

SECTION 051200 - STRUCTURAL STEEL

PART 1 - GENERAL

1.1 SCOPE OF WORK

- A. The work required under this heading shall include all labor, materials, tools, equipment and services necessary for and reasonably incidental to the fabrication and delivery to site as shown on the drawings and/or as herein specified.

1.2 RELATED DOCUMENTS

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

1.3 SUMMARY

- A. This Section includes:

1. Structural steel.
2. Field-installed shear connectors.
3. Grout.

- B. Related Sections: The following Sections contain requirements that relate to this Section:

1. Division 1 Section "Quality Control" for independent testing agency procedures and administrative requirements.
2. Division 5 Section "Steel Deck" for field installation of shear connectors.
3. Division 5 Section "Metal Fabrications" for loose steel bearing plates and miscellaneous steel framing.
4. Section 012100 "Allowances" for Quality Control Services Testing and Inspection allowances for Owner specified or indicated Testing and Inspections.

1.4 PERFORMANCE REQUIREMENTS

- A. Connections: Engineer structural steel connections required by the Contract Documents to be selected or completed by the fabricator to withstand design loadings indicated. For brace members only.
- B. Engineering Responsibility: Engage a fabricator who utilizes a qualified professional engineer to prepare calculations, Shop Drawings, and other structural data for structural steel connections.

1.5 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Shop Drawings: Show fabrication details of structural-steel components.

1. Indicate welds by standard AWS symbols, distinguishing between shop and field welds, and show size, length, and type of each weld.
 2. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify high-strength bolted slip-critical, direct-tension, or tensioned shear/bearing connections.
 3. Include Shop Drawings signed and sealed by a qualified professional engineer licensed in Missouri responsible for their preparation.
 4. Shop Drawings shall be drawn at 1/8-inch equals 1'-0" minimum for plans and 3/4-inch equals 1'-0" minimum for sections. Contract Drawings shall not be reproduced in whole or in part for modification into Shop Drawings. Contract Drawings modified without approval will be returned without review.
 5. Each sheet of the Shop Drawings shall bear the review stamp of the Contractor indicating their review and approval. Drawings without the Contractor's stamp will be returned without review.
- C. Welding certificates.
- D. Mill test reports.
1. Structural steel, including chemical and physical properties.
 2. Bolts, nuts, and washers, including mechanical properties and chemical analysis.
 3. Twist-off tension control bolts.
 4. Shear stud connectors.
 5. Shop primers.
 6. Nonshrink grout.
- E. Source quality-control test reports.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: Engage an experienced Installer who has completed structural steel work similar in material, design, and extent to that indicated for this Project and with a record of successful in-service performance.
- B. Fabricator Qualifications: Engage a firm experienced in fabricating structural steel similar to that indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to fabricate structural steel without delaying the Work.
1. Fabricator must participate in the AISC Quality Certification Program and be designated an AISC-Certified Plant. In lieu of AISC certification, fabrication must submit (5) projects of similar size and complexity for approval of Architect and Engineering of record during bidding. Engineer of record shall determine if qualifications are satisfactory to waive AISC certification.
 2. Comply with applicable provisions of the following specifications and documents:
 - a. AISC 303.
 - b. AISC 360.
 - c. RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- C. Professional Engineer Qualifications: A professional engineer who is legally authorized to practice in the 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 projects with structural steel framing that are similar to that indicated for this Project in material, design, and extent.

- D. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code-Steel."
 - 1. Present evidence that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.
- E. Comply with applicable provisions of AISC's "Code of Standard Practice for Steel Buildings and Bridges."
- F. Preinstallation Conference: Conduct conference at Project site.

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Deliver structural steel to Project site in such quantities and at such times to ensure continuity of installation.
- B. Store materials to permit easy access for inspection and identification. Keep steel members off ground by using pallets, platforms, or other supports. Protect steel members and packaged materials from erosion and deterioration.
 - 1. Store fasteners in a protected place. Clean and re-lubricate bolts and nuts that become dry or rusty before use.
 - 2. Do not store materials on structure in a manner that might cause distortion or damage to members or supporting structures. Repair or replace damaged materials or structures as directed.

1.8 SEQUENCING

- A. Supply anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, templates, instructions, and directions, as required, for installation.

PART 2 - PRODUCTS

2.1 STRUCTURAL-STEEL MATERIALS

- A. W-Shapes: ASTM A 992.
- B. Channels, Angles-Shapes: ASTM A 36.
- C. Plate and Bar: ASTM A 36, carbon steel angles.
- D. Cold-Formed Structural Steel Tubing: ASTM A 500, C.
- E. Steel Pipe: ASTM A 53, Type E or S, Grade B.
 - 1. Weight Class: As indicated on Drawings.
 - 2. Finish: Black, except where indicated to be galvanized.
- F. Anchor Rods, Bolts, Nuts, and Washers: ASTM A 36.
- G. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy hex steel structural bolts, heavy hex carbon-steel nuts, and hardened carbon-steel washers.

1. Finish: Plain, uncoated.
2. Provide twist-off tension control bolts.
 - a. Finish: Plain, uncoated.
- H. Shear Connectors: ASTM A 108, Grades 1015 through 1020, headed-stud type, cold-finished carbon steel; AWS D1.1/D1.1M, Type B.
- I. Welding Electrodes: Comply with AWS requirements.

2.2 PRIMER

- A. Refer to Division 9 specifications for all final painted finish on steel and coordination of compatibility with finish paint products.
- B. Primer: SSPC-Paint 25, Type II, iron oxide, zinc oxide, raw linseed oil, and alkyd. Submit a bid alternate for applying a soy based primer.
- C. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds and repair painting galvanized steel, with dry film containing not less than 93 percent zinc dust by weight, and complying with DOD-P-21035A or SSPC-Paint 20.

2.3 GROUT

- A. Non metallic, Shrinkage-Resistant Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage compensating agents, plasticizing and water-reducing agents, complying with ASTM C 1107, of consistency suitable for application, and a 30-minute working time.

2.4 FABRICATION

- A. Structural Steel: Fabricate and assemble structural steel in shop to greatest extent possible. Fabricate structural steel according to AISC specifications referenced in this Section and in Shop Drawings.
 1. Camber structural steel members where indicated.
 2. Identify high-strength structural steel according to ASTM A 6 and maintain markings until steel has been erected.
 3. Mark and match-mark materials for field assembly.
 4. Fabricate for delivery a sequence that will expedite erection and minimize field handling of structural steel.
 5. Splicing structural steel members is prohibited unless shown otherwise.
 6. Complete structural steel assemblies, including welding of units, before starting shop-priming operations.
 7. Comply with fabrication tolerance limits of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for structural steel.

- B. Thermal Cutting: Perform thermal cutting by machine to greatest extent possible.
 - 1. Plane thermally cut edges to be welded.
- C. Finishing: Accurately mill ends of columns and other members transmitting loads in bearing.
- D. Holes: Provide holes required for securing other work to structural steel framing and for passage of other work through steel framing members, as shown on Shop Drawings.
 - 1. Cut, drill, or punch holes perpendicular to metal surfaces. Do not flame-cut holes or enlarge holes by burning. Drill holes in bearing plates.
 - 2. Weld threaded nuts to framing and other specialty items as indicated to receive other work.
- E. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.

2.5 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. Bolts: ASTM A 325 high-strength bolts, unless otherwise indicated.
 - 2. Joint Type: Snug tightened.
- 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. Assemble and weld built-up sections by methods that will maintain true alignment of axes without warp.

