

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. Pre-assembled steel stairs with concrete-filled treads.
 - 2. Steel tube railings attached to metal stairs.
 - 3. Steel tube handrails attached to walls adjacent to metal stairs.
 - 4. Wood blocking for anchoring railings.

1.03 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Design metal stairs, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.
- B. Structural Performance of Stairs: Metal stairs shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated.
 - 1. Uniform Load: 100 lbf/sq. ft (4.79 kN/sq. m).
 - 2. Concentrated Load: 300 lbf (1.33 kN) applied on an area of 4 sq. in (2580 sq. mm).
 - 3. Uniform and concentrated loads need not be assumed to act concurrently.
 - 4. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
 - 5. Limit deflection of treads, platforms, and framing members to L/360 or 1/4 inch (6.4 mm), whichever is less.
- C. Structural Performance of Handrails and Railings: Handrails and railings shall withstand the structural loads required by ASCE 7 without exceeding the allowable design working stress of the materials for handrails, railings anchors and connections. Gravity loads and the following loads and stresses within the limits and under the 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).
- D. Seismic Performance: Metal stairs shall withstand the effects of earthquake motions determined according to ASCE/SEI 7, Minimum Design Loads for Buildings and Other Structures": Section 9 "Earthquake Loads".
 - 1. Component Importance Factor is 1.15.

1.04 ACTION SUBMITTALS

- A. Product Data: For metal stairs and the following:
 - 1. Refilled metal-pan stair treads.
 - 2. Abrasive nosings.
 - 3. Paint products.
 - 4. Grout.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

1. Provide templates for anchors and bolts specified for installation under other sections.

1.05 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For qualified professional engineer.
- B. Welding certificates. Certified welder employed on the work shall have AWS Certification within the previous 12 months.
- C. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.
- D. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for stairs.
- E. Special Inspection Requirements:
 1. Where materials, welding procedures and qualifications of welders are verified prior to the start of work, periodic inspections of the work in progress and a visual inspection of all welds are made prior to shipping of shop welding, continuous special inspections of welding will not be required.

1.06 QUALITY ASSURANCE

- A. Installer Qualifications: Fabricator of products.
- B. Professional Engineer Qualifications: A Professional Engineer who is legally qualified to practice in the state in which the project is located and who is experienced in providing engineering services of the type indicated and required for this section of the work. Engineering services are defined as those performed for installations of Metal Stairs including handrails and railing systems, that are similar to those indicated for this project in material, design and extent.
- C. Fabricator Qualifications: A firm experienced in producing Metal Stairs similar to those indicated for this project and with a record of successful in-service performance, as well as sufficient production capability to produce the required units.
- D. 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. Ornamental Stairs: Architectural class.
- E. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- F. Welding Qualifications: Qualify procedures and personnel according to the following:
 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 2. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."

1.07 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages for metal stairs. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items

with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

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

PART 2 - PRODUCTS

2.01 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.

2.02 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 A36/A36M.
- C. Steel Tubing: ASTM A500/A500M (cold formed).
- D. Uncoated, Cold-Rolled Steel Sheet: ASTM A1008/A1008M, either commercial steel, or structural steel, Grade 25 (Grade 170), unless another grade is required by design loads; exposed.

2.03 ABRASIVE NOSINGS

- A. Extruded Units: Aluminum units with abrasive filler consisting of aluminum oxide, silicon carbide, or a combination of both, in an epoxy-resin binder. 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. American Safety Tread Co., Inc.
 - b. Balco Inc.
 - c. Wooster Products Inc.
 - a. Provide ribbed units, with abrasive filler strips projecting 1/16 inch (1.5 mm) above aluminum extrusion.
 - b. For Solid Hardwood treads: Provide 3/8 inch individual strips routed into treads spaced 1 1/2 inch apart. Color of abrasive shall be as selected by the architect.
 - c. Provide solid-abrasive-type units without ribs.
 - d. Nosings: Square-back units, 3 inches (75 mm) wide, without lip.
 - e. Nosings: Two-piece units, 3 inches (75 mm) wide, with subchannel for casting into concrete.
- B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- C. Apply bituminous paint to concealed surfaces of cast-metal units set into concrete.
- D. Apply clear lacquer to concealed surfaces of extruded units set into concrete.

2.04 FASTENERS

- A. General: Provide zinc-plated fasteners with coating complying with ASTM B633 or ASTM F1941/F1941M, Class Fe/Zn 12 for exterior use, and Class Fe/Zn 5 where built into exterior walls. Select fasteners for type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A307, Grade A (ASTM F 568M, Property Class 4.6); with hex nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.
- C. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).
- D. Plain Washers: Round, ASME B18.22.1 (ASME B18.22M).
- E. Lock Washers: Helical, spring type, ASME B18.21.1 (ASME B18.21.2M).
- F. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors capable of sustaining, without failure, a load equal to six times the load imposed when installed in unit masonry and four times the load imposed when installed in concrete, as determined by testing according to ASTM E488/E488M, conducted by a qualified independent testing agency.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B633 or ASTM F1941/F1941M, Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 2 (A4) stainless-steel bolts, ASTM F593, and nuts, ASTM F594.

