SECTION 05 12 00 - STRUCTURAL STEEL

PART 1 – GENERAL

1.1 SUMMARY

A. Scope: This Section includes fabrication and erection of structural steel work, as shown on drawings including schedules, notes, and details showing size and location of members, typical connections, and types of steel required.

B. Structural steel is that work defined in American Institute of Steel Construction (AISC) "Code of Standard Practice" and as otherwise shown on drawings.

C. Miscellaneous Metal Fabrications are specified elsewhere in Division 5.

1.2 SUBMITTALS

A. General: Submit the following in accordance with Conditions of Contract and Division 1 Specification Sections.

B. Product data or manufacturer's specifications and installation instructions for following products. Include laboratory test reports and other data to show compliance with specifications (including specified standards).

1. Structural steel (each type), including certified copies of mill reports covering chemical and physical properties.
2. High-strength bolts (each type), including nuts and washers.
3. Structural steel primer paint.
4. Shrinkage-resistant grout.

C. Shop drawings, including complete details and schedules for fabrication and assembly of structural steel members, procedures, and diagrams. Submit three prints to the Engineer. One will be kept as a record copy and two marked-up prints will be returned to the Architect. The Engineer will have up to ten (10) working days from the time of receipt of the submittal to complete his review and return the submittal to the Architect.

1. Include details of cuts, connections, camber, holes, and other pertinent data. Indicate welds by standard AWS symbols and show size, length, and type of each weld.
2. Provide setting drawings, templates, and directions for installation of anchor bolts and other anchorages to be installed as work of other sections.
3. See Section Submittals for shop drawings requirements.
4. Miscellaneous Metal Fabrications are specified elsewhere in Division 5.
5. All shop drawings used in the field must bear the Architect/Engineer shop drawings review stamp with "Approved" indicated.
6. For connections not scheduled or detailed include stamped calculations and shop drawings prepared under supervision of a Louisiana licensed Structural Engineer.

D. Mill Test Reports: Submit manufacturer's certified test reports to the testing laboratory and architect showing chemical analysis and results of tensile and bending tests. Tests shall meet the requirements of ASTM A6/A6M.

E. Test reports conducted on shop- and field-bolted and welded connections. Include data on type(s) of tests conducted and test results.

F. LEED Submittal:

1. Product Data for LEED Credits:
   a. MRc2- Construction Waste Management 75%.
   b. MRc4- Recycled Steel Content 85% minimum.
   c. MRc5-Regional Materials-report locally produced steel.
   d. IEQc4.1-Low Emitting Materials-required if adhesives and sealants are within weatherproofing sys-

tem.

e. IEQc4.2-Low Emitting Materials- required if paints and coatings are within weatherproofing system.

1.3 QUALITY ASSURANCE

A. Standard Specifications: Except as modified or supplemented by these specifications, materials, design, fabrication, and erection of Structural Steel shall be in accordance with the American Institute of Steel Construction's "Specifications for Structural Steel for Buildings, Allowable Stress Design and Plastic Design", June 1, 1989, and the A.I.S.C. "Code of Standard Practice for Steel Buildings and Bridges", September 1, 1986. A.I.S.C. "Manual of Steel Construction, Allowable Stress Design", Ninth Edition.

B. Codes and Standards: Comply with provisions of following, except as otherwise indicated:

1. American Institute of Steel Construction (AISC) "Code of Standard Practice for Steel Buildings and Bridges."
   a. Paragraph 4.2.1 of the above code is hereby modified by deletion of the following sentence: "This approval constitutes the Owner's acceptance of all responsibility for the design adequacy of any detail configuration of connections developed by the fabricator as a part of his preparation of these shop drawings."
2. AISC "Specifications for Structural Steel Buildings," including "Commentary."
3. "Specifications for Structural Joints using ASTM A 325 or A 490 Bolts" approved by the Research Council on Structural Connections.
4. American Welding Society (AWS) D1.1 "Structural Welding Code - Steel."
5. ASTM A 6 "General Requirements for Delivery of Rolled Steel Plates, Shapes, Sheet Piling and Bars for Structural Use."

C. Qualifications for Welding Work: Qualify welding procedures and welding operators in accordance with AWS "Qualification" requirements.

1. Provide certification that welders to be employed in work have satisfactorily passed AWS qualification tests.
2. If re-certification of welders is required, retesting will be Contractor's responsibility.

1.4 DELIVERY, STORAGE, AND HANDLING

A. Deliver materials to site at such intervals to ensure uninterrupted progress of work.

B. Deliver anchor bolts and anchorage devices, which are to be embedded in cast-in-place concrete or masonry, in ample time to not to delay work.

C. 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. If bolts and nuts become dry or rusty, clean and relubricate before use.