2.6 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 only in the Server and Entrance vestibule area. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces according to the following specifications and standards:
 - 1. SSPC-SP 3, "Power Tool 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.

2.7 GALVANIZING

- A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process according to ASTM A 123 as follows:
 - 1. Structural steel indicated in mechanical screened area.
 - 2. All permanent exterior exposed structural steel and lintels.

2.8 SOURCE QUALITY CONTROL

- A. Owner may engage an independent testing and inspecting agency to perform shop tests and inspections and prepare test reports.
 - 1. Testing agency will conduct and interpret tests and state in each report whether test specimens comply with or deviate from requirements.
 - 2. Provide testing agency with access to places where structural steel Work is being fabricated or produced so required inspection and testing can be accomplished.
- B. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.
- C. Additional testing, at Contractor's expense, will be performed to determine compliance of corrected Work with specified requirements.
- D. Shop-bolted connections will be inspected for use of tension control bolts.
- E. All full-penetration welds will be inspected and tested according to AWS D1.1 and the inspection procedures listed below, 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. Radiographic Inspection: ASTM E 94 and ASTM E 142; minimum quality level "2-2T."
 - 4. Ultrasonic Inspection: ASTM E 164.
- F. In addition to visual inspection, shop-welded shear connectors will be tested and inspected according to requirements in AWS D1.1 for stud welding.
 - 1. Bend tests will be performed when visual inspections reveal either less than a continuous 360-degree flash or welding repairs to any shear connector.
 - 2. Tests will be conducted on additional shear connectors when weld fracture occurs on shear connectors already tested, according to requirements of AWS D1.1.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Before erection proceeds, and with the steel erector present, verify elevations of concrete and masonry bearing surfaces and locations of anchorages for compliance with requirements.

- B. Do not proceed with erection until 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 specifications referenced in this Section.
- B. Provide rigid templates for anchor bolts.
- C. 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. Tighten anchor bolts 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 prior to 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.
 - a. Comply with manufacturer's instructions for proprietary grout materials.
- D. Maintain erection tolerances of structural steel within AISC's "Code of Standard Practice for Steel Buildings and Bridges."
- E. 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. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 - 1. Level and plumb individual members of structure.
 - 2. Establish required leveling and plumbing measurements on mean operating temperature of structure. Make allowances for difference between temperature at time of erection and mean temperature at which structure will be when completed and in service.
- F. Splice members only where indicated.
- G. Remove erection bolts on welded, architecturally exposed structural steel; fill holes with plug welds; and grind smooth at exposed surfaces.
- H. Do not use thermal cutting during erection.
- I. Finish sections thermally cut during erection equal to a sheared appearance.

- J. Do not enlarge unfair holes in members by burning or by using drift pins. Ream holes that must be enlarged to admit bolts.
- K. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1/D1.1M and manufacturer's written instructions.

3.4 FIELD CONNECTIONS

- A. Install and tighten high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
 - 1. Bolts: ASTM A 325 high-strength bolts, unless otherwise indicated.
- B. Weld Connections: Comply with AWS D1.1 for procedures, appearance and quality of welds, and methods used in correcting welding work.
 - 1. Comply with AISC specifications referenced in this Section for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds.
 - 2. Assemble and weld built-up sections by methods that will maintain true alignment of axes without warp.

3.5 FIELD QUALITY CONTROL

- A. Testing Agency: Owner may engage an independent testing and inspecting agency to perform field inspections and tests and to prepare test reports.
 - 1. Testing agency will conduct and interpret tests and state in each report whether tested Work complies with or deviates from requirements.
- 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. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

3.6 CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint. Apply paint to exposed areas using same material as used for shop painting.
- B. Apply by brush or spray to provide a minimum dry film thickness of 1.5 mils.

END OF SECTION 051200

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SECTION 052100 - STEEL JOISTS

PART 1 - GENERAL

1.1 SCOPE OF WORK

- A. The work required under this heading shall include all labor, materials, tools, equipment and services necessary for and reasonably incidental to the fabrication and delivery to site as shown on the drawings and/or as herein specified.

1.2 RELATED DOCUMENTS

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

1.3 SUMMARY

- A. This Section includes the following:
 - 1. K-series steel joists.
 - 2. KCS-type K-series steel joists.
 - 3. Joist accessories.
- B. Related Sections include the following:
 - 1. Division 3 Section "Cast-in-Place Concrete" for installing bearing plates in concrete.
 - 2. Division 5 Section "Metal Fabrications" for furnishing steel bearing plates.
 - 3. Section 012100 "Allowances" for Quality Control Services Testing and Inspection allowances for Owner specified or indicated Testing and Inspections.

1.4 SUBMITTALS

- A. Product Data: For each type of joist, accessory, and product indicated.
- B. Shop Drawings: Show layout, designation, number, type, location, and spacings of joists. Include joining and anchorage details, bracing, bridging, joist accessories; splice and connection locations and details; and attachments to other construction.
- C. Welding certificates.
- D. Manufacturer certificates.
- E. Mill Certificates: For bolts.
- F. Field quality-control test and inspection reports.
- G. Research/Evaluation reports.

1.5 DEFINITIONS

- A. Special Joists: Joists requiring modification by the manufacturer to support nonuniform, unequal, or special loading conditions that invalidate SJI's "Standard Specifications Load Tables and Weight Tables for Steel Joists and Joist Girders."

1.6 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide special joists and connections capable of withstanding design loads within limits and under conditions indicated. Refer to structural drawings for information.
- B. Design joists to withstand design loads with live load deflections no greater than the following:
 - 1. Roof Joists: Vertical deflection of 1/360 of the span.

1.7 QUALITY ASSURANCE

- A. Manufacturer Qualifications: A manufacturer certified by the Steel Joist Institute (SJI) to manufacture joists complying with SJI standard specifications and load tables.
 - 1. Assumes responsibility for engineering special joists to comply with performance requirements. This responsibility includes preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer.
- B. Professional Engineer Qualifications: A professional engineer who is legally authorized 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 joists that are similar to those indicated for this Project in material, design, and extent.
- C. SJI Specifications: Comply with SJI's "Standard Specifications, Load Tables and Weight Tables for Steel Joists and Joist Girders" (hereafter, SJI's "Specifications") that are applicable to types of joists indicated.
- D. Welding: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.8 SEQUENCING

- A. Deliver steel bearing plates and other devices to be built into concrete construction.

1.9 DELIVERY, STORAGE, AND HANDLING

- A. Deliver, store, and handle joists as recommended in SJI's "Specifications."
- B. Protect joists from corrosion, deformation, and other damage during delivery, storage, and handling.

PART 2 - PRODUCTS

2.1 MATERIALS

- A. Steel: Comply with SJI's "Specifications" for web and steel-angle chord members.
- B. Carbon-Steel Bolts and Threaded Fasteners: ASTM A 307, Grade A, carbon-steel, hex-head bolts and threaded fasteners; carbon-steel nuts; and flat, unhardened steel washers.
 - 1. Finish: Plain, uncoated.
- C. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy hex steel structural bolts, heavy hex carbon-steel nuts, and hardened carbon-steel washers.
 - 1. Finish: Plain, uncoated.
- D. Primer: Match requirements in Section 2.2 of 051200.
- E. Welding Electrodes: Comply with AWS standards.

