

SECTION 051200 - STRUCTURAL STEEL FRAMING

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. This Section includes the following:

1. Structural steel.
2. Architecturally exposed structural steel.
3. Prefabricated building columns.
4. Grout.

- B. Related Sections include the following:

1. Division 01 Section "Quality Requirements" for independent testing agency procedures and administrative requirements.
2. Division 05 Section "Steel Decking" for field installation of shear connectors.
3. Division 05 Section "Metal Fabrications" for and other metal items not defined as structural steel.
4. for surface preparation and priming requirements.
5. Division 13 Section "Metal Building Systems" for structural steel.

1.3 DEFINITIONS

- A. Structural Steel: Elements of structural-steel frame, as classified by AISC's "Code of Standard Practice for Steel Buildings and Bridges," that support design loads.
- B. Architecturally Exposed Structural Steel: Structural steel designated as architecturally exposed structural steel in the Contract Documents.

1.4 PERFORMANCE REQUIREMENTS

- A. Connections: Provide details of simple shear connections required by the Contract Documents to be selected or completed by structural-steel fabricator to withstand ASD-service loads indicated and comply with other information and restrictions indicated.
1. Select and complete connections using schematic details indicated and AISC's "Manual of Steel Construction, Load and Resistance Factor Design," Volume 2, Part 9.
 2. Engineering Responsibility: Fabricator's responsibilities include using a qualified professional engineer to prepare structural analysis data for structural-steel connections.

B. Construction: Type FR, fully restrained.

C. Construction: Type 1, rigid frame.

1.5 SUBMITTALS

A. Product Data: For each type of product indicated.

B. LEED Submittal:

1. Product Data for Credit MR 4.1: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content.
 - a. Include statement indicating costs for each product having recycled content.

C. 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.
4. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical high-strength bolted connections.
5. For structural-steel connections indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

D. Welding certificates.

E. Qualification Data: For Installer fabricator and testing agency.

F. Mill Test Reports: Signed by manufacturers certifying that the following products comply with requirements:

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

G. Source quality-control test reports.

1.6 QUALITY ASSURANCE

A. Shop-Painting Applicators: Qualified according to AISC's Sophisticated Paint Endorsement or SSPC-QP 3, "Standard Procedure for Evaluating Qualifications of Shop Painting Applicators."

- B. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel."
- C. Comply with applicable provisions of the following specifications and documents:
1. AISC's "Code of Standard Practice for Steel Buildings and Bridges."
 2. AISC's "Seismic Provisions for Structural Steel Buildings" and "Supplement No. 2."
 3. AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design."
 4. AISC's "Specification for the Design of Steel Hollow Structural Sections."
 5. AISC's "Specification for Allowable Stress Design of Single-Angle Members."
 6. RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- D. Mockups: Build mockups of architecturally exposed structural steel to set quality standards for fabrication and installation.
1. Coordinate finish painting requirements with Division 09 painting Sections.
 2. Approved mockups may become part of the completed Work if undisturbed at time of Substantial Completion.
- E. Preinstallation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 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 erosion and deterioration.
1. Store fasteners in a protected place. Clean and relubricate bolts and nuts that become dry or rusty before use.
 2. 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.

1.8 COORDINATION

- A. Furnish 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.

PART 2 - PRODUCTS

2.1 STRUCTURAL-STEEL MATERIALS

- A. Recycled Content of Steel Products: Provide products with an average recycled content of steel products so postconsumer recycled content plus one-half of preconsumer recycled content is not less than 25 percent.
- B. Recycled Content of Steel Products: Provide products with an average recycled content of steel products so postconsumer recycled content plus one-half of preconsumer recycled content is not less than the following:
1. W-Shapes: 60 percent.
 2. Channels, Angles-Shapes: 60 percent.
 3. Plate and Bar: 25 percent.
 4. Cold-Formed Hollow Structural Sections: 25 percent.
 5. Steel Pipe: 25 percent.
 6. All Other Steel Materials: 25 percent.
- C. W-Shapes: ASTM A 529/A 529M, Grade 50 (345).
- D. Channels, Angles-Shapes: ASTM A 529/A 529M, Grade 50.
- E. Plate and Bar: ASTM A 529/A 529M, Grade 50.
- F. Corrosion-Resisting Structural Steel: ASTM A 588/A 588M, Grade 50.
- G. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B, structural tubing.
- H. Corrosion-Resisting Cold-Formed Hollow Structural Sections: ASTM A 847, structural tubing.
- I. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
1. Weight Class: Standard.
 2. Finish: Black, except where indicated to be galvanized.
- J. Medium-Strength Steel Castings: ASTM A 27/A 27M, Grade 65-35, carbon steel.
- K. High-Strength Steel Castings: ASTM A 148/A 148M, Grade 80-50, carbon or alloy steel.
- L. Welding Electrodes: Comply with AWS requirements.

2.2 BOLTS, CONNECTORS, AND ANCHORS

- A. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy hex steel structural bolts; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers.
1. Finish: Plain.
 2. Direct-Tension Indicators: ASTM F 959, Type 325 compressible-washer type.

- a. Finish: Plain.
- B. High-Strength Bolts, Nuts, and Washers: ASTM A 490, Type 1, heavy hex steel structural bolts or tension-control, bolt-nut-washer assemblies with splined ends; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers, plain.
 - 1. Direct-Tension Indicators: ASTM F 959, Type 490, compressible-washer type, plain.
- C. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F 1852, Type 1, round head steel structural bolts with splined ends; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers.
 - 1. Finish: Plain.
- D. Shear Connectors: ASTM A 108, Grades 1015 through 1020, headed-stud type, cold-finished carbon steel; AWS D1.1, Type B.
- E. Unheaded Anchor Rods: ASTM A 307, Grade A.
 - 1. Configuration: Hooked.
 - 2. Nuts: ASTM A 563 heavy hex carbon steel.
 - 3. Plate Washers: ASTM A 36/A 36M carbon steel.
 - 4. Washers: ASTM F 436 hardened carbon steel.
 - 5. Finish: Plain.
- F. Headed Anchor Rods: ASTM A 307, Grade A, straight.
 - 1. Nuts: ASTM A 563 heavy hex carbon steel.
 - 2. Plate Washers: ASTM A 36/A 36M carbon steel.
 - 3. Washers: ASTM F 436 hardened carbon steel.
 - 4. Finish: Plain.
- G. Threaded Rods: ASTM A 307, Grade A.
 - 1. Nuts: ASTM A 563 heavy hex carbon steel.
 - 2. Washers: ASTM A 36/A 36M carbon steel.
 - 3. Finish: Plain.
- H. Turnbuckles: ASTM A 108, Grade 1035, cold-finished carbon steel.
- I. Eye Bolts and Nuts: ASTM A 108, Grade 1030, cold-finished carbon steel.
- J. Sleeve Nuts: ASTM A 108, Grade 1018, cold-finished carbon steel.

