

SECTION 05 50 00 - METAL FABRICATIONS

PART 1 - GENERAL

1.1 SUMMARY

- A. This Section includes the following:
 - 1. Miscellaneous steel framing and supports.
 - 2. Prefabricated building columns.
 - 3. Shelf angles.
 - 4. Loose bearing and leveling plates.
 - 5. Steel weld plates and angles.
 - 6. Structural-steel door frames.
 - 7. Miscellaneous steel trim.
 - 8. Metal ladders and safety cages.
 - 9. Metal bollards.
 - 10. Pipe guards.
 - 11. Bicycle racks.
 - 12. Metal floor plate and supports.
 - 13. Abrasive metal nosings, treads and thresholds.
 - 14. Loose steel lintels.

1.2 SUBMITTALS

- A. Product Data: For the following:
 - 1. Prefabricated building columns.
 - 2. Metal nosings and treads.
 - 3. Grout.
- B. Shop Drawings: Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
- C. Structural calculations: for all items anchored to structure, submit structural calculations and drawings.
- D. Templates: For anchors and bolts.
- E. Samples: For each type and finish of extruded nosing and tread.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. In other Part 2 articles where titles below introduce lists, the following requirements apply to product selection:
1. Products: Subject to compliance with requirements, provide one of the products specified.
 2. Manufacturers: Subject to compliance with requirements, provide products by one of the manufacturers specified.

2.2 METALS

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces without blemishes.
- B. Ferrous Metals:
1. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
 2. Stainless-Steel Bars and Shapes: ASTM A 276, Type 304.
 3. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
 4. Rolled-Stainless-Steel Floor Plate: ASTM A 793.
 5. Abrasive-Surface Floor Plate: Steel plate with abrasive granules rolled into surface or with abrasive material metallurgically bonded to steel by a proprietary process.
 - a. Products:
 - 1) IKG Industries, a Harsco company; Mebac.
 - 2) W. S. Molnar Company; SlipNOT.
 6. Steel Tubing: ASTM A 500, cold-formed steel tubing.
 7. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
 8. Slotted Channel Framing: Cold-formed metal channels complying with MFMA-3, 1-5/8 by 1-5/8 inches. Channels made from galvanized steel complying with ASTM A 653/A 653M, structural steel, Grade 33, with G90 coating; 0.079-inch nominal thickness.
 9. Cast Iron: ASTM A 48/A 48M, Class 30, unless another class is indicated or required by structural loads.
 10. Galvanizing: hot dipped to G60 class coating.
- C. Nonferrous Metals:
1. Aluminum Extrusions: ASTM B 221, alloy 6063-T6.
 2. Aluminum-Alloy Rolled Tread Plate: ASTM B 632/B 632M, alloy 6061-T6.
 3. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

2.3 FASTENERS

- A. General: Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 5, at exterior walls. Provide stainless-steel fasteners for fastening aluminum. Select fasteners for type, grade, and class required.
- B. Cast-in-Place Anchors in Concrete: Threaded or wedge type; galvanized ferrous castings, either ASTM A 47/A 47M malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, hot-dip galvanized per ASTM A 153/A 153M.

2.4 MISCELLANEOUS MATERIALS

- A. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI #79.
- B. Zinc-Rich Primer: Complying with SSPC-Paint 20 or SSPC-Paint 29 and compatible with topcoat.
 - 1. Products:
 - a. Benjamin Moore & Co.; Epoxy Zinc-Rich Primer CM18/19.
 - b. Carboline Company; Carbozinc 621.
 - c. ICI Devoe Coatings; Catha-Coat 313.
 - d. International Coatings Limited; Interzinc 315 Epoxy Zinc-Rich Primer.
 - e. PPG Ownerural Finishes, Inc.; Aquapon Zinc-Rich Primer 97-670.
 - f. Sherwin-Williams Company (The); Corothane I GalvaPac Zinc Primer.
 - g. Tnemec Company, Inc.; Tneme-Zinc 90-97.
- C. Galvanizing Repair Paint: SSPC-Paint 20, high-zinc-dust-content paint for regalvanizing welds in steel.
- D. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107.
- E. Concrete Materials and Properties: Comply with requirements in Division 03 Section "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi, unless otherwise indicated.

2.5 FABRICATION

- A. General: Preassemble items in the shop to greatest extent possible. Use connections that maintain structural value of joined pieces.
 - 1. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges. Remove sharp or rough areas on exposed surfaces.
 - 2. Weld corners and seams continuously. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals. Obtain fusion without undercut or overlap. Remove welding flux immediately. Finish exposed welds smooth and blended.

3. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Locate joints where least conspicuous.
 4. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
 5. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, not less than 24 inches o.c.
- B. Miscellaneous Framing and Supports: Provide steel framing and supports not specified in other Sections as needed to complete the Work. Fabricate units from steel shapes, plates, and bars of welded construction. Cut, drill, and tap units to receive hardware, hangers, and similar items.
1. Fabricate steel girders for wood frame construction from continuous steel shapes. Where wood nailers are attached to girders with bolts or lag screws, drill holes at 24 inches o.c.
 2. Fabricate steel pipe columns for supporting wood frame construction with steel baseplates and top plates welded to pipe with fillet welds the same size as pipe wall thickness.
- C. Loose Steel Lintels: Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.
1. Lintels in Exterior Walls: hot dip galvanize.
- D. Shelf Angles: Fabricate shelf angles of sizes indicated and for attachment to framing. Fabricate with horizontally slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and 24 inches o.c.
1. Shelf Angles in Exterior Walls: hot dip galvanize.
 2. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.
- E. Loose Bearing and Leveling Plates: Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts.
- F. Structural-Steel Door Frames: Fabricate from structural shapes and bars fully welded together, with 5/8-by-1-1/2-inch steel channel stops secured with countersunk machine screws. Reinforce frames and drill and tap as necessary to accept finish hardware. Provide with integrally welded steel strap anchors for securing door frames into adjoining concrete or masonry.
1. Exterior Frames: hot dip galvanize.
- G. Miscellaneous Steel Trim: 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. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work.
1. Exterior Miscellaneous Steel Trim: hot dip galvanize.
- H. Metal Ladders and Safety Cages: Comply with ANSI A14.3, unless otherwise indicated.
1. Elevator Pit Ladders: Comply with ASME A17.1.