2.2 K-SERIES STEEL JOISTS

- A. Manufacture steel joists according to "Standard Specifications for Open Web Steel Joists, K-Series" in SJI's "Specifications," with steel-angle top- and bottom-chord members, underslung ends, and parallel top chord.
- B. Steel Joist Substitutes: Manufacture according to "Standard Specifications for Open Web Steel Joists, K-Series" in SJI's "Specifications," with steel-angle or -channel members.
- C. Comply with AWS requirements and procedures for shop welding, appearance, quality of welds, and methods used in correcting welding work.
- D. Provide holes in chord members for connecting and securing other construction to joists.
- E. Top-Chord Extensions: Extend top chords of joists with SJI's Type S top-chord extensions where indicated, complying with SJI's "Specifications."
- F. Extended Ends: Extend bearing ends of joists with SJI's Type R extended ends where indicated, complying with SJI's "Specifications."
- G. Camber joists according to SJI's "Specifications."
- H. Equip bearing ends of joists with manufacturer's standard beveled ends or sloped shoes if joist slope exceeds 1/4 inch per 12 inches.

2.3 JOIST ACCESSORIES

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

1. Coordinate bridging locations with work of other trades and/or locations of other construction.
 2. Provide one row of additional bottom chord bridging at each end for joists with up lift.
- C. Supply ceiling extensions, either extended bottom-chord elements or a separate extension unit of enough strength to support ceiling construction. Extend ends to within 1/2 inch of finished wall surface, unless otherwise indicated.
- D. Supply miscellaneous accessories, including splice plates and bolts required by joist manufacturer to complete joist installation.

2.4 CLEANING AND SHOP PAINTING

- A. Clean and remove loose scale, heavy rust, and other foreign materials from fabricated joists and accessories. Apply 1 coat of shop primer.
- B. Do not prime paint joists and accessories to receive sprayed fire-resistive materials (if any).

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting substrates, embedded bearing plates, and abutting structural framing, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Do not install joists until supporting construction is in place and secured.
- B. Install joists and accessories plumb, square, and true to line; securely fasten to supporting construction according to SJ's "Specifications," joist manufacturer's written recommendations, and requirements in this Section.
1. Before installation, splice joists delivered to Project site in more than one piece.
 2. Space, adjust, and align joists accurately in location before permanently fastening.
 3. Install temporary bracing and erection bridging, connections, and anchors to ensure that joists are stabilized during construction.
 4. Delay rigidly connecting bottom-chord extensions to columns or supports until dead loads have been applied.
- C. Field weld joists to supporting steel bearing plates and framework. Coordinate welding sequence and procedure with placement of joists. Comply with AWS requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
- D. Bolt joists to supporting steel framework using carbon-steel bolts, unless otherwise indicated. Bolting for erection only.
- E. Install and connect bridging concurrently with joist erection, before construction loads are applied. Anchor ends of bridging lines at top and bottom chords if terminating at walls or beams.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Owner may engage a qualified independent testing and inspecting agency to inspect field welds and high-strength bolted connections.
- B. Field welds will be visually inspected according to AWS D1.1.
- C. Correct deficiencies in Work that inspections and test reports have indicated are not in compliance with specified requirements.
- D. Additional testing, at Contractor's expense, will be performed to determine compliance of corrected Work with specified requirements.

3.4 REPAIRS AND PROTECTION

- A. 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.
- B. Provide final protection and maintain conditions, in a manner acceptable to manufacturer and Installer that ensure joists and accessories are without damage or deterioration at time of Substantial Completion.

END OF SECTION 052100

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SECTION 053100 - STEEL DECK

PART 1 - GENERAL

1.1 SCOPE OF WORK

- A. The work required under this heading shall include all labor, materials, tools, equipment and services necessary for and reasonably incidental to the fabrication and delivery to site as shown on the drawings and/or as herein specified.

1.2 RELATED DOCUMENTS

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

1.3 SUMMARY

- A. This Section includes the following:

1. Roof deck.
2. Acoustical roof deck.
3. Steel form (floor) deck.

- B. Related Sections include the following:

1. Division 3 Section "Cast-in-Place Concrete" for concrete fill and reinforcing steel.
2. Division 5 Section "Metal Fabrications" for framing deck openings with miscellaneous steel shapes.
3. Division 5 "Structural Steel Framing" for shop- and field-welded shear connectors.
4. Section 012100 "Allowances" for Quality Control Services Testing and Inspection allowances for Owner specified or indicated Testing and Inspections.

1.4 SUBMITTALS

- A. Product Data: For each type of deck, accessory, and product indicated.
- B. Shop Drawings: Show layout and types of deck panels, anchorage details, reinforcing channels, pans, cut deck openings, special jointing, accessories, and attachments to other construction.
- C. Product certificates. For each type of deck
- D. Welding certificates.
- E. Field quality-control test and inspection reports.
- F. Research/Evaluation Reports: Evidence of steel deck's compliance with building code in effect for Project, from a model code organization acceptable to authorities having jurisdiction.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: An experienced installer who has completed steel deck similar in material, design, and extent to that indicated for this Project and whose work has resulted in construction with a record of successful in-service performance.
- B. Testing Agency Qualifications: An independent testing agency, acceptable to authorities having jurisdiction, qualified according to ASTM E 329 to conduct the testing indicated, as documented according to ASTM E 548.
- C. Welding: Qualify procedures and personnel according to AWS D1.3, "Structural Welding Code - Sheet Steel."
- D. Fire-Test-Response Characteristics: Where indicated, provide steel deck units identical to those tested for fire resistance per ASTM E 119 by a testing and inspecting agency acceptable to authorities having jurisdiction.
 - 1. Fire-Resistance Ratings: Indicated by design designations of applicable testing and inspecting agency.
 - 2. Steel deck units shall be identified with appropriate markings of applicable testing and inspecting agency.
- E. AISI Specifications: Comply with calculated structural characteristics of steel deck according to AISI's "North American Specification for the Design of Cold-Formed Steel Structural Members."

1.6 DELIVERY, STORAGE, AND HANDLING

- A. Protect steel deck from corrosion, deformation, and other damage during delivery, storage, and handling.
- B. Stack steel deck on platforms or pallets and slope to provide drainage. Protect with a waterproof covering and ventilate to avoid condensation.

1.7 COORDINATION

- A. Coordinate installation of sound-absorbing insulation strips in acoustic deck ribs with related units of Work specified in other sections to ensure that the insulation is protected against damage from effects of the weather and other causes.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

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

2.2 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. BHP Steel Building Products USA Inc.
 - 2. Consolidated Systems, Inc.

3. Epic Metals Corp.
4. Marlyn Steel Products, Inc.
5. Nucor Corp.; Vulcraft Div.
6. Roof Deck, Inc.
7. United Steel Deck, Inc.
8. Verco Manufacturing Co.
9. Wheeling Corrugating Co.; Div. of Wheeling-Pittsburgh Steel Corp.

2.3 ROOF DECK

- A. Steel Roof Deck: Fabricate panels, without top-flange stiffening grooves, to comply with "SDI Specifications and Commentary for Steel Roof Deck," in SDI Publication No. 30, and with the following:
1. Prime-Painted Steel Sheet: Match Section 051200 for finish and color.
 1. Deck Profile: As indicated
 2. Profile Depth: As indicated
 3. Design Uncoated-Steel Thickness: As indicated.