2.3 PRIMER

- A. Primer: SSPC-Paint 25, Type I, iron oxide, zinc oxide, raw linseed oil, and alkyd.
- B. Primer: SSPC-Paint 25 BCS, Type I, iron oxide, zinc oxide, raw linseed oil, and alkyd.

C. Primer: SSPC-Paint 23, latex primer.

D. Primer: Fabricator's standard lead- and chromate-free, nonasphaltic, rust-inhibiting primer.

2.4 GROUT

A. Cement Grout: Portland cement, ASTM C 150, Type I; and clean, natural sand, ASTM C 404, Size No. 2. Mix at ratio of 1 part cement to 2-1/2 parts sand, by volume, with minimum water required for placement and hydration.

B. Metallic, Shrinkage-Resistant Grout: ASTM C 1107, factory-packaged, metallic aggregate grout, mixed with water to consistency suitable for application and a 30-minute working time.

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

2.5 FABRICATION

A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design."

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

B. Architecturally Exposed Structural Steel: Comply with fabrication requirements, including tolerance limits, of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for structural steel identified as architecturally exposed structural steel.

1. Fabricate with exposed surfaces smooth, square, and free of surface blemishes including pitting, rust, scale, seam marks, roller marks, rolled trade names, and roughness.
2. Remove blemishes by filling or grinding or by welding and grinding, before cleaning, treating, and shop priming.

C. 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.

D. Bolt Holes: Cut, drill, mechanically thermal cut, or punch standard bolt holes perpendicular to metal surfaces.

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

- 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 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. Straighten as required to provide uniform, square, and true members in completed wall framing.
- H. Welded Door Frames: Build up welded door frames attached to structural steel. Weld exposed joints continuously and grind smooth. Plug-weld fixed steel bar stops to frames. Secure removable stops to frames with countersunk, cross-recessed head machine screws, uniformly spaced not more than 10 inches o.c., unless otherwise indicated.
- I. Holes: Provide holes required for securing other work to structural steel and for passage of other work through steel framing members.
 - 1. Cut, drill, or punch holes perpendicular to steel surfaces. Do not thermally cut bolt holes or enlarge holes by burning.
 - 2. Base-Plate 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.

2.6 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: Slip critical.
- B. Weld Connections: Comply with AWS D1.1 for welding procedure specifications, tolerances, appearance, and quality of welds and for methods used in correcting welding work.
 - 1. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 - 2. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.
 - 3. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Grind butt welds flush.
 - b. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

2.7 PREFABRICATED BUILDING COLUMNS

- A. General: Prefabricated building columns consisting of load-bearing structural-steel members encased in manufacturer's standard insulating concrete for fire protection and enclosed in an outer non-load-bearing steel shell.

- B. Column Configuration: Provide columns of sizes and shapes indicated. Fabricate connections to comply with details shown or as required to suit type of structure indicated.
- C. Available Manufacturers: Subject to compliance with requirements, manufacturers offering prefabricated building columns that may be incorporated into the Work include, but are not limited to, the following:
- D. Manufacturers: Subject to compliance with requirements, provide prefabricated building columns by one of the following:
 - 1. Black Rock Column, Inc.
 - 2. Dean, George H. Inc.
 - 3. Fire-Trol Division; Dean Lally L.P.

2.8 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.
 - 2. Surfaces to be field welded.
 - 3. Surfaces to be high-strength bolted with slip-critical connections.
 - 4. Surfaces to receive sprayed fire-resistive materials.
 - 5. Galvanized surfaces.
- B. Surface Preparation: Clean surfaces to be painted. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces according to the following specifications and standards:
 - 1. SSPC-SP 2, "Hand Tool Cleaning."
 - 2. SSPC-SP 3, "Power Tool Cleaning."
 - 3. SSPC-SP 5/NACE No. 1, "White Metal Blast Cleaning."
 - 4. SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 5. SSPC-SP 7/NACE No. 4, "Brush-Off Blast Cleaning."
 - 6. SSPC-SP 8, "Pickling."
 - 7. SSPC-SP 10/NACE No. 2, "Near-White Blast Cleaning."
 - 8. SSPC-SP 11, "Power Tool Cleaning to Bare Metal."
 - 9. SSPC-SP 14/NACE No. 8, "Industrial Blast Cleaning."
- C. Priming: Immediately after surface preparation, apply primer according to manufacturer's written instructions and at rate recommended by SSPC to provide a dry film thickness of not less than 1.5 mils. 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 inaccessible surfaces after assembly or erection. Change color of second coat to distinguish it from first.

- D. Painting: Apply a 1-coat, nonasphaltic primer complying with SSPC-PS Guide 7.00, "Painting System Guide 7.00: Guide for Selecting One-Coat Shop Painting Systems," to provide a dry film thickness of not less than 1.5 mils.

2.9 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 holes and grind smooth after galvanizing.
 - 2. Galvanize lintels attached to structural-steel frame and located in exterior walls.

2.10 SOURCE QUALITY CONTROL

- A. Owner will engage an independent testing and inspecting agency to perform shop tests and inspections and prepare test reports.
 - 1. Provide testing agency with access to places where structural-steel work is being fabricated or produced to perform tests and inspections.
- B. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.
- C. Bolted Connections: Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- D. Welded Connections: In addition to visual inspection, shop-welded connections will be tested and inspected according to AWS D1.1 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 will not be accepted.
 - 3. Ultrasonic Inspection: ASTM E 164.
 - 4. Radiographic Inspection: ASTM E 94.
- E. In addition to visual inspection, shop-welded shear connectors will be tested and inspected according to requirements in AWS D1.1 for stud welding and as follows:
 - 1. Bend tests will be performed if visual inspections reveal either a less-than- continuous 360-degree flash or welding repairs to any shear connector.
 - 2. Tests will be conducted on additional shear connectors if weld fracture occurs on shear connectors already tested, according to requirements in AWS D1.1.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Verify elevations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments, with steel erector present, for compliance with requirements.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 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.