2.05 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Shop Primers: Provide primers that comply with Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."
- C. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, non-gaseous grout complying with ASTM C1107/C1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- D. Concrete Materials and Properties: Comply with requirements in Division 03 for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 4000 psi (20 MPa) unless otherwise indicated.
- E. Nonslip-Aggregate Concrete Finish: Factory-packaged abrasive aggregate made from fused, aluminum-oxide grits or crushed emery; rustproof and non-glazing; unaffected by freezing, moisture, or cleaning materials.
- F. Welded Wire Fabric: ASTM A 185/A 185M, 6 by 6 inches (152 by 152 mm), W1.4 by W1.4, unless otherwise indicated.

2.06 FABRICATION, GENERAL

- A. 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.

- B. Preassembled Stairs: Assemble stairs in shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.
- C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch (1 mm) unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- E. Form exposed work with accurate angles and surfaces and straight edges.
- F. Weld connections to comply with the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. Weld exposed corners and seams continuously unless otherwise indicated.
 - 5. At exposed connections, finish exposed welds to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 1 welds: no evidence of a welded joint.
- G. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts unless otherwise indicated. Locate joints where least conspicuous.
- H. Fabricate joints that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

2.07 STEEL-FRAMED STAIRS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. Alfab, Inc.
 - 2. American Stair, Inc.
 - 3. Sharon Companies Ltd. (The).
- B. Stair Framing:
 - 1. Fabricate stringers of steel plates or channels tubes or a combination of both as indicated.
 - a. Provide closures for exposed ends of channel or tube stringers.
 - 2. Construct platforms of steel tube headers and miscellaneous framing members as indicated.
 - 3. Weld or bolt stringers to headers; weld or bolt framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.
 - 4. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.
- C. Metal-Pan Stairs: Form risers, subtread pans, and subplatforms to configurations shown from steel sheet of thickness needed to comply with performance requirements but not less than 0.067 inch (1.7 mm).
 - 1. Steel Sheet: Galvanized and primed cold-rolled steel sheet.
 - 2. Directly weld metal pans to stringers; locate welds on top of subtreads where they will be concealed by concrete fill. Do not weld risers to stringers.
 - 3. Shape metal pans to include nosing integral with riser.

4. At Contractor's option, provide stair assemblies with metal-pan subtreads filled with reinforced concrete during fabrication.
5. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.
 - a. Smooth Soffit Construction: Construct subplatforms with flat metal under surfaces to produce smooth soffits.
6. When indicated, provide Hot-Dip galvanized completed fabrications with a factory primer ready for field painting.

2.08 STAIR RAILINGS

- A. Comply with applicable requirements in Section 055213 - PIPE AND TUBE RAILINGS or as indicated in this Section.
 1. Rails may be bent at corners, rail returns, and wall returns, instead of using prefabricated fittings.
 2. 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 round top and bottom rails and 1-1/2-inch round posts.
 2. Picket Infill: 1/2-inch round pickets spaced less than 3 7/8" inches clear.
 3. Intermediate Rails Infill: 1-1/2-inch round intermediate rails spaced less than 21 inches clear or as shown on the drawings.
 4. Gates: Form gates from steel tube of same size and shape as top rails, with infill to match guards. Provide with cam-type, self-closing hinges for fastening to wall and overlapping stop with rubber bumper to prevent gate from opening in direction opposite egress.
- 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 1 welds: no evidence of a welded joint.
- D. Form changes in direction of railings as follows:
 1. As detailed.
 2. By radius bends of radius indicated or by inserting prefabricated elbow fittings of radius indicated.
- E. 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.
- F. Close exposed ends of railing members with prefabricated end fittings.
- G. 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.
- H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
 1. Connect posts to stair framing by direct welding unless otherwise indicated.
 2. For non-galvanized railings, provide non-galvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.

2.09 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. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 1. Interior Stairs: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."

PART 3 - EXECUTION

3.01 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.
- C. 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 Division 03.
 - 1. Steel trowel concrete to a smooth finish, free of trowel marks and uniform in texture and appearance. allow concrete to cure for three days. Do not allow traffic on concrete.
 - 2. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.

3.02 INSTALLING METAL STAIRS WITH GROUTED BASEPLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of baseplates.
- B. Set steel stair baseplates on wedges, shims, or leveling nuts. After stairs have been positioned and aligned, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.
 - 1. Use nonmetallic, nonshrink grout unless otherwise indicated.
 - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.03 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 1-1/2-inch (38-mm) clearance from inside face of handrail and finished wall surface. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as follows:
 - 1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 - 2. For hollow masonry anchorage, use toggle bolts.
 - 3. For steel-framed partitions, use toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.

3.04 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

END OF SECTION