2.4 ACOUSTICAL ROOF DECK

- A. Acoustical Roof Deck: Fabricate panels, without top-flange stiffening grooves, to comply with "SDI Specifications and Commentary for Steel Roof Deck," in SDI Publication No. 31, and with the following:
1. Prime-Painted Steel Sheet: Match Section 051200 for finish and color.
 2. Deck Profile: As indicated.
 3. Profile Depth: As indicated.
 4. Design Uncoated-Steel Thickness: As indicated.
 5. Span Condition: Triple span or more.
 6. Side Laps: Overlapped.
 7. Sound-Absorbing Insulation: Manufacturer's standard premolded roll or strip of glass or mineral fiber.
 - a. Factory installed sound-absorbing insulation into cells of cellular deck.
 8. Acoustical Performance: NRC 0.65, tested according to ASTM C 423.

2.5 NONCOMPOSITE FORM DECK

- A. Noncomposite Form Deck: Fabricate ribbed-steel sheet noncomposite form-deck panels to comply with "SDI Specifications and Commentary for Noncomposite Steel Form Deck," in SDI Publication No. 31, with the minimum section properties indicated, and with the following:
1. Galvanized-Steel Sheet: ASTM A 653, Structural Steel (SS), G60 zinc coating.
 2. Profile Depth: As indicated
 3. Design Uncoated-Steel Thickness: As indicated
 4. Span Condition: As indicated
 5. Side Laps: As indicated.

2.6 ACCESSORIES

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

- B. Mechanical Fasteners: Corrosion-resistant, low-velocity, power-actuated or pneumatically driven carbon-steel fasteners; or self-drilling, self-threading screws.
- C. Side-Lap Fasteners: Corrosion-resistant, hexagonal washer head; self-drilling, carbon-steel screws, No. 10 minimum diameter or as indicated.
- D. Column Closures, End Closures, Z-Closures, and Cover Plates: Steel sheet, of same material, finish, and thickness as deck, unless otherwise indicated.
- E. Pour Stops and Girder Fillers: Steel sheet, minimum yield strength of 33,000 psi, of same material and finish as deck, and of thickness and profile recommended by SDI Publication No. 29 for overhang and slab depth.
- F. Flexible Closure Strips: Vulcanized, closed-cell, synthetic rubber.
- G. Miscellaneous Sheet Metal Deck Accessories: Steel sheet, minimum yield strength of 33,000 psi, not less than 0.0359-inch design uncoated thickness, of same material and finish as deck; of profile indicated or required for application.
- H. Flat Receiver Pans: Manufacturer's standard size, single-piece steel sheet, 0.071-inch-thick minimum units, of same material as deck panels. Cut holes for drains in the field.
- I. Repair Paint: Manufacturer's standard rust-inhibitive primer of same color as primer.
- J. Galvanizing Repair Paint: SSPC-Paint 20 or DOD-P-21035, with dry film containing a minimum of 94 percent zinc dust by weight.

PART 3 - EXECUTION

3.1 EXAMINATION

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

3.2 INSTALLATION - GENERAL

- A. Install deck panels and accessories according to applicable specifications and commentary in SDI Publication No. 30, manufacturer's written instructions, requirements in this Section, and as indicated.
- B. Install temporary shoring before placing deck panels, if required to meet deflection limitations.
- C. Locate decking bundles to prevent overloading of supporting members.
- D. Place deck panels on supporting frame and adjust to final position with ends accurately aligned and bearing on supporting frame before being permanently fastened. Do not stretch or contract side-lap interlocks.
- E. Place deck panels flat and square and fasten to supporting frame without warp or deflection.
- F. Cut and neatly fit deck panels and accessories around openings and other work projecting through or adjacent to deck.
- G. Provide additional reinforcement and closure pieces at openings as required for strength, continuity of deck, and support of other work.

- H. Comply with AWS requirements and procedures for manual shielded metal arc welding, appearance and quality of welds, and methods used for correcting welding work.
- I. End Bearing: Install deck ends over supporting frame with a minimum end bearing of 1-1/2 inches.

3.3 ROOF DECK INSTALLATION

- A. Fasten roof deck panels to steel supporting members as indicated, and fasten side laps of panel edges as indicated, as required to develop the minimum diaphragm shear indicated on the Drawings and as follows:
 - 1. Connector Spacing: As indicated.
 - 2. Side Lap Fastening: As indicated.
- B. End Bearing: Install deck ends over supporting framing with a minimum end bearing of 1-1/2 inches, with end joints lapped 2 inches minimum. Lap in direction to shed water where applicable.
- C. Roof Sump Plates: Install over openings provided in roof decking, and weld flanges to top of deck. Space welds not more than 12 inches apart with at least one weld at each corner.
- D. Miscellaneous Roof Deck Accessories: Install ridge and valley plates, finish strips, cover plates, end closures, and reinforcing channels according to deck manufacturer's recommendations. Weld to substrate to provide a complete deck installation.
 - 1. Provide deck closures at all roof penetrations to prevent building air from infiltrating space above deck.
- E. Flexible Closure Strips: Install flexible closure strips over partitions, walls, and where indicated. Install with adhesive according to manufacturer's instructions to ensure complete closure.

3.4 FLOOR DECK INSTALLATION

- A. Fasten floor deck panels to steel supporting members as indicated of the surface diameter indicated and as follows:
 - 1. Connector Spacing: As indicated.
 - 2. Side Lap Fastening: As indicated.
- B. Side-Lap and Perimeter Edge Fastening: Fasten side laps and perimeter edges of panels between supports, at intervals not exceeding the lesser of 1/2 of the span or 36 inches, and as follows:
 - 1. As indicated per structural drawings.
- C. End Bearing: Install deck ends over supporting frame with a minimum end bearing of 2 inches, with end joints as follows:
 - 1. End Joints: Lapped.
- D. Pour Stops and Girder Fillers: Weld steel sheet pour stops and girder fillers to supporting structure according to SDI recommendations, unless otherwise indicated.
- E. Floor Deck Closures: Weld steel sheet column closures, cell closures, and Z-closures to deck, according to SDI recommendations, to provide tight-fitting closures at open ends of ribs and

sides of decking. Weld cover plates at changes in direction of floor deck panels, unless otherwise indicated.

3.5 FIELD QUALITY CONTROL

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

3.6 REPAIRS

- A. Galvanizing Repairs: At the end of each day's work, prepare and repair damaged galvanized coatings on both surfaces of deck with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Repair Painting: Wire brush and clean rust spots, welds, and abraded areas on surfaces of prime-painted deck immediately after installation, and apply repair paint.

END OF SECTION 053100

SECTION 054000 - COLD-FORMED METAL FRAMING

PART 1 - GENERAL

1.1 SCOPE OF WORK

- A. The work required under this heading shall include all labor, materials, tools, equipment and services necessary for and reasonably incidental to the fabrication and delivery to site as shown on the drawings and/or as herein specified.

1.2 RELATED DOCUMENTS

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

1.3 SUMMARY

- A. This Section includes the following:
 - 1. Exterior non-load-bearing wall framing.
- B. Related Sections include the following:
 - 1. Division 5 Section "Metal Fabrications" for masonry shelf angles and connections.
 - 2. Division 9 Section "Non-Structural Metal Framing" for interior non-load-bearing metal-stud framing and ceiling-suspension assemblies.
 - 3. Section 012100 "Allowances" for Quality Control Services Testing and Inspection allowances for Owner specified or indicated Testing and Inspections.

1.4 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 indicated on Structural Drawings, but not less than required by prevailing Building Code.
 - 2. Deflection Limits: Design framing systems to withstand design loads without deflections greater than the following:
 - a. Exterior Non-Load-Bearing Framing: Horizontal deflection of 1/600 of the wall height.
 - 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-inch.

5. Design exterior non-load-bearing curtain-wall framing to accommodate horizontal deflection without regard for contribution of sheathing materials.

B. Engineering Responsibility: Engage a fabricator who assumes undivided responsibility for engineering cold-formed metal framing by employing a qualified professional engineer to prepare design calculations, shop drawings, and other structural data.

1.5 SUBMITTALS

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

B. Shop Drawings: Show layout, spacings, sizes, thicknesses, and types of cold-formed metal framing; fabrication; and fastening and anchorage details, including mechanical fasteners.

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.

C. Welding certificates.

D. Qualification data.

E. Product test reports.

F. Research/evaluation reports.

1.6 QUALITY ASSURANCE

A. Product Tests: Mill certificates or data from a qualified independent testing agency indicating steel sheet complies with requirements.

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

C. 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.

D. 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."

PART 2 - PRODUCTS

2.1 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 or approved equivalent.

2.2 EXTERIOR NON-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: 0.0566 inch (16 Ga). or as indicated on drawings.
 - 2. Flange Width: 1-5/8 inches, or as indicated on drawings.
- B. Steel Track: Manufacturer's standard U-shaped steel track, of web depths indicated, unpunched, with unstiffened flanges, and same minimum base-metal thickness as steel studs.
 - 1. Minimum Base-Metal Thickness: 0.0566 inch (16 Ga). or as indicated on drawings.
 - 2. Flange Width: 1-1/4 inches, or as indicated on drawings.
- C. Allow for alternative valued engineered opening framing systems
RedHeader RO System manufactured by ClarkWestern Building Systems. (Designed to provide an opening alternative system for conventional interior framing and/or exterior curtain wall built-up header and jamb framing by reducing labor and components up to 50 percent)
 - 1. Exterior systems are subject to requirements of code evaluation reports and/or shop drawings with engineering calculations signed and sealed by a registered PE (Professional Engineer).
 - 2. Minimum Material Thickness: As required by design
 - 3. Minimum Flange Width: As required by design
 - 4. Equivalent Products
 - a. Dietrich HDS
 - b. Brady Pro X
 - c. TSN Jamb Stud
- D. Vertical Deflection Clips: Manufacturer's standard bypass or head clips, capable of accommodating upward and downward vertical displacement of primary structure through positive mechanical attachment to stud web.

2.3 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, unless otherwise indicated.
- B. Steel Shapes and Clips: ASTM A 36/A 36M, zinc coated by hot-dip process according to ASTM A 123/A 123M.
- C. Double Deflection Tracks: Manufacturer's double, deep-leg, U-shaped steel tracks, consisting of nested inner and outer tracks; unpunched, with unstiffened flanges.
- D. Cast-in-Place Anchor Bolts and Studs: ASTM A 307, Grade A; carbon-steel hex-head bolts and studs; carbon-steel nuts; and flat, unhardened-steel washers. Zinc coated by the hot-dip process according to ASTM A 153. Expansion Anchors (where approved for use by Structural Engineer): 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.

- F. Power-Actuated Anchors (where approved for use by Structural Engineer): 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.
- G. 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.

2.4 MISCELLANEOUS MATERIALS

- A. Galvanizing Repair Paint: SSPC-Paint 20 or DOD-P-21035, with dry film containing a minimum of 94 percent zinc dust by weight. 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. Shims: Load bearing, high-density multimonomer plastic, nonleaching.
- D. 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.
- E. Welding Electrodes: Comply with AWS standards.

PART 3 - EXECUTION

3.1 PREPARATION

- A. 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.
- B. 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.

3.2 INSTALLATION, GENERAL

- A. 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.
- B. 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. With acceptance of Architect, screw fastening may be permitted. Wire tying of framing members is not permitted.
 - a. Comply with AWS requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.

- C. Install framing members in one-piece lengths.
- D. 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.
- E. Do not bridge building expansion and control joints with cold-formed metal framing. Independently frame both sides of joints.
- F. Install insulation, specified in Division 7 Section "Building 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.
- G. Fasten hole reinforcing plate over web penetrations that exceed size of manufacturer's standard punched openings.
- H. 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.

3.3 EXTERIOR NON-LOAD-BEARING WALL INSTALLATION

- A. Install continuous tracks sized to match studs. Align tracks accurately and securely anchor to supporting structure.
- B. Fasten both flanges of studs to top and bottom track unless otherwise indicated. Space studs as follows:
 - 1. Stud Spacing: 16 inches or as indicated on 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 deep-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 studs and anchor to building structure.
 - 4. Connect drift clips to cold-formed steel metal framing and anchor to building structure.
- E. Install horizontal bridging in wall studs, spaced vertically in rows indicated on Shop Drawings but not more than 48 inches apart. Fasten at each stud intersection.
 - 1. Channel Bridging: Cold-rolled steel channel, welded or mechanically fastened to webs of punched studs.
 - 2. Strap 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. Bar Bridging: Proprietary bridging bars installed according to manufacturer's written instructions.

- F. Top Bridging for Single Deflection Track: Install row of horizontal bridging within **18 inches** of single deflection track. Install a combination of bridging and stud or stud-track solid blocking of width and thickness matching studs, secured to stud webs or flanges.
 - 1. Install solid blocking at centers indicated on Shop Drawings.
- G. Install miscellaneous framing and connections, including stud kickers, web stiffeners, clip angles, continuous angles, anchors, and fasteners, to provide a complete and stable wall-framing system.

3.4 FIELD QUALITY CONTROL

- A. Testing: Owner may 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.

3.5 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 RELATED DOCUMENTS

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

1.2 SUMMARY

- A. Section Includes:
 - 1. Steel framing and supports for overhead doors.
 - 2. Steel framing and supports for countertops.
 - 3. Steel framing and supports for mechanical and electrical equipment.
 - 4. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 - 5. Shelf angles.
 - 6. Metal bollards.
 - 7. Loose bearing and leveling plates for applications where they are not specified in other Sections.
- B. Products furnished, but not installed, under this Section include the following:
 - 1. Loose steel lintels.
 - 2. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
 - 3. Steel weld plates and angles for casting into concrete for applications where they are not specified in other Sections.
- C. Related Requirements:
 - 1. Section 042000 "Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
 - 2. Section 051200 "Structural Steel Framing" for steel framing, supports, elevator machine beams, hoist beams, divider beams, door frames, and other steel items attached to the structural-steel framing.

1.3 COORDINATION

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

1.4 ACTION SUBMITTALS

- A. Product Data: For the following:
 - 1. Fasteners.
 - 2. Shop primers.
 - 3. Shrinkage-resisting grout.
 - 4. Metal bollards.

- 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. Steel framing and supports for overhead doors.
 - 2. Steel framing and supports for countertops.
 - 3. Steel framing and supports for mechanical and electrical equipment.
 - 4. Shelf angles.
 - 5. Metal bollards.
 - 6. Loose steel lintels.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For professional engineer's experience with providing delegated-design engineering services of the kind indicated, including documentation that engineer is licensed in the jurisdiction in which Project is located.

- B. Welding certificates.

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

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel in accordance with the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.7 FIELD CONDITIONS

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

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. 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.