3.3 ERECTION

- A. Set structural steel accurately in locations and to elevations indicated and according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design."
- B. Base and Bearing Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting base and bearing plates. Clean bottom surface of base and bearing plates.
 - 1. Set base and bearing plates for structural members on wedges, shims, or setting nuts as required.
 - 2. Weld plate washers to top of base plate.
 - 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 base or bearing plate before packing with grout.
 - 4. Promptly pack grout solidly between bearing surfaces and base or bearing 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's "Code of Standard Practice for Steel Buildings and Bridges."
- D. Align and adjust various members forming part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that will be 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. Remove erection bolts on welded, architecturally exposed structural steel; fill holes with plug welds; and grind smooth at exposed surfaces.
- G. Do not use thermal cutting during erection.
- H. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.
- I. 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 and manufacturer's written instructions.

3.4 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: Slip critical.
- B. Weld Connections: Comply with AWS D1.1 for welding procedure specifications, tolerances, appearance, and quality of welds and for methods used in correcting welding work.
 1. Comply with AISC's "Code of Standard Practice for Steel Buildings and Bridges" and "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design" for bearing, adequacy of temporary connections, alignment, 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 will maintain true alignment of axes without exceeding tolerances of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.
 4. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Grind butt welds flush.
 - b. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

3.5 PREFABRICATED BUILDING COLUMNS

- A. Install prefabricated building columns to comply with AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Plastic Design," manufacturer's written recommendations, and requirements of testing and inspecting agency that apply to the fire-resistance rating indicated.

3.6 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to inspect field welds and high-strength bolted connections.
- B. Bolted Connections: Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- C. Welded Connections: Field welds will be visually inspected according to AWS D1.1.
 - 1. In addition to visual inspection, field welds will be tested according to AWS D1.1 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 will not be accepted.
 - c. Ultrasonic Inspection: ASTM E 164.
 - d. Radiographic Inspection: ASTM E 94.
- D. In addition to visual inspection, test and inspect field-welded shear connectors according to requirements in AWS D1.1 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 on additional shear connectors if weld fracture occurs on shear connectors already tested, according to requirements in AWS D1.1.
- E. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

3.7 REPAIRS AND 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 and accessories, bearing plates, and abutting structural steel.
 - 1. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC-SP 3 power-tool cleaning.
 - 2. Apply a compatible primer of same type as shop primer used on adjacent surfaces.
- C. Touchup Painting: Cleaning and touchup painting are specified in Division 09 painting Sections.

END OF SECTION 051200

SECTION 054000 - COLD-FORMED METAL FRAMING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

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

1.2 SUMMARY

- A. This Section includes the following:

- 1. Exterior load-bearing wall framing.
- 2. Interior load-bearing wall framing.
- 3. Exterior non-load-bearing wall framing.
- 4. Floor joist framing.
- 5. Roof trusses.
- 6. Roof rafter framing.
- 7. Ceiling joist framing.

- B. Related Sections include the following:

- 1. Division 05 Section "Metal Fabrications" for masonry shelf angles and connections.
- 2. Division 09 Section "Non-Structural Metal Framing" for interior non-load-bearing, metal-stud framing and ceiling-suspension assemblies.
- 3. Division 09 Section "Gypsum Board Shaft Wall Assemblies" for interior non-load-bearing, metal-stud-framed, shaft-wall assemblies.

1.3 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide cold-formed metal framing capable of withstanding design loads within limits and under conditions indicated.

- 1. Design Loads: As follows:

- a. Dead Loads: Weights of materials and construction.
- b. Live Loads: 20 psf
- c. Roof Loads: 25 psf
- d. Snow Loads: 65 psf
- e. Wind Loads: 40 psf

- 2. Deflection Limits: Design framing systems to withstand design loads without deflections greater than the following:

- a. Exterior Load-Bearing Wall Framing: Horizontal deflection of 1/360 of the wall height.

- b. Interior Load-Bearing Wall Framing: Horizontal deflection of $1/360$ of the wall height under a horizontal load of 5 lbf/sq. ft. (239 Pa).
 - c. Exterior Non-Load-Bearing Framing: Horizontal deflection of $1/360$ $1/600$ $1/720$ Insert ratio of the wall height.
 - d. Floor Joist Framing: Vertical deflection of $1/480$ for live loads and $1/360$ for total loads of the span.
 - e. Roof Trusses: Vertical deflection of $1/360$ of the span.
 - f. Scissor Roof Trusses: Horizontal deflection of 1-1/4 inches (32 mm) at reactions.
 - g. Roof Rafter Framing: Horizontal deflection of $1/360$ of the horizontally projected span.
 - h. Ceiling Joist Framing: Vertical deflection of $1/360$ of the span.
- 3. Design framing systems to provide for movement of framing members without damage or overstressing, sheathing failure, connection failure, undue strain on fasteners and anchors, or other detrimental effects when subject to a maximum ambient temperature change of 120 deg F.
- 4. Design framing system to maintain clearances at openings, to allow for construction tolerances, and to accommodate live load deflection of primary building structure as follows:
 - a. Upward and downward movement of 1/2 inch.
- B. Cold-Formed Steel Framing, General: Design according to AISI's "Standard for Cold-Formed Steel Framing - General Provisions."
 - 1. Headers: Design according to AISI's "Standard for Cold-Formed Steel Framing - Header Design."
 - 2. Design exterior non-load-bearing wall framing to accommodate horizontal deflection without regard for contribution of sheathing materials.
 - 3. Roof Trusses: Design according to AISI's "Standard for Cold-Formed Steel Framing - Truss Design."

1.4 SUBMITTALS

- A. Product Data: For each type of cold-formed metal framing product and accessory indicated.
- B. LEED Submittal:
 - 1. Product Data for Credit MR 4.1 and Credit MR 4.2: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content.
 - a. Include statement indicating costs for each product having recycled content.
- C. Shop Drawings: Show layout, spacings, sizes, thicknesses, and types of cold-formed metal framing; fabrication; and fastening and anchorage details, including mechanical fasteners. Show reinforcing channels, opening framing, supplemental framing, strapping, bracing, bridging, splices, accessories, connection details, and attachment to adjoining work.

1. For cold-formed metal framing indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
- D. Welding certificates.
- E. Qualification Data: For testing agency.
- F. Product Test Reports: From a qualified testing agency, unless otherwise stated, indicating that each of the following complies with requirements, based on evaluation of comprehensive tests for current products:
 1. Steel sheet.
 2. Expansion anchors.
 3. Power-actuated anchors.
 4. Mechanical fasteners.
 5. Vertical deflection clips.
 6. Horizontal drift deflection clips
 7. Miscellaneous structural clips and accessories.
- G. Research/Evaluation Reports: For cold-formed metal framing.