2. Space siderails 16 inches apart, unless otherwise indicated.
 3. Steel Ladder Construction: Flat bar siderails, with 3/4-inch- diameter steel bar rungs fitted in centerline of siderails, plug-welded, and ground smooth on outer rail faces. Provide nonslip surfaces on top of each rung.
 4. Aluminum Ladder Construction: Extruded channel or tube siderails, not less than 2-1/2 inches deep, 3/4 inch wide, and 1/8 inch thick; with extruded tube rungs, not less than 3/4 inch deep and not less than 1/8 inch thick, fitted into centerline of siderails and fastened by welding or with stainless-steel fasteners or brackets and aluminum rivets. Provide rungs with ribbed tread surfaces.
 5. Fabricate ladder safety cages to comply with ANSI A14.3. Fabricate from same metal as ladders to which safety cages are attached and assemble by welding or riveting.
 6. Exterior Steel Ladders, extensions and Safety Cages: hot dip galvanize.
- I. Metal Bollards: Fabricate from 1/4-inch wall-thickness rectangular steel tubing.
1. Cap bollards with 1/4-inch- thick steel plate.
 2. Fabricate bollards with 3/8-inch- thick steel baseplates for bolting to concrete slab. Drill baseplates at all four corners for 3/4-inch anchor bolts.
 3. Fabricate sleeves for bollard anchorage from steel pipe with 1/4-inch- thick steel plate welded to bottom of sleeve.
- J. Pipe Guards: Fabricate from 3/8-inch- thick by 12-inch- wide steel plate, bent to fit flat against the wall or column at both ends and to fit around pipe with 2-inch clearance between pipe and pipe guard. Drill each end for two 3/4-inch anchor bolts.
- K. Bicycle Racks: Fabricate from Schedule 40 steel pipe, fully welded together.
1. Fabricate with NPS 3 top rails and end posts, NPS 1-1/2 bottom rails, and NPS 3/4 vertical separators at approximately 8 inches o.c.
 2. Make top rails 36 inches above pavement/floor and bottom rails 4 inches above pavement/floor.
 3. Fabricate end posts with 1/4-inch- thick steel baseplates for bolting to concrete slab. Drill end post baseplates at all 4 corners for 1/2-inch anchor bolts.
 4. Finish: hot dip galvanize.
- L. Metal Floor Plate:
1. Fabricate from rolled-steel floor plate of thickness indicated below:
 - a. Thickness: 1/8 inch unless otherwise indicated.
 2. Provide steel angle supports as indicated.
 3. Provide flush steel bar drop handles for lifting removable sections, one at each end of each section.
- M. Abrasive Metal Nosings, Treads and Thresholds.
1. Cast-Metal Units: Cast gray iron, Class 20, with an integral abrasive finish.
 - a. Manufacturers:

- 1) American Safety Tread Co., Inc.
- 2) Balco Inc.
- 3) Barry Pattern & Foundry Co., Inc.
- 4) Granite State Casting Co.
- 5) Safe-T-Metal Co.
- 6) Wooster Products Inc.

2.6 FINISHES

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes. Finish metal fabrications after assembly.
- B. Steel and Iron Finishes:
 1. Hot-dip galvanize items as indicated to comply with ASTM A 123/A 123M or ASTM A 153/A 153M as applicable.
 2. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with requirements indicated below for environmental exposure conditions of installed metal fabrications:
 - a. Exteriors (SSPC Zone 1B) and Items Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - b. Interiors (SSPC Zone 1A): SSPC-SP 3, "Power Tool Cleaning."
 3. Shop Priming: Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finishes and those to be embedded in concrete, sprayed-on fireproofing, or masonry, to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting," for shop painting.

PART 3 - EXECUTION

3.1 INSTALLATION

- A. General: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, with edges and surfaces level, plumb, and true.
 1. Fit exposed connections accurately together. Weld connections that are not to be left as exposed joints but cannot be shop welded. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication.
 2. Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction.
 3. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- B. Set bearing and leveling plates on cleaned surfaces using wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts and pack solidly with nonshrink, nonmetallic grout.

C. Bollards:

1. Anchor bollards to existing construction with anchor bolts or through bolts. Provide four 3/4-inch bolts at each bollard.
2. Anchor bollards in concrete with pipe sleeves preset and anchored into concrete. Fill annular space around bollard solidly with nonshrink, nonmetallic grout.
3. Anchor bollards in place with concrete footings. Place concrete and vibrate or tamp for consolidation. Support and brace bollards in position until concrete has cured.
4. Fill bollards solidly with concrete, mounding top surface to shed water.

D. Touch up surfaces and finishes after erection.

1. Painted Surfaces: Clean field welds, bolted connections, and abraded areas and touch up paint with the same material as used for shop painting.
2. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 05 50 00