2.2 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 A36/A36M.
- C. Steel Tubing: ASTM A500/A500M, cold-formed steel tubing.
- D. Steel Pipe: ASTM A53/A53M, Standard Weight (Schedule 40) unless otherwise indicated.

2.3 FASTENERS

- A. General: Unless otherwise indicated, provide Type 304 stainless steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B633 or ASTM F1941, Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.
 - 1. Provide stainless steel fasteners for fastening stainless steel.
- B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A307, Grade A; with hex nuts, ASTM A563; and, where indicated, flat washers.
- C. High-Strength Bolts, Nuts, and Washers: ASTM F3125, Grade A325, Type 3, heavy-hex steel structural bolts; ASTM A563, Grade DH3, heavy-hex carbon-steel nuts; and where indicated, flat washers.
- D. Stainless Steel Bolts and Nuts: Regular hexagon-head annealed stainless steel bolts, ASTM F593; with hex nuts, ASTM F594; and, where indicated, flat washers; Alloy Group 1 (A1).
- E. Anchor Bolts: ASTM F1554, Grade 36, of dimensions indicated; with nuts, ASTM A563 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. Anchors, General: 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 in accordance with ASTM E488, conducted by a qualified independent testing agency.
- G. Cast-in-Place Anchors in Concrete: Either threaded or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A47 malleable iron or ASTM A27 cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F2329.
- H. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B633 or ASTM F1941, 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 F593, and nuts, ASTM F594.

2.4 MISCELLANEOUS MATERIALS

- A. Shop Primers: Provide primers that comply with Section 099113 "Exterior Painting," and Section 099123 "Interior Painting."

- B. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.
- C. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- D. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- E. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D1187.
- F. Shrinkage-Resistant Grout: Factory-packaged, nonmetallic, nonstaining, noncorrosive, nongaseous grout complying with ASTM C1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- G. 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 3000 psi.

2.5 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in the shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
- B. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- C. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- D. Form exposed work with accurate angles and surfaces and straight edges.
- E. Weld corners and seams continuously to comply with the following:
 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 2. Obtain fusion without undercut or overlap.
 3. Remove welding flux immediately.
 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- F. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners or welds where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) fasteners unless otherwise indicated. Locate joints where least conspicuous.
- G. Fabricate seams and other connections that are exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- H. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- I. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
- J. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches, with a minimum 6-inch embedment and 2-inch

hook, not less than 8 inches from ends and corners of units and 24 inches o.c., unless otherwise indicated.

2.6 SHELF ANGLES

- A. Fabricate shelf angles from steel angles of sizes indicated and for attachment to concrete framing. Provide horizontally slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and 24 inches o.c., unless otherwise indicated.
 - 1. Provide mitered and welded units at corners.
 - 2. Provide open joints in shelf angles at expansion and control joints. Make open joint approximately 2 inches larger than expansion or control joint.
- B. For cavity walls, provide vertical channel brackets to support angles from backup masonry and concrete.
- C. Galvanize and prime shelf angles located in exterior walls.
- D. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.

2.7 MISCELLANEOUS STEEL TRIM

- A. Unless otherwise indicated, fabricate units from steel shapes, plates, and bars of profiles shown with continuously welded joints and smooth exposed edges. Miter corners and use concealed field splices where possible.
- B. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work.
 - 1. Provide with integrally welded steel strap anchors for embedding in concrete or masonry construction.
- C. Galvanize and prime exterior miscellaneous steel trim.

2.8 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 40 steel pipe, as indicated.
 - 1. Cap bollards with 1/4-inch-thick, steel plate with flat top, unless indicated otherwise.
- B. Prime steel bollards.

2.9 LOOSE BEARING AND LEVELING PLATES

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

2.10 LOOSE STEEL LINTELS

- A. Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated. Fabricate in single lengths for each opening unless otherwise indicated. Weld adjoining members together to form a single unit where indicated.
- B. Size loose lintels to provide bearing length at each side of openings equal to 1/12 of clear span, but not less than 8 inches unless otherwise indicated.
- C. Galvanize and prime loose steel lintels located in exterior walls.

2.11 GENERAL FINISH REQUIREMENTS

- 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.

2.12 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A153 for steel and iron hardware and with ASTM A123 for other steel and iron products.
 - 1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.
- B. Preparation for Shop Priming Galvanized Items: After galvanizing, thoroughly clean galvanized surfaces of grease, dirt, oil, flux, and other foreign matter, and treat with metallic phosphate process.
- C. 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 primers compatible or as specified in Section 099113 "Exterior Painting" and in Section 099123 "Interior Painting" indicated.
- D. Preparation for Shop Priming: Prepare surfaces to comply with SSPC-SP 3, "Power Tool Cleaning," or requirements indicated below:
 - 1. Exterior Items: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 2. Items Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 3. Other Steel Items: SSPC-SP 3, "Power Tool Cleaning."
 - 4. Galvanized-Steel Items: SSPC-SP 16, "Brush-off Blast Cleaning of Coated and Uncoated Galvanized Steel, and Non-Ferrous Metals."
- E. Shop Priming: Apply shop primer to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.
 - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- B. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- C. Field Welding: Comply with the following requirements:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.
 - 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- D. Fastening to In-Place Construction: Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction. Provide threaded fasteners for use with concrete and masonry inserts, toggle bolts, through bolts, lag screws, wood screws, and other connectors.
- E. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.

3.2 INSTALLATION OF METAL BOLLARDS

- A. Anchor bollards in place with concrete footings not less than 42 inches deep. Center and align bollards in holes 3 inches above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace bollards in position until concrete has cured.
- B. Fill bollards solidly with concrete, mounding top surface to shed water.

3.3 INSTALLATION OF 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 shrinkage-resistant grout. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.4 REPAIRS

- A. Touchup Painting:

1. Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded areas with same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.
 - a. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.
 2. Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint.
- B. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A780.

END OF SECTION 055000

SECTION 055113 - METAL PAN 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.
- B. Section 057300 "Decorative Metal Railings"

1.2 SUMMARY

- A. Section Includes:
 - 1. Preassembled steel stairs for concrete-filled treads, designed as indicated on drawings.
 - 2. Steel pipe/bar railings attached to metal stairs, as indicated on drawings.
 - 3. Steel pipe handrails attached to walls adjacent to metal stairs, as indicated on drawings.

1.3 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages for metal stairs and railings.
 - 1. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, blocking for attachment of wall-mounted handrails, and items with integral anchors, that are to be embedded in concrete or masonry.
 - 2. Deliver such items to Project site in time for installation.
- C. Schedule installation of railings so wall attachments are made only to completed walls.
 - 1. Do not support railings temporarily by any means that do not satisfy structural performance requirements.

1.4 ACTION SUBMITTALS

- A. Shop Drawings:
 - 1. Include plans, elevations, sections, details, and attachments to other work.
 - 2. Indicate sizes of metal sections, thickness of metals, profiles, holes, and field joints.
 - 3. Include plan at each level.
 - 4. Indicate locations of anchors, weld plates, and blocking for attachment of wall-mounted handrails.
- B. Delegated-Design Submittal: For stairs, railings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

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.

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 - 2. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Store materials to permit easy access for inspection and identification.
 - 1. Keep steel members off ground and spaced by using pallets, dunnage, or other supports and spacers.
 - 2. Protect steel members and packaged materials from corrosion and deterioration.
 - 3. Do not store materials on structure in a manner that might cause distortion, damage, or overload to members or supporting structures.
 - a. Repair or replace damaged materials or structures as directed.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, to design stairs, railings, including attachment to building construction.
- 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, per the IBC 2015 Code, and indicated:
 - 1. Uniform Load: 100 lbf/sq. ft.
 - 2. Concentrated Load: 300 lbf applied on an area of 4 sq. in.
 - 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, whichever is less.
- C. Structural Performance of Railings: Railings, including attachment to building construction, shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions, per IBC 2015 Code, and indicated:
 - 1. Handrails and Top Rails of Guards:
 - a. Uniform load of 50 lbf/ft. applied in any direction.
 - b. Concentrated load of 200 lbf 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 applied horizontally on an area of 1 sq. ft..
- b. Infill load and other loads need not be assumed to act concurrently.

2.2 METALS

- A. Metal Surfaces: Provide materials with smooth, flat surfaces unless otherwise indicated. For components exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.
- B. Steel Plates, Shapes, and Bars: ASTM A36.
- C. Steel Pipe for Railings: ASTM A53, Type F or Type S, Grade A, Standard Weight (Schedule 40), unless another grade and weight are required by structural loads.
- D. Uncoated, Cold-Rolled Steel Sheet: ASTM A1008 either commercial steel, Type B, or structural steel, Grade 25 (Grade 170), unless another grade is required by design loads; exposed.
- E. Uncoated, Hot-Rolled Steel Sheet: ASTM A1011 either commercial steel, Type B, or structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.
- F. Expanded-Metal, Carbon Steel: ASTM F1267, Type I (expanded) Type II (expanded and flattened), Class 1 (uncoated).
- G. Wire Mesh: Intermediate-crimp, diamond or square pattern, 2-inch woven-wire mesh, made from 0.135-inch nominal-diameter steel wire complying with ASTM A510/A510M.
- H. Cast Iron: Either gray iron, ASTM A48, or malleable iron, ASTM A47, unless otherwise indicated.

2.3 FASTENERS

- A. Fasteners for Anchoring Railings to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated and capable of withstanding design loads.
- B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A307, Grade A; with hex nuts, ASTM A563; and, where indicated, flat washers.
- C. Anchor Bolts: ASTM F1554, Grade 36, of dimensions indicated; with nuts, ASTM A563; and, where indicated, flat washers.
- D. 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 E488, 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.

2.4 MISCELLANEOUS MATERIALS

- A. Welding Electrodes: Comply with AWS requirements.
- B.

2.5 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. Assemble stairs and railings in shop to greatest extent possible.
 - 1. Disassemble units only as necessary for shipping and handling limitations.
 - 2. Clearly mark units for reassembly and coordinated installation.
- C. Cut, drill, and punch metals cleanly and accurately.
 - 1. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated.
 - 2. 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 Finish #1 - No evidence of welded joint.
- G. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible.
 - 1. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts unless otherwise indicated.
 - 2. Locate joints where least conspicuous.

2.6 FABRICATION OF STEEL-FRAMED STAIRS

- A. Stair Framing:
 - 1. Fabricate stringers of steel plates or steel channels or steel rectangular tubes as indicated on Drawings.
 - a. Stringer Size: As required to comply with "Performance Requirements" Article.
 - b. Provide closures for exposed ends of channel and rectangular tube stringers.
 - c. Finish: Shop primed.
 - 2. Construct platforms of steel plate or channel or rectangular tube headers and miscellaneous framing members as [required to comply with "Performance Requirements" Article and indicated on Drawings].
 - a. Provide closures for exposed ends of channel and rectangular tube framing.

- b. Finish: Shop primed.
- 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.
- B. 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: Uncoated, cold hot-rolled steel sheet, unless otherwise indicated.
 - 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. Attach risers and subtreads to stringers with brackets made of steel angles or bars. Weld brackets to stringers and attach metal pans to brackets by welding, riveting, or bolting.
 - 4. Shape metal pans to include nosing integral with riser.
 - 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.

2.7 FINISHES

- A. Blacking patina:
 - 1. After fabrication, prepare railings for blacking patina: use fine abrasives to prepare exposed surfaces and thoroughly clean railings of grease, dirt, oil, flux, and other foreign matter.
 - 2. Apply blacking patina to prepared surfaces of railings unless otherwise indicated, including hardware.
 - 3. Topcoat: apply lacquer or polyurethane topcoat as recommended by blacking patina manufacturer.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Verify elevations of floors, bearing surfaces and locations of bearing plates, and other embedments for compliance with requirements.
 - 1. For wall-mounted railings, verify locations of concealed reinforcement within gypsum board and plaster assemblies.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLING METAL PAN STAIRS

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction.
 - 1. 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. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- D. Fit exposed connections accurately together to form hairline joints.
 - 1. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations.
 - 2. 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.
 - 3. Comply with requirements for welding in "Fabrication, General" Article.
- E. Place and finish concrete fill for treads and platforms to comply with Section 033000 "Cast-in-Place Concrete."

END OF SECTION 055113

SECTION 057300 - DECORATIVE METAL RAILINGS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

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

1.2 SUMMARY

- A. Section Includes:
 - 1. Steel and iron decorative railings.
- B. Related Requirements:
 - 1. Section 061053 "Miscellaneous Rough Carpentry" for wood blocking for anchoring railings.
 - 2. Section 092216 "Non-Structural Metal Framing" for metal backing for anchoring railings.

1.3 DEFINITIONS

- A. Railings: Guards, handrails, and similar devices used for protection of occupants at open-sided floor areas and for pedestrian guidance and support, visual separation, or wall protection.

1.4 COORDINATION AND SCHEDULING

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible.
- B. Coordinate installation of anchorages for railings. 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 items to Project site in time for installation.
- C. Schedule installation so wall attachments are made only to completed walls. Do not support railings temporarily by any means that do not meet structural performance requirements.

1.5 ACTION SUBMITTALS

- A. Shop Drawings: Include plans, elevations, sections, and attachment details.
- B. Samples for Initial Selection: For products involving selection of color, texture, or design.
- C. Samples for Verification: For each type of exposed finish required.
 - 1. Sample of wood guardrail cap.
 - 2. Sample of steel blackening patina, minimum 7"x7"

- D. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.6 QUALITY ASSURANCE

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

1.7 FIELD CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with railings by field measurements before fabrication and indicate measurements on Shop Drawings.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Source Limitations: Obtain each type of railing from single source from single manufacturer.
- B. Product Options: Information on Drawings and in Specifications establishes requirements for system's aesthetic effects and performance characteristics. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction. Performance characteristics are indicated by criteria subject to verification by one or more methods, including structural analysis, preconstruction testing, field testing, and in-service performance.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design railings, including attachment to building construction.
- B. General: In engineering railings to withstand structural loads indicated, determine allowable design working stresses of railing materials based on the following:
 - 1. Steel: 72 percent of minimum yield strength.
- C. Structural Performance: Railings, including attachment to building construction, shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Handrails and Top Rails of Guards:
 - a. Uniform load of 50 lbf/ft. (0.73 kN/m) applied in any direction.
 - b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.

2. Infill of Guards:
 - a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
 - b. Infill load and other loads need not be assumed to act concurrently.
- D. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior railings 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.

2.3 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth surfaces, without seam marks, roller marks, rolled trade names, stains, discolorations, or blemishes.
- B. Brackets, Flanges, and Anchors: Same metal and finish as supported rails unless otherwise indicated.
 1. Provide cast-metal brackets with flange tapped for concealed anchorage to threaded hanger bolt.
 2. Provide either formed- or cast-metal brackets with predrilled hole for exposed bolt anchorage.

2.4 STEEL AND IRON

- A. Tubing: [ASTM A500/A500M (cold formed)] [or] [ASTM A513].
- B. Bars: Hot-rolled, carbon steel complying with ASTM A29/A29M, Grade 1010.
- C. Plates, Shapes, and Bars: ASTM A36/A36M.

2.5 FASTENERS

- A. Fastener Materials: Unless otherwise indicated, provide the following:
 1. Uncoated Steel Components: Plated-steel fasteners complying with ASTM B633, Class Fe/Zn 25 for electrodeposited zinc coating where concealed; Type 304 stainless-steel fasteners where exposed.
- B. Fasteners for Anchoring to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated and capable of withstanding design loads.
- C. Provide concealed fasteners for interconnecting railing components and for attaching railings to other work unless exposed fasteners are unavoidable.
 1. Provide Phillips, square or hex socket flat-head machine screws for exposed fasteners unless otherwise indicated.

- D. Post-Installed Anchors: Fastener systems with working capacity greater than or equal to the design load, according to an evaluation report acceptable to authorities having jurisdiction, based on ICC-ES AC193 or ICC-ES AC308.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B633 or ASTM F1941 (ASTM F1941M), Class Fe/Zn 5, unless otherwise indicated.

2.6 MISCELLANEOUS MATERIALS

- A. Wood Rails: Clear, straight-grained hardwood rails secured exposed metal subrail.
 - 1. Species: Hard White Maple
 - 2. Finish: Manufacturer's standard transparent finish.
 - 3. Staining: None.
 - 4. Profile: As indicated, with eased edges.
- B. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
 - 1. For aluminum railings, provide type and alloy as recommended by producer of metal to be welded and as required for color match, strength, and compatibility in fabricated items.

2.7 FABRICATION

- A. General: Fabricate railings to comply with requirements indicated for design, dimensions, member sizes and spacing, details, finish, and anchorage, but not less than that required to support structural loads.
- B. Assemble railings in the shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation. Use connections that maintain structural value of joined pieces.
- 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 work true to line and level with accurate angles and surfaces.
- E. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.
- F. Connections: Fabricate railings with welded connections unless otherwise indicated.
- G. 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. 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 flux immediately.
 - 4. 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.
- H. Close exposed ends of hollow railing members with prefabricated end fittings.

- I. 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.
- J. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work unless otherwise indicated.
 - 1. At brackets and fittings fastened to plaster or gypsum board partitions, provide crush-resistant fillers, or other means to transfer loads through wall finishes to structural supports and to prevent bracket or fitting rotation and crushing of substrate.
- K. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work. Fabricate anchorage devices capable of withstanding loads imposed by railings. Coordinate anchorage devices with supporting structure.

2.8 GENERAL FINISH REQUIREMENTS

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" recommendations for applying and designating finishes.
- B. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipment.
- C. Appearance of Finished Work: Noticeable variations in same piece are not acceptable. Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.
- D. Provide exposed fasteners with finish matching appearance, including color and texture, of railings.

2.9 STEEL AND IRON FINISHES

- A. Blacking patina:
 - 1. After fabrication, prepare railings for blacking patina: use fine abrasives to prepare exposed surfaces and thoroughly clean railings of grease, dirt, oil, flux, and other foreign matter.
 - 2. Apply blacking patina to exposed and prepared surfaces of railings unless otherwise indicated, including hardware.
 - 3. Topcoat: apply lacquer or polyurethane topcoat as recommended by blacking patina manufacturer.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine plaster and gypsum board assemblies, where reinforced to receive anchors, to verify that locations of concealed reinforcements have been clearly marked for Installer. Locate reinforcements and mark locations if not already done.

3.2 INSTALLATION, GENERAL

- A. Fit exposed connections together to form tight, hairline joints.
- B. Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.
 - 1. Do not weld, cut, or abrade surfaces of railing components that have been coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
 - 2. Set posts plumb within a tolerance of 1/16 inch in 3 feet (2 mm in 1 m).
 - 3. 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 (5 mm in 3 m).
- C. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.
- D. Adjust railings before anchoring to ensure matching alignment at abutting joints.
- E. Fastening to In-Place Construction: Use anchorage devices and fasteners where necessary for securing railings and for properly transferring loads to in-place construction.

3.3 RAILING CONNECTIONS

- A. Nonwelded Connections: Use mechanical or adhesive joints for permanently connecting railing components. Use wood blocks and padding to prevent damage to railing members and fittings. Seal recessed holes of exposed locking screws using plastic cement filler colored to match finish of railings.
- B. Welded Connections: Use fully welded joints for permanently connecting railing components. Comply with requirements for welded connections in "Fabrication" Article whether welding is performed in the shop or in the field.
- C. Expansion Joints: Install expansion joints at locations indicated but not farther apart than required to accommodate thermal movement. Provide slip-joint internal sleeve extending 2 inches (50 mm) beyond joint on either side, fasten internal sleeve securely to one side, and locate joint within 6 inches (150 mm) of post.

3.4 ANCHORING POSTS

- A. Anchor guardrail and handrail assemblies as indicated on drawings.

3.5 ATTACHING RAILINGS

- A. Anchor railing ends to concrete with flanges connected to railing ends and anchored to construction with anchors and bolts.
- B. Anchor railing ends to metal surfaces with flanges bolted to metal surfaces and welded to railing ends.
- C. Attach handrails to walls with wall brackets except where end flanges are used. Provide brackets 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.

1. Use type of bracket with predrilled hole for exposed bolt anchorage.
2. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads.

D. Secure wall brackets and railing end flanges to building construction as follows:

1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
2. For steel-framed partitions, use hanger or lag bolts set into wood backing between studs. Coordinate with stud installation to locate backing members.

3.6 FIELD QUALITY CONTROL

- A. Extent and Testing Methodology: Testing agency will randomly select completed railing assemblies for testing that are representative of different railing designs and conditions in the completed Work. Test railings according to ASTM E894 and ASTM E935 for compliance with performance requirements.
- B. Remove and replace railings where test results indicate that they do not comply with specified requirements unless they can be repaired in a manner satisfactory to Architect and comply with specified requirements.
- C. Perform additional testing and inspecting, at Contractor's expense, to determine compliance of replaced or additional work with specified requirements.

3.7 CLEANING

- A. Clean aluminum and stainless steel by washing thoroughly with clean water and soap, rinsing with clean water, and wiping dry.
- B. Clean copper alloys according to metal finisher's written instructions in a manner that leaves an undamaged and uniform finish matching approved Sample.
- C. Clean and polish materials as recommended in writing by manufacturer. Wash both exposed surfaces in each area of Project not more than four days before date scheduled for inspections that establish date of Substantial Completion.
- D. Clean wood rails by wiping with a damp cloth and then wiping dry.

3.8 PROTECTION

- A. Protect finishes of railings from damage during construction period with temporary protective coverings approved by railing manufacturer. Remove protective coverings at time of Substantial Completion.
- B. Restore finishes damaged during installation and construction period so no evidence remains of correction work. Return items that cannot be refinished in the field to the shop; make required alterations and refinish entire unit, or provide new units.

END OF SECTION 057300

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