1.5 QUALITY ASSURANCE

- A. Engineering Responsibility: Preparation of Shop Drawings, design calculations, and other structural data by a qualified professional engineer.
- B. Professional Engineer Qualifications: A professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for installations of cold-formed metal framing that are similar to those indicated for this Project in material, design, and extent.
- C. Testing Agency Qualifications: An independent testing agency, acceptable to authorities having jurisdiction, qualified according to ASTM E 329 to conduct the testing indicated.
- D. Product Tests: Mill certificates or data from a qualified independent testing agency indicating steel sheet complies with requirements, including base-metal thickness, yield strength, tensile strength, total elongation, chemical requirements, and metallic-coating thickness.
- E. Welding: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code--Steel," and AWS D1.3, "Structural Welding Code--Sheet Steel."
- F. Fire-Test-Response Characteristics: Where indicated, provide cold-formed metal framing identical to that of assemblies tested for fire resistance per ASTM E 119 by a testing and inspecting agency acceptable to authorities having jurisdiction.

- G. AISI Specifications and Standards: Comply with AISI's "North American Specification for the Design of Cold-Formed Steel Structural Members" and its "Standard for Cold-Formed Steel Framing - General Provisions."
 - 1. Comply with AISI's "Standard for Cold-Formed Steel Framing - Truss Design."
 - 2. Comply with AISI's "Standard for Cold-Formed Steel Framing - Header Design."
- H. Comply with AISI's "Standard for Cold-Formed Steel Framing - Prescriptive Method for One and Two Family Dwellings."
- I. Preinstallation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.6 DELIVERY, STORAGE, AND HANDLING

- A. Protect cold-formed metal framing from corrosion, deformation, and other damage during delivery, storage, and handling.
- B. Store cold-formed metal framing, protect with a waterproof covering, and ventilate to avoid condensation.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

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

16. Southeastern Stud & Components, Inc.
17. Steel Construction Systems.
18. Steeler, Inc.
19. Super Stud Building Products, Inc.
20. United Metal Products, Inc.

2.2 MATERIALS

- A. Recycled Content of Steel Products: Provide products with an average recycled content of steel products so postconsumer recycled content plus one-half of preconsumer recycled content is not less than 25 percent.
- B. Steel Sheet: ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of grade and coating weight as follows:
 1. Grade: As required by structural performance.
 2. Coating: G60, A60, AZ50, or GF30.
- C. Steel Sheet for drift Clips: ASTM A 653/A 653M, structural steel, zinc coated, of grade and coating as follows:
 1. Grade: As required by structural performance.
 2. Coating: G90.

2.3 LOAD-BEARING WALL FRAMING

- A. Steel Studs: Manufacturer's standard C-shaped steel studs, of web depths indicated, punched, with stiffened flanges, and as follows:
 1. Minimum Base-Metal Thickness: 0.0966 inch.
 2. Flange Width: 1-3/8 inches.
- B. Steel Track: Manufacturer's standard U-shaped steel track, of web depths indicated, unpunched, with straight flanges, and as follows:
 1. Minimum Base-Metal Thickness: Matching steel studs.
 2. Flange Width: 1-1/4 inches.
- C. Steel Box or Back-to-Back Headers: Manufacturer's standard C-shapes used to form header beams, of web depths indicated, punched, with stiffened flanges, and as follows:
 1. Minimum Base-Metal Thickness: 0.0966 inch.
 2. Flange Width: 1-3/8 inches.
- D. Steel Double-L Headers: Manufacturer's standard L-shapes used to form header beams, of web depths indicated, and as follows:
 1. Minimum Base-Metal Thickness: 0.0966 inch.
 2. Top Flange Width: 1-1/2 inches.

2.4 ROOF TRUSSES

- A. Roof Truss Members: Manufacturer's standard C-shaped steel sections, of web depths indicated, unpunched, with stiffened flanges.
1. Minimum Base-Metal Thickness: 0.0966 inch.
 2. Flange Width: 1-5/8 inches, minimum.

2.5 ROOF-RAFTER FRAMING

- A. Steel Rafters: Manufacturer's standard C-shaped steel sections, of web depths indicated, unpunched, with stiffened flanges, and as follows:
1. Minimum Base-Metal Thickness: 0.0966 inch.
 2. Flange Width: 1-5/8 inches, minimum.
- B. Built-up Members: Built-up members of manufacturer's standard C-shaped steel section, with stiffened flanges, nested into a U-shaped steel section joist track, with unstiffened flanges; unpunched; of web depths indicated; and as follows:
1. Minimum Base-Metal Thickness: Matching steel rafters.
 2. Flange Width: 1-5/8 inches, minimum.

2.6 CEILING JOIST FRAMING

- A. Steel Ceiling Joists: Manufacturer's standard C-shaped steel sections, of web depths indicated, punched with enlarged service holes, with stiffened flanges, and as follows:
1. Minimum Base-Metal Thickness: 0.0966 inch.
 2. Flange Width: 1-5/8 inches, minimum.

2.7 FRAMING ACCESSORIES

- A. Fabricate steel-framing accessories from steel sheet, ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of same grade and coating weight used for framing members.
- B. Provide accessories of manufacturer's standard thickness and configuration, unless otherwise indicated, as follows:
1. Supplementary framing.
 2. Bracing, bridging, and solid blocking.
 3. Web stiffeners.
 4. Anchor clips.
 5. End clips.
 6. Foundation clips.
 7. Gusset plates.
 8. Stud kickers, knee braces, and girts.

9. Joist hangers and end closures.
10. Hole reinforcing plates.
11. Backer plates.

2.8 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. Anchor Bolts: ASTM F 1554, Grade 36, threaded carbon-steel hex-headed bolts and carbon-steel nuts; and flat, hardened-steel washers; zinc coated by hot-dip process according to ASTM A 153/A 153M, Class C.
- C. Expansion Anchors: Fabricated from corrosion-resistant materials, with capability to sustain, without failure, a load equal to 5 times design load, as determined by testing per ASTM E 488 conducted by a qualified independent testing agency.
- D. Power-Actuated Anchors: Fastener system of type suitable for application indicated, fabricated from corrosion-resistant materials, with capability to sustain, without failure, a load equal to 10 times design load, as determined by testing per ASTM E 1190 conducted by a qualified independent testing agency.
- E. 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.
- F. Welding Electrodes: Comply with AWS standards.

2.9 MISCELLANEOUS MATERIALS

- A. Galvanizing Repair Paint: SSPC-Paint 20 or DOD-P-21035.
- B. Cement Grout: Portland cement, ASTM C 150, Type I; and clean, natural sand, ASTM C 404. Mix at ratio of 1 part cement to 2-1/2 parts sand, by volume, with minimum water required for placement and hydration.
- C. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, and plasticizing and water-reducing agents, complying with ASTM C 1107, with fluid consistency and 30-minute working time.
- D. Shims: Load bearing, high-density multimer plastic, nonleaching.
- E. Sealer Gaskets: Closed-cell neoprene foam, 1/4 inch thick, selected from manufacturer's standard widths to match width of bottom track or rim track members.

2.10 FABRICATION

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

PART 3 - EXECUTION

3.1 EXAMINATION

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

3.2 PREPARATION

- A. Before sprayed fire-resistive materials are applied, attach continuous angles, supplementary framing, or tracks to structural members indicated to receive sprayed fire-resistive materials.
- B. After applying sprayed fire-resistive materials, remove only as much of these materials as needed to complete installation of cold-formed framing without reducing thickness of fire-resistive materials below that are required to obtain fire-resistance rating indicated. Protect remaining fire-resistive materials from damage.

- C. Install load bearing shims or grout between the underside of wall bottom track or rim track and the top of foundation wall or slab at stud or joist locations to ensure a uniform bearing surface on supporting concrete or masonry construction.
- D. Install sealer gaskets to isolate the underside of wall bottom track or rim track and the top of foundation wall or slab at stud or joist locations.

3.3 INSTALLATION, GENERAL

- A. Cold-formed metal framing may be shop or field fabricated for installation, or it may be field assembled.
- B. Install cold-formed metal framing according to AISI's "Standard for Cold-Formed Steel Framing - General Provisions" and to manufacturer's written instructions unless more stringent requirements are indicated.
- C. Install shop- or field-fabricated, cold-formed framing and securely anchor to supporting structure.
 - 1. Screw, bolt, or weld wall panels at horizontal and vertical junctures to produce flush, even, true-to-line joints with maximum variation in plane and true position between fabricated panels not exceeding 1/16 inch.
- D. Install cold-formed metal framing and accessories plumb, square, and true to line, and with connections securely fastened.
 - 1. Cut framing members by sawing or shearing; do not torch cut.
 - 2. Fasten cold-formed metal framing members by welding, screw fastening, clinch fastening, or riveting. Wire tying of framing members is not permitted.
 - a. Comply with AWS D1.3 requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners and install according to Shop Drawings, and complying with requirements for spacing, edge distances, and screw penetration.
- E. Install framing members in one-piece lengths unless splice connections are indicated for track or tension members.
- F. Install temporary bracing and supports to secure framing and support loads comparable in intensity to those for which structure was designed. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to framing are secured.
- G. Do not bridge building expansion and control joints with cold-formed metal framing. Independently frame both sides of joints.
- H. Install insulation, specified in Division 07 Section "Thermal Insulation," in built-up exterior framing members, such as headers, sills, boxed joists, and multiple studs at openings, that are inaccessible on completion of framing work.

- I. Fasten hole reinforcing plate over web penetrations that exceed size of manufacturer's standard punched openings.
- J. Erection Tolerances: Install cold-formed metal framing level, plumb, and true to line to a maximum allowable tolerance variation of 1/8 inch in 10 feet and as follows:
 - 1. Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.

3.4 LOAD-BEARING WALL INSTALLATION

- A. Install continuous top and bottom tracks sized to match studs. Align tracks accurately and securely anchor at corners and ends, and at spacings as follows:
 - 1. Anchor Spacing: 24 inches or as shown on Shop Drawings.
- B. Squarely seat studs against top and bottom tracks with gap not exceeding of 1/8 inch between the end of wall framing member and the web of track. Fasten both flanges of studs to top and bottom tracks. Space studs as follows:
 - 1. Stud Spacing: As indicated on shop drawings.
- C. Set studs plumb, except as needed for diagonal bracing or required for nonplumb walls or warped surfaces and similar configurations.
- D. Align studs vertically where floor framing interrupts wall-framing continuity. Where studs cannot be aligned, continuously reinforce track to transfer loads.
- E. Align floor and roof framing over studs. Where framing cannot be aligned, continuously reinforce track to transfer loads.
- F. Anchor studs abutting structural columns or walls, including masonry walls, to supporting structure as indicated.
- G. Install headers over wall openings wider than stud spacing. Locate headers above openings as indicated. Fabricate headers of compound shapes indicated or required to transfer load to supporting studs, complete with clip-angle connectors, web stiffeners, or gusset plates.
 - 1. Frame wall openings with not less than a double stud at each jamb of frame as indicated on Shop Drawings. Fasten jamb members together to uniformly distribute loads.
 - 2. Install runner tracks and jack studs above and below wall openings. Anchor tracks to jamb studs with clip angles or by welding, and space jack studs same as full-height wall studs.
- H. Install supplementary framing, blocking, and bracing in stud framing indicated to support fixtures, equipment, services, casework, heavy trim, furnishings, and similar work requiring attachment to framing.
 - 1. If type of supplementary support is not indicated, comply with stud manufacturer's written recommendations and industry standards in each case, considering weight or load resulting from item supported.

- I. Install horizontal bridging in stud system, spaced as indicated on Shop Drawings. Fasten at each stud intersection.
 - 1. Bridging: Cold-rolled steel channel, welded or mechanically fastened to webs of punched studs with a minimum of 2 screws into each flange of the clip angle for framing members up to 6 inches deep.
 - 2. Bridging: Combination of flat, taut, steel sheet straps of width and thickness indicated and stud-track solid blocking of width and thickness to match studs. Fasten flat straps to stud flanges and secure solid blocking to stud webs or flanges.
 - 3. Bridging: Proprietary bridging bars installed according to manufacturer's written instructions.
- J. Install steel sheet diagonal bracing straps to both stud flanges, terminate at and fasten to reinforced top and bottom tracks. Fasten clip-angle connectors to multiple studs at ends of bracing and anchor to structure.
- K. Install miscellaneous framing and connections, including supplementary framing, web stiffeners, clip angles, continuous angles, anchors, and fasteners, to provide a complete and stable wall-framing system.

3.5 EXTERIOR NON-LOAD-BEARING WALL INSTALLATION

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

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

3.6 TRUSS INSTALLATION

- A. Install, bridge, and brace trusses according to Shop Drawings and requirements in this Section.
- B. Truss Spacing: As indicated on shop drawings.
- C. Do not alter, cut, or remove framing members or connections of trusses.
- D. Erect trusses with plane of truss webs plumb and parallel to each other, align, and accurately position at spacings indicated.
- E. Erect trusses without damaging framing members or connections.
- F. 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.
- G. Install continuous bridging and permanently brace trusses as indicated on Shop Drawings and designed according to LGSEA's Technical Note 551e, "Design Guide for Permanent Bracing of Cold-Formed Steel Trusses."