PART 2 – PRODUCTS

2.1 MATERIALS

A. Metal Surfaces, General: For fabrication of work that will be exposed to view, use only materials that are smooth and free of surface blemishes including pitting, rust and scale seam marks, roller marks, rolled trade names, and roughness. Remove such blemishes by grinding, or by welding and grinding, prior to cleaning, treating, and applying surface finishes.

B. Structural Steel.

1. Shapes, except for channels, angles and plate: ASTM A992 Grade 50.
2. Channels, angles and plate: ASTM A 36.

C. Cold-Formed Steel Tubing: ASTM A 500, Grade B, min. fy = 46 ksi.

D. Steel Pipe: ASTM A 53, Type E or S, Grade B; or ASTM A 501, min. fy = 35 ksi.

E. Anchor Bolts: ASTM A 307, non-headed type unless otherwise indicated, or ASTM F1554 grade 105 with recommended nuts and washers as indicated on the drawings.

F. Unfinished Threaded Fasteners: ASTM A 307, Grade A, regular low-carbon steel bolts and nuts.

1. Provide hexagonal heads and nuts for all connections.

G. High-Strength Threaded Fasteners: Heavy hexagon structural bolts, heavy hexagon nuts, and hardened washers, as follows.

1. Quenched and tempered medium-carbon steel bolts, nuts, and washers, complying with ASTM A 325.
2. Where indicated as galvanized, provide units that are zinc coated, either mechanically deposited complying with ASTM B 695, Class 50, or hot-dip galvanized complying with ASTM A 153.

H. Electrodes for Welding: Comply with AWS Code.

1. Welding electrodes for manual shielded metal-arc welding shall conform to AWS A5.1 or A5.5 E70XXX welding electrodes and flux used in submerged arc process shall conform to AWS A5.17 F7X-EXXX. Use low hydrogen electrodes for A572 steel.

I. Structural Steel Primer Paint:

1. For steel scheduled to be located inside of the weatherproofed areas of the building, Sherwin Williams Pro-Cryl Universal Primer B66-310 Series, or an approved equal primer meeting the LEED requirements of IEQc4.2.

2. For steel scheduled to be located outside of the weatherproofed areas of the building, Tnemec 10-99 Alkyd Primer, or approved equal.

Note: Verify that primers are compatible with field-applied topcoats.

J. Cement Grout: Portland cement (ASTM C 150, Type I or Type III) and clean, uniformly graded, natural sand (ASTM C 404, Size No. 2). Mix at a ratio of 1.0 part cement to 2.0 parts sand, by volume, with minimum water required for placement and hydration.

K. Nonmetallic Shrinkage-Resistant Grout: Premixed, nonmetallic, non-corrosive, non-staining product containing selected silica sands, Portland cement, shrinkage compensating agents, plasticizing and water-reducing agents, complying with CE-CRD-C621.

2.2 FABRICATION

A. Shop Fabrication and Assembly: Fabricate and assemble structural assemblies in shop to greatest extent possible. Fabricate items of structural steel in accordance with AISC Specifications and as indicated on final shop drawings. Provide camber in structural members where indicated.

1. Properly mark and match-mark materials for field assembly. Fabricate for delivery sequence that will expedite erection and minimize field handling of materials.
2. Where finishing is required, complete assembly, including welding of units, before start of finishing operations. Provide finish surfaces of members exposed in final structure free of markings, burrs, and other defects.

B. Connections: Weld or bolt shop connections, as indicated.

1. Bolt field connections, except where welded connections or other connections are indicated.

C. Welded Construction: Comply with AWS Code for procedures, appearance and quality of welds, and methods used in correcting welding work.

D. Holes for Other Work: Provide holes required for securing other work to structural steel framing and for passage of other work through steel framing members, as shown on final shop drawings.

1. Provide threaded nuts welded to framing and other specialty items as indicated to receive other work.
2. Cut, drill, or punch holes perpendicular to metal surfaces. Do not flame-cut holes or enlarge holes by burning. Drill holes in bearing plates.

2.3 SHOP PRIMING

A. General: Shop-paint structural steel, except those members or portions of members to be embedded in concrete or mortar. Paint embedded steel that is partially exposed on exposed portions and initial 2 inches of embedded areas only.

1. Do not paint surfaces to be welded or high-strength bolted with friction-type connections
2. Do not paint surfaces scheduled to receive sprayed-on fireproofing.
3. Apply 2 coats of paint to surfaces that are inaccessible after assembly or erection. Change color of second coat to distinguish it from first.
4. For primer applied to steel scheduled to be located within weather proofed areas, use the primer material meeting the LEED requirements of IEQc4.2.

