

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. Elevator machine beams, hoist beams, and divider beams.
 2. Steel shapes for supporting elevator door sills.
 3. Steel Ladders
 4. Elevator pit sump covers.
 5. Abrasive metal nosings.
 6. Loose bearing and leveling plates for applications where they are not specified in other Sections.

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 metal fabrications that are anchored to or that receive other work. 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. Metal nosings.
 2. Grout.
- B. Shop Drawings: Show fabrication and installation details. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items. Provide Shop Drawings for the following:
 1. Elevator machine beams, hoist beams, and divider beams.
 2. Steel shapes for supporting elevator door sills.
 3. Aluminum railings.
 4. Steel Ladders.
 5. Abrasive metal nosings.

1.05 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For professional engineer.
- B. Welding certificates.

1.06 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."

1.07 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication and indicate measurements on the shop drawings.
 1. Established dimensions: Where field measurements cannot be made without delaying the work, establish dimensions and proceed with fabricating metal fabrications without field measurements. Coordinate wall and other contiguous construction to ensure that actual dimensions correspond with established dimensions.

PART 2 - PRODUCTS

2.01 METALS

- 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.
- 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. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.
- E. Aluminum Extrusions: ASTM B 221 (ASTM B 221M), Alloy 6063-T6.
- F. Aluminum Sheet: ASTM B 209 (ASTM B 209M), Alloy 5005-H34.
- G. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

2.02 FASTENERS

- A. General: Unless otherwise indicated, provide Type 316 stainless-steel fasteners. (ASTM F 1941M)
 1. Provide stainless-steel fasteners for fastening aluminum.
- B. Steel 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. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 325, Type 3 (ASTM A 325M, Type 3); with hex nuts, ASTM A 563, Grade C3 (ASTM A 563M, Class 8S3); and, where indicated, flat washers.
- D. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593 (ASTM F 738M); with hex nuts, ASTM F 594 (ASTM F 836M); and, where indicated, flat washers; Alloy Group 2 (A4).
- E. 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.
- F. Plain Washers: Round, ASME B18.22.1.
- G. 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/E 488M, conducted by a qualified independent testing agency.
- H. 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.
- I. Post-Installed Anchors: Torque-controlled expansion anchors .
1. 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).

2.03 MISCELLANEOUS MATERIALS

- A. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.
- B. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- 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. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187/D 1187M.
- E. Non-shrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, non-gaseous grout complying with ASTM C 1107/C 1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- F. Concrete: Comply with requirements in Section 033000 "Cast-in-Place Concrete" for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 4000 psi (20 MPa).

2.04 FABRICATION, GENERAL

- A. Shop Assembly: Pre-assemble 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 exposed work with accurate angles and surfaces and straight edges.
- D. Weld corners and seams continuously to comply with the following:
1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 2. Obtain fusion without undercut or overlap.

3. Remove welding flux immediately.
 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- E. 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.
- F. Fabricate seams and other connections that are exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- G. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- H. 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.

2.05 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.
- C. Galvanize miscellaneous framing and supports where indicated.

2.06 STEEL LADDERS

- A. Ladders: Steel; in compliance with ANSI A14.3; with mounting brackets and attachments; prime paint finish.
1. Side Rails: 3/8 x 2 inches (9 x 50 mm) members spaced at 20 inches (500 mm). with eased edges and radius top extensions.
 2. Rungs: one inch (25 mm) diameter solid round bar with non-slip tread aluminum oxide surfaces, spaced 12 inches (300 mm) on center.
 3. Fit rungs into center of side rails, plug weld and grind smooth on outer rail faces.
 4. Space rungs 7 inches (175 mm) from wall surface to centerline of rungs.
 5. Support each ladder rail at the top and bottom and not more than 60 inches on center with welded steel offset brackets.
 6. Prime interior ladders including brackets and fasteners for finish painting as per Division 9.

2.07 METAL FLOOR PLATE

- A. Fabricate from rolled-steel floor abrasive-surface floor plate of thickness indicated below:
- B. Provide steel angle supports as indicated.
- C. Provide flush steel bar drop handles for lifting removable sections, one at each end of each section.

2.08 ABRASIVE METAL 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. Manufacturers Subject to compliance with requirements, provide products by one of the following:
 - a. Balco, Inc
 - b. Safe-T-Metal Company, Inc
 - c. Wooster Products Inc
 - 2. Nosings: Cross-hatched units, 4 inches (100 mm) wide with 1/4-inch (6-mm) lip, for casting into concrete.
 - 3. Nosings: Cross-hatched units, 1-1/2 by 1-1/2 inches (38 by 38 mm), for casting into concrete.
 - 4. Treads: Cross-hatched units, full depth of tread with 3/4-by-3/4-inch (19-by-19-mm) nosing, for application over bent plate treads or existing stairs.
- B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- C. Drill for mechanical anchors and countersink. Locate holes not more than 4 inches (100 mm) from ends and not more than 12 inches (300 mm) o.c., evenly spaced between ends, unless otherwise indicated. Provide closer spacing if recommended by manufacturer.
- D. Apply bituminous paint to concealed surfaces of cast-metal units.

2.09 METAL DOWNSPOUT BOOTS

- A. Provide downspout boots made from cast in heights indicated with inlets of size and shape to suit downspouts. Provide units with flanges and holes for countersunk anchor bolts.
 - 1. Outlet: Vertical, to discharge into pipe.

2.10 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. Hot Dip Galvanize plates (2.0 oz. / sq. ft.).

2.11 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. Galvanize loose steel lintels located in exterior walls.

2.12 FINISHES, GENERAL

- A. Finish metal fabrications after assembly.
- B. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.13 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 primers specified in Section 099113 "Exterior Painting", primers specified in Section 099123 "Interior Painting" unless indicated.

2.14 ALUMINUM FINISHES

- A. As-Fabricated Finish: AA-M12.

PART 3 - EXECUTION

3.01 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, 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 come into contact with grout, concrete, masonry, wood, or dissimilar metals with the following:
 - 1. Cast Aluminum: Heavy coat of bituminous paint.

3.02 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 securely to, and rigidly brace from, building structure.
- C. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified in "Installing Bearing and Leveling Plates" Article.

3.03 INSTALLING NOSINGS, TREADS, AND THRESHOLDS

- A. Center nosings on tread widths unless otherwise indicated.
- B. For nosings embedded in concrete steps or curbs, align nosings flush with riser faces and level with tread surfaces.

3.04 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 non-shrink grout. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.05 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. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in Section 099113 "Exterior Painting."
- 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