3.7 FIELD QUALITY CONTROL

- A. Testing: Owner will engage a qualified independent testing and inspecting agency to perform field tests and inspections and prepare test reports.
- B. Field and shop welds will be subject to testing and inspecting.
- C. Testing agency will report test results promptly and in writing to Contractor and Architect.
- D. Remove and replace work where test results indicate that it does not comply with specified requirements.
- E. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of replaced or additional work with specified requirements.

3.8 REPAIRS AND PROTECTION

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

END OF SECTION 054000

SECTION 055000: METAL FABRICATIONS**PART 1: GENERAL****1.1 SUMMARY**

- A. This Section includes the following:
 - 1. Miscellaneous steel framing and supports.
 - 2. Loose steel lintels.
- B. See Division 5 Section "Pipe Railings" for metal pipe railings and guards.

1.2 SUBMITTALS

- A. Shop Drawings: Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
- B. Templates: For anchors and bolts.

PART 2: PRODUCTS**2.1 MANUFACTURERS**

- A. In other Part 2 articles where titles below introduce lists, the following requirements apply to product selection:
 - 1. Available Products: Subject to compliance with requirements, products that may be incorporated into the Work include, but are not limited to, products specified.
 - 2. Products: Subject to compliance with requirements, provide one of the products specified.
 - 3. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, manufacturers specified.
 - 4. Manufacturers: Subject to compliance with requirements, provide products by one of the manufacturers specified.

2.2 METALS

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces without blemishes.
- B. Ferrous Metals:
 - 1. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
 - 2. Channels, Angles, M, S-Shapes: ASTM A 36/A 36M.
 - 3. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.

- C. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C.

2.3 FASTENERS

- A. General: Hot-dip zinc coated fasteners, at exterior walls and exterior use

2.4 MISCELLANEOUS MATERIALS

- A. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI #79.
- B. Galvanizing Repair Paint: SSPC-Paint 20, high-zinc-dust-content paint for reglazing welds in steel.
- C. Non-shrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107.
- D. Concrete Materials and Properties: Comply with requirements in Division 3 Section "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3500 psi, unless otherwise indicated.

2.5 FABRICATION

- A. General: Preassemble items in the shop to greatest extent possible. Use connections that maintain structural value of joined pieces.
 - 1. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges. Remove sharp or rough areas on exposed surfaces.
 - 2. Weld corners and seams continuously. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals. Obtain fusion without undercut or overlap. Remove welding flux immediately. Finish exposed welds smooth and blended.
 - 3. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, not less than 24 inches o.c.
- B. Miscellaneous Framing and Supports: Provide steel framing and supports not specified in other Sections as needed to complete the Work. Fabricate units from steel shapes, plates, and bars of welded construction. Cut, drill, and tap units to receive hardware, hangers, and similar items.
- C. Loose Steel Lintels: Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.
 - 1. Lintels in Exterior Walls: Hot-dip galvanizes.

2.6 FINISHES

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes. Finish metal fabrications after assembly.
- B. Steel and Iron Finishes:
 - 1. Hot-dip galvanize items as indicated to comply with ASTM A 123/A 123M or ASTM A 153/A 153M as applicable.
 - 2. Shop Priming: Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finishes to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting," for shop painting.

PART 3: EXECUTION

3.1 INSTALLATION

- A. General: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, with edges and surfaces level, plumb, and true.
 - 1. Fit exposed connections accurately together. Weld connections that are not to be left as exposed joints but cannot be shop welded. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication.
 - 2. Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction.
- B. Touch up surfaces and finishes after erection.
 - 1. Painted Surfaces: Clean field welds, bolted connections, and abraded areas and touch up paint with the same material as used for shop painting.
 - 2. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION

SECTION 055100 - METAL STAIRS**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. Preassembled steel stairs with abrasive-coating-finished formed-metal treads. All tread finishes by Contractor.
- 2. Industrial-type stairs with steel grating treads.
- 3. Steel tube railings attached to metal stairs.
- 4. Steel tube handrails attached to walls adjacent to metal stairs.
- 5. Railing gates at the level of exit discharge.

B. Related Sections:

- 1. Section 055213 "Pipe and Tube Railings" for pipe and tube railings not attached to metal stairs or to walls adjacent to metal stairs.
- 2. Section 061000 "Rough Carpentry" for wood blocking for anchoring railings.

C. Reference Standards:

- 1. American Disability Act (ADA)
 - a. ADA-ABA Accessibility Guidelines and ICC/ANSI A117.1
- 2. American Institute of Steel Construction
 - a. Manual of Steel Construction
 - b. Code of Standard Practice
- 3. American Iron and Steel Institute (AISI):
 - a. AISI 121: Standard Definitions for Use in the Design of Steel Structures.
- 4. American National Standards Institute (ANSI):

- a. ANSI A117.1: Accessible and Usable Buildings and Facilities Standards.
- 5. ASTM International formerly American Standards for Testing and Materials (ASTM):
 - a. ASTM 1008: Standard Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy and High-Strength Low-Alloy with Improved Formability, Solution Hardened, and Bake Hardened.
 - b. ASTM A1011/A 1011M: Standard Specification for Steel, Carbon, Hot-Rolled Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy and High-Strength Low-Alloy with Improved Formability.
 - c. ASTM A 123: Standard Specification for Zinc (Hot-Dip Galvanized) coatings on Iron and Steel Products.
 - d. ASTM A 153/A 153M: Standard Specification for Zinc Coating (Hot-Dip Galvanized) on Iron and Steel Hardware.
 - e. ASTM A 283/A 283M: Standard Specification for Low and Intermediate Tensile Strength Carbon Steel Plates.
 - f. ASTM A 36/A 36M: Standard Specification for Carbon Structural Steel.
 - g. ASTM A 47/A 47M: Standard Specification for Steel Sheet, Aluminum-Coated, by the Hot-Dip Process.
 - h. ASTM A 513: Standard Specification for Electric-Resistance-Welded Carbon and Alloy Mechanical Tubing.
 - i. ASTM A 526/A 536M: Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) by the Hot-Dip Process, Commercial Quality.
 - j. ASTM A 53: Standard Specification for Pipe, Steel, Black and Hot Dipped, Zinc-Coated, Welded and Seamless.
 - k. ASTM A 6/A 6M: Standard specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling.