B. Painting: Immediately after surface preparation, apply structural steel primer paint in accordance with manufacturer's instructions and at a rate to provide dry film thickness of not less than 1.5 mils. Use painting methods that result in full coverage of joints, corners, edges, and exposed surfaces.

2.4 GALVANIZING

A. Items shown on the plans to be galvanized and bolts for same shall be hot dip zinc coated after fabrications. Galvanizing shall be done in accordance with A.S.T.M. Serial Designation A123 and A153. Any zinc coating that is damaged shall be touched up with Galvacon as manufactured by Southern Coatings in accordance with the manfacturer's recommendations.

2.5 SOURCE QUALITY CONTROL

A. General: Materials and fabrication procedures are subject to inspection and tests in mill, shop, and field, conducted by a qualified inspection agency. Such inspections and tests will not relieve Contractor of responsibility for providing materials and fabrication procedures in compliance with specified requirements.

1. Promptly remove and replace materials or fabricated components that do not comply.

B. Design of Members and Connections: Details shown are typical; similar details apply to similar conditions, unless otherwise indicated. Verify dimensions at site whenever possible without causing delay in the work.

1. Promptly notify Architect whenever design of members and connections for any portion of structure are not indicated.

PART 3 - EXECUTION

3.1 ERECTION

A. Temporary Shoring and Bracing: Provide temporary shoring and bracing members with connections of sufficient strength to bear imposed loads. Remove temporary Members and connections when permanent members are in place and final connections are made. Provide temporary guy lines to achieve proper alignment of structures as erection proceeds.

B. Temporary Planking: Provide temporary planking and working platforms as necessary to effectively complete work.

C. Setting Bases and Bearing Plates: Clean concrete and masonry bearing surfaces of bond-reducing materials and roughen to improve bond to surfaces. Clean bottom surface of base and bearing plates.

1. Set loose and attached base plates and bearing plates for structural members on wedges or other adjusting devices.
2. 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.
3. Pack grout solidly between bearing surfaces and bases or plates to ensure that no voids remain. Finish exposed surfaces, protect installed materials, and allow to cure.
4. For proprietary grout materials, comply with manufacturer's instructions.

D. Field Assembly: Set structural frames accurately to lines and elevations indicated. Align and adjust various members forming part of complete frame or structure before permanently fastening. Clean bearing surfaces and other surfaces that will be in permanent contact before assembly. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.

1. Level and plumb individual members of structure within specified AISC tolerances.
2. Splice members only where indicated and accepted on shop drawings.

E. Erection Bolts: On exposed welded construction, remove erection bolts, fill holes with plug welds, and grind smooth at exposed surfaces.

1. Comply with AISC Specifications for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds.
2. Do not enlarge unfair holes in members by burning or by using drift pins, except in secondary bracing members. Ream holes that must be enlarged to admit bolts.

F. Gas Cutting: Do not use gas cutting torches in field for correcting fabrication errors in primary structural framing. Cutting will be permitted only on secondary members that are not under stress, as acceptable to Architect. Finish gas-cut sections equal to a sheared appearance when permitted.

G. Touch-Up 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.

1. Apply by brush or spray to provide minimum dry film thickness of 1.5 mils.

3.2 QUALITY CONTROL

A. The Contractor will engage an independent testing and inspection agency to inspect high-strength bolted welded connections and to perform tests and prepare test reports. Refer to Division 01 requirements.

1. Testing agency shall conduct and interpret tests, state in each report whether test specimens comply with requirements, and specifically state any deviations therefrom.
2. Provide access for testing agency to places where structural steel work is being fabricated or produced so that required inspection and testing can be accomplished.
3. Testing agency may inspect structural steel at plant before shipment.

B. Correct deficiencies in structural steel work that inspections and laboratory test reports have indicated to be not in

compliance with requirements. Perform additional tests, at Contractor's expense, as necessary to reconfirm any noncompliance of original work and to show compliance of corrected work.

C. Shop-Bolted Connections: Inspect or test in accordance with AISC specifications. Verify that gaps of installed Direct Tension Indicators are less than gaps specified in ASTM F 959, Table 2.

D. Shop Welding: Inspect and test during fabrication of structural steel assemblies, as follows:

1. Certify welders and conduct inspections and tests as required. Record types and locations of defects found in work. Record work required and performed to correct deficiencies.
2. Perform visual inspection of all welds.
3. Perform tests on 20% of all full-pen welds as follows: Ultrasonic Inspection: ASTM E 164.

E. Field-Bolted Connections: Inspect in accordance with AISC specifications.

F. Field Welding: Inspect and test during erection of structural steel as follows:

1. Certify welders and conduct inspections and tests as required. Record types and locations of defects found in work. Record work required and performed to correct deficiencies.
2. Perform visual inspection of all welds.
3. Perform tests of all (100%) full-pen welds as follows: