Product Data: For the following:

1. Clips and anchorage devices for gratings.
2. Paint products.

B. Shop Drawings: Include plans, sections, details, and attachments to other work.

C. Delegated-Design Submittal: For gratings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.05 INFORMATIONAL SUBMITTALS

A. Mill Certificates: Signed by manufacturers of stainless steel certifying that products furnished comply with requirements.

B. Welding certificates.

C. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.06 QUALITY ASSURANCE

A. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
2. AWS D1.2/D1.2M, "Structural Welding Code - Aluminum."

1.07 FIELD CONDITIONS

A. Field Measurements: Verify actual locations of walls and other construction contiguous with gratings by field measurements before fabrication.

PART 2 - PRODUCTS

2.01 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Alabama Metal Industries Corporation; a Gibraltar Industries company.
2. All American Grating.
3. BarnettBates Corporation.
4. Borden Metal Products (Canada) Limited.
5. Fisher & Ludlow; Division of Harris Steel Limited.
6. Grating Pacific, Inc.
7. Grupo Metelmex, S.A. de C.V.
8. IKG Industries; a division of Harsco Corporation.
9. Marwas Steel Co.; Laurel Steel Products Division.
10. Ohio Gratings, Inc.
11. Seidelhuber Metal Products; Division of Brodhead Steel Products.

2.02 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer to design gratings.

B. Structural Performance: Gratings shall withstand the minimum effects of gravity loads and the following loads and stresses within limits and under conditions indicated or as required on the structural drawings:

1. Floors: Uniform load of 125 lbf/sq. ft. (6.00 kN/sq. m) or concentrated load of 2000 lbf (8.90 kN), whichever produces the greater stress.
2. Floors: Uniform load of 250 lbf/sq. ft. (11.97 kN/sq. m) or concentrated load of 3000 lbf (13.40 kN), whichever produces the greater stress.
3. Walkways and Elevated Platforms Other Than Exits: Uniform load of 60 lbf/sq. ft. (2.87 kN/sq. m).
4. Walkways and Elevated Platforms Used as Exits: Uniform load of 100 lbf/sq. ft. (4.79 kN/sq. m).
5. Sidewalks and Vehicular Driveways, Subject to Trucking: Uniform load of 250 lbf/sq. ft. (11.97 kN/sq. m) or concentrated load of 8000 lbf (35.60 kN), whichever produces the greater stress.
6. Limit deflection to L/360 or 1/4 inch (6.4 mm), whichever is less.

C. Seismic Performance: Gratings shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.

1. Component Importance Factor: 1.5.

2.03 METAL BAR GRATINGS

A. Metal Bar Grating Standards: Comply with NAAMM MBG 531, "Metal Bar Grating Manual

B. Welded Steel Grating:

1. Bearing Bar Spacing: as required to comply with the structural requirements.
2. Bearing Bar Depth: as indicated on the structural drawings.
3. Bearing Bar Thickness: as required to comply with the structural requirements.
4. Crossbar Spacing: 4 inches (102 mm) o.c.
5. Traffic Surface: Applied abrasive finish consisting of aluminum-oxide aggregate in an epoxy-resin adhesive.
6. Steel Finish: Hot-dip galvanized with a coating weight of not less than 1.8 oz./sq. ft. (550 g/sq. m) of coated surface.

C. Pressure-Locked, Rectangular Bar Aluminum Grating: Fabricated by pressing rectangular flush-top crossbars into slotted bearing bars or swaging crossbars between bearing bars.

1. Bearing Bar Spacing: as required to comply with structural performance.
2. Bearing Bar Depth: as indicated on the drawings.

3. Bearing Bar Thickness: As required to comply with structural performance requirements.
4. Crossbar Spacing: 4 inches o.c.
5. Traffic Surface: Applied abrasive finish consisting of aluminum-oxide aggregate in an epoxy-resin adhesive .
6. Aluminum Finish: Class I, clear, anodized finish.

2.04 FERROUS METALS

A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

B. Steel Bars for Bar Gratings: ASTM A 36/A 36M or steel strip, ASTM A 1011/A 1011M or ASTM A 1018/A 1018M.

C. Wire Rod for Bar Grating Crossbars: ASTM A 510 (ASTM A 510M).

D. Galvanized-Steel Sheet: ASTM A 653/A 653M, structural quality, Grade 33 (Grade 230), with G90 (Z275) coating.

2.05 ALUMINUM

A. General: Provide alloy and temper recommended by aluminum producer for type of use indicated, with not less than the strength and durability properties of alloy, and temper designated below for each aluminum form required.

B. Extruded Bars and Shapes: ASTM B 221 (ASTM B 221M), alloys as follows:

1. 6061-T6 or 6063-T6, for bearing bars of gratings and shapes.
2. 6061-T1, for grating crossbars.

C. Aluminum Sheet: ASTM B 209 (ASTM B 209M), Alloy 5052-H32.

2.06 FASTENERS

A. General: Unless otherwise indicated, provide Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.

1. Provide stainless-steel fasteners for fastening aluminum.
2. Provide stainless-steel fasteners for fastening stainless steel.

B. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, nuts, and, where indicated, flat washers; ASTM F 593 (ASTM F 738M) for bolts and ASTM F 594 (ASTM F 836M) for nuts.

C. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563 (ASTM A 563M,) and, where indicated, flat washers.

1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.

D. Post-Installed Anchors: Torque-controlled expansion or chemical anchors capable of sustaining, 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/E 488M, conducted by a qualified independent testing agency.

1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.
2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

2.07 MISCELLANEOUS MATERIALS

A. Shop Primers: Provide primers that comply with Section 09 90 00 "Painting and Coating"

B. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

2.08 FABRICATION

A. Shop Assembly: Fabricate grating sections 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. Cut, drill, and punch material cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch (1 mm) unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.

C. Form from materials of size, thickness, and shapes indicated, but not less than that needed to support indicated loads.

D. Fit exposed connections accurately together to form hairline joints.

E. Welding: 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.

F. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space the anchoring devices to secure gratings, frames, and supports rigidly in place and to support indicated loads.

1. Fabricate toeplates to fit grating units and weld to units in shop unless otherwise indicated.

2. Fabricate toeplates for attaching in the field.

3. Toeplate Height: 4 inches (100 mm) unless otherwise indicated.

G. Removable Grating Sections: Fabricate with banding bars attached by welding to entire perimeter of each section. Include anchors and fasteners of type indicated or, if not indicated, as recommended by manufacturer for attaching to supports.

1. Provide no fewer than four weld lugs for each heavy-duty grating section, with each lug shop welded to two bearing bars.
2. Provide no fewer than four saddle clips for each grating section containing rectangular bearing bars 3/16 inch (4.8 mm) or less in thickness and spaced 15/16 inch (24 mm) or more o.c., with each clip designed and fabricated to fit over two bearing bars.
3. Provide no fewer than four weld lugs for each grating section containing rectangular bearing bars 3/16 inch (4.8 mm) or less in thickness and spaced less than 15/16 inch (24 mm) o.c., with each lug shop welded to three or more bearing bars. Interrupt intermediate bearing bars as necessary for fasteners securing grating to supports.
4. Provide no fewer than four flange blocks for each section of aluminum I-bar grating, with block designed to fit over lower flange of I-shaped bearing bars.
5. Furnish threaded bolts with nuts and washers for securing grating to supports.
6. Furnish self-drilling fasteners with washers for securing grating to supports.
7. Furnish galvanized malleable-iron flange clamp with galvanized bolt for securing grating to supports. Furnish as a system designed to be installed from above grating by one person.
    1) Kee Industrial Products, Inc.; Grating Clip.
    2) Lindapter North America, Inc.; Grate-Fast.

H. Fabricate cutouts in grating sections for penetrations indicated. Arrange cutouts to permit grating removal without disturbing items penetrating gratings.

1. Edge-band openings in grating that interrupt four or more bearing bars with bars of same size and material as bearing bars.

I. Do not notch bearing bars at supports to maintain elevation.

2.09 GRATING FRAMES AND SUPPORTS

A. Fabricate from metal shapes, plates, and bars of welded construction to sizes, shapes, and profiles indicated and as necessary to receive gratings. Miter and weld connections for perimeter angle frames. Cut, drill, and tap units to receive hardware and similar items.

1. Unless otherwise indicated, fabricate from same basic metal as gratings.
2. Equip units indicated to be cast into concrete or built into masonry with integrally welded anchors. Unless otherwise indicated, space anchors 24 inches (600 mm) o.c. and provide minimum anchor units in the form of steel straps 1-1/4 inches (32 mm) wide by 1/4 inch (6 mm) thick by 8 inches (200 mm) long.

B. Galvanize steel frames and supports in the following locations:

1. Exterior.
2. Interior, where indicated.

2.10 ALUMINUM FINISHES

A. Clear Anodic Finish: AAMA 611, AA-M12C22A41, Class I.

2.11 STEEL FINISHES

A. Finish gratings, frames, and supports after assembly.

B. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.

C. Shop prime gratings, frames, and supports not indicated to be galvanized unless otherwise indicated.

PART 3 - EXECUTION

3.01 INSTALLATION, GENERAL

A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing gratings 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 gratings. Set units accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.

C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete or masonry.

D. Fit exposed connections accurately together to form hairline joints.

1. 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 that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.

E. Attach toeplates to gratings by welding at locations indicated.

F. Field Welding: 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.

G. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals, with a heavy coat of bituminous paint.

3.02 INSTALLING METAL BAR GRATINGS

A. General: Install gratings to comply with recommendations of referenced metal bar grating standards that apply to grating types and bar sizes indicated, including installation clearances and standard anchoring details.

B. Attach 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. Attach nonremovable units to supporting members by welding where both materials are same; otherwise, fasten by bolting as indicated above.

3.03 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 same material as used for shop painting to comply with SSPC-PA 1 requirements for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in 09 90 00 "Painting and Coating".

C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

END OF SECTION