- l. ASTM A 780/A 780M: Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings.
 - m. ASTM A 786: Standard Specification for Hot-Rolled Carbon, Low-Alloy, High-Strength Low-Alloy, and Alloy Steel Floor Plates.
 - n. ASTM E 894: Standard Test Method for Anchorage of Permanent Metal Railing Systems and Rails for Buildings.
 - o. ASTM E935: Standard Test Method for Performance of Permanent Metal Railing Systems and Rails for Buildings.
- 6. American Welding Society (AWS):
 - a. AWS D1.1/D1.1M: Structural Welding Code - Steel.
 - b. AWS D1.3: Structural Welding Code - Sheet Steel.
- 7. International Code Council
 - a. ICC International Building Code: Check local code enforcement for which edition has been adopted.
- 8. Master Painters Institute(MPI):
 - a. MPI #20: Epoxy Zinc-Rich Primer
- 9. National Association of Architectural Metal Manufacturers (NAAMM):
 - a. AMP 500-06: Metal Finishes Manual
 - b. AMP 510-92: Metal Stair Manual
 - c. MBG 531-09: Metal Bar Grating Manual
- 10. New York City Building Code Reference Standard:
 - a. RS 6-1: Photoluminescent Exit Path Markings.

- b. RS 6-1A: Additional Standards as Required by Reference Standard RS 601 for Photoluminescent Exit Path Markings

11. Society for Protective Coatings (SSPC):

- a. SSPC-PC3: Power Tool Cleaning
- b. SSPC Paint 20: Zinc-Rich Coating
- c. SSPC Paint 25: Zinc Oxide, Alkyd, Linseed Oil Primer for Use Over Hand Cleaned Steel Type 1 and Type 2
- d. SSPC-SP 2: Hand Tool Cleaning
- e. SSPC-SP 3: Power Tool Cleaning
- f. SSPC-SP 6/Nace No. 3: Commercial Blast Cleaning

12. Miscellaneous:

- a. Local construction codes and guidelines enforced by the local code officials having jurisdiction over code enforcement.

1.3 PERFORMANCE REQUIREMENTS

- A. 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/240 or 1/4 inch (6.4 mm), whichever is less.
- B. 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.
 - 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 (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.
 - D. Seismic Performance: Metal stairs shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.
 - 1. Component Importance Factor is 1.5.
- 1.4 ACTION SUBMITTALS
- A. Product Data: For metal stairs and the following:
 - 1. Grating treads.
 - 2. Paint products.
 - 3. Erection drawings (Hard/Electronic copies).
 - B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
 - C. Samples for Initial Selection: For products involving selection of color, texture, or design.
 - D. Samples for Verification: For the following products, in manufacturer's standard sizes:
 - 1. Grating treads.
 - E. Engineering calculations and stamped construction documents provided by a third party.
- 1.5 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. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for stairs and railings.
 - 1. Test railings according ASTM E 894 and ASTM E 935.

1.6 QUALITY ASSURANCE

- A. Manufacturer Qualifications: Manufacturer shall have produced the types of stair, platforms and railing systems specified in this section for not less than five (5) years.
- B. Installer Qualifications: Fabricator of products.
- C. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," for class of stair designated, unless more stringent requirements are indicated.
 - 1. Preassembled Stairs: Commercial class.
 - 2. Industrial-Type Stairs: Industrial class.
- D. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- E. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 - 2. AWS D1.3, "Structural Welding Code - Sheet Steel."

1.7 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. Contractor to coordinate, provide and install all anchors for metal stair erection. 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. Contractor to coordinate locations of hanger rods and struts with other work so that they will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.

PART 2 - PRODUCTS

2.1 METALS, GENERAL

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

2.2 FERROUS METALS

- A. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 25 percent.
- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Steel Tubing: ASTM A 513.
- D. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
- E. Steel Bars for Grating Treads: ASTM A 36/A 36M or steel strip, ASTM A 1011/A 1011M or ASTM A 1018/A 1018M.
- F. Wire Rod for Grating Crossbars: ASTM A 510 (ASTM A 510M).
- G. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.
- H. Galvanized-Steel Sheet: ASTM A 653/A 653M, G90 (Z275) coating, structural steel, Grade 33 (Grade 230), unless another grade is required by design loads.
- I. Expanded-Metal, Carbon Steel: ASTM F 1267, Type I (expanded), Class 1 (uncoated).
- J. Woven-Wire Mesh: Intermediate-crimp, square pattern, 2-inch (50-mm) woven-wire mesh, made from 0.135-inch (3.5-mm) nominal diameter wire complying with ASTM A 510 (ASTM A 510M).

2.3 FASTENERS

Note: All anchoring fasteners are provided and installed by the Contractor. The Manufacturer shall provide only product-related 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. Post-Installed Anchors: Torque-controlled expansion 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.
 - 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).

2.4 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."
- C. Shop Primers: Provide primers that comply with Section 099113 "Interior Painting."
- D. 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.
- E. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

2.5 FABRICATION, GENERAL

- A. Stringers shall be cut and formed from a single piece of stock for the full, design length. Splicing shall not be permitted.
- B. Risers shall be solid and equally spaced to within 3/16" of any adjacent riser and within 3/8" of any two non-adjacent risers on the stair.
- C. All closed tubes that require hot dip galvanizing will include an appropriately sized drain hole.
- D. Provide complete stair assemblies, including metal framing, hangers, struts, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
 1. Join components by welding unless otherwise indicated.
 2. Use connections that maintain structural value of joined pieces.
- E. 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. Preassembled Stairs come either treads to stringers or rail to stringer with bolt in treads.

- F. 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.
- G. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- H. Form exposed work with accurate angles and surfaces and straight edges.
- I. 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 3 welds: partially dressed weld with spatter removed.
- J. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Where exposed fasteners are required, use carriage bolts unless otherwise indicated. Locate joints where least conspicuous.
- K. Fabricate joints that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

2.6 STEEL-FRAMED STAIRS

- A. Manufacturers: Provide products by the manufacturer listed below:
 - 1. Orange County Iron Works LLC or approved equal.
 - a. Contact Information: Orange County Iron Works LLC
36 Maybrook Road
Montgomery, NY 12549
Phone: (845) 457-1077
Web: www.ocillc.com
- 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.

3. Weld stringers to headers; weld framing members to stringers and headers
 4. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.
- C. 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 with 1-1/4-by-3/16-inch (32-by-5-mm) bearing bars at 15/16 inch (24 mm) o.c. and crossbars at 4 inches (100 mm) o.c.
 2. Fabricate treads and platforms from welded steel grating with openings in gratings no more than 3/4 inch (19 mm) in least dimension.
 3. Surface: Serrated.
 4. Finish: Painted.
 5. Fabricate grating treads with rolled-steel floor plate 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.

2.7 STAIR RAILINGS

- A. Comply with applicable requirements in Section 055213 "Pipe and Tube Railings."
1. Fabricate
 2. Rails may be bent at corners, rail returns, and wall returns, instead of using prefabricated fittings.
 3. Connect posts to stair framing by direct welding unless otherwise indicated.
- B. Steel Tube Railings: Fabricate railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.
1. Rails and Posts: 1-1/2-inch- (38-mm-) square top and bottom rails and 1-1/2-inch- (38-mm-) square posts.
 2. Picket Infill: 3/4-inch square pickets spaced less than 4 inches (100 mm) clear.
 3. Mesh Infill: Welded wire mesh welded into 1-by-1/2-by-1/8-inch (25-by-13-by-3-mm) steel channel frames. Orient wire mesh with wires horizontal and vertical.

- C. 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 Type 3 welds: partially dressed weld with spatter removed.
- D. Form simple and compound curves by bending members in jigs to produce uniform curvature for each repetitive configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- E. Close exposed ends of railing members with prefabricated end fittings.
- F. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated. Close ends of returns unless clearance between end of rail and wall is 1/4 inch (6 mm) or less.
- G. Cap handrail return if exposed.
- H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges and miscellaneous fittings for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
 - 1. Connect posts to stair framing by direct welding unless otherwise indicated.
 - 2. For galvanized railings, provide stainless steel fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
 - 3. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves.

2.8 FINISHES

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish metal stairs after assembly.
- C. 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 will be exposed in finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.

- D. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with the following.
 - 1. Interior Stairs: SSPC-SP 3, "Power Tool Cleaning."
- E. 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

Note: All planning, coordination and execution regarding the erection of the stair/stairs to be performed by Project Contractor.

3.1 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.
- C. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete unless otherwise indicated.
- D. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- E. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- F. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.
- G. Place and finish concrete fill for treads and platforms to comply with Section 033000 "Cast-in-Place Concrete."
 - 1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.

3.2 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.

3.3 INSTALLING RAILINGS

- A. Adjust railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and rail ends to building construction as follows:
 - 1. Anchor posts to steel by welding directly to steel supporting members.
 - 2. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.
- B. Attach handrails to wall with wall brackets. Use type of bracket with predrilled hole for exposed bolt anchorage. Provide bracket with 2-1/4-inch clearance from inside face of handrail and finished wall surface. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as required to comply with performance requirements.

3.4 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 099113 "Exterior Painting" and Section 099123 "Interior Painting."] [Section 099600 "High-Performance Coatings."]
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 055100

SECTION 055213 – PIPE & TUBE RAILINGS**PART 1 - GENERAL****1.1 SUMMARY**

- A. This Section includes the following:
 - 1. Steel pipe railings and guards.

1.2 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide railings capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Handrails:
 - a. Uniform load of 50 lbf/ ft. applied in any direction.
Concentrated load of 200 lbf applied in any direction.
 - b. Uniform and concentrated loads need not be assumed to act concurrently.

1.3 SUBMITTALS

- A. Product Data: Support bracket and paint products.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
 - 1. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
- C. Samples: For each exposed finish required.

PART 2 - PRODUCTS**2.1 METALS**

- A. Brackets, Flanges, and Anchors: Cast or formed metal of same type of material and finish as supported rails, unless otherwise indicated.
- B. Steel and Iron:
 - 1. Tubing: ASTM A 500 (cold formed) or ASTM A 513, Type 5 (mandrel drawn).
 - 2. Pipe: ASTM A 53/A 53M, Type F or Type S, Grade A, Standard Weight (Schedule 40), unless another grade and weight are required by structural loads.
 - 3. Plates, Shapes, and Bars: ASTM A 36/A 36M.
 - 4. Castings: Either gray or malleable iron, unless otherwise indicated.

- a. Gray Iron: ASTM A 48/A 48M, Class 30, unless another class is indicated or required by structural loads.
- b. Malleable Iron: ASTM A 47/A 47M.

2.2 MISCELLANEOUS MATERIALS

- A. Wall Brackets: Provide "Style D" Round Saddle type wall brackets # 4581 as manufactured by Wagner, R & B, Inc.; a division of the Wagner Companies, Tel: 888-243-6914; Web: www.shopwagner.com ; or an equivalent as approved by the Architect. Bracket to provide minimum vertical clearance between underside of handrail and bracket arm of 1½".
- B. Fasteners: Provide concealed fasteners, unless unavoidable or standard for railings indicated.
 - 1. Steel Railings: Plated steel fasteners complying with ASTM B 633, Class Fe/Zn 25 for electrodeposited zinc coating.
- C. Anchors: Provide torque-controlled expansion anchors, fabricated from corrosion-resistant materials with capability to sustain, without failure, a load equal to six times the load imposed when installed in unit masonry and equal to four times the load imposed when installed in concrete, as determined by testing per ASTM E 488.
- D. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- E. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79.
- F. Grout and Anchoring Cement: Factory-packaged, nonshrink, nonmetallic grout complying with ASTM C 1107; or water-resistant, nonshrink anchoring cement; recommended by manufacturer for exterior use.

2.3 FABRICATION

- A. General: Fabricate railings to comply with design, dimensions, and details indicated, but not less than that required to support structural loads.
- B. Welded Connections: Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.
- C. Nonwelded Connections: Connect members with concealed mechanical fasteners and fittings.
- D. Form changes in direction by bending.
- E. Form curves by bending in jigs to produce uniform curvature; maintain cross section of member throughout bend without cracking or otherwise deforming exposed surfaces.
- F. Close exposed ends of railing members with prefabricated end fittings.
- G. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated.

- H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work, unless otherwise indicated.

2.4 FINISHES

- A. Steel and Iron:
 - 1. Shop-Primed Steel Finish: Prepare to comply with SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning" and apply primer to comply with SSPC-PA 1.

PART 3 - EXECUTION

3.1 INSTALLATION

- A. General: Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation.
 - 1. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
 - 2. Align rails so variations from level for horizontal members and variations from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.
- B. Anchor posts in concrete by inserting into core-drilled holes and grouting annular space.
- C. Anchor posts to metal surfaces with oval flanges.
- D. Attach handrails to wall with wall brackets.
 - 1. Use type of bracket with flange tapped for concealed anchorage to threaded hanger bolt.
 - 2. For wood stud partitions, use hanger or lag bolts set into wood backing between studs.
 - 3. For steel-framed partitions, fasten brackets with toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.
- E. Adjusting and Cleaning:
 - 1. Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material as used for shop painting.

END OF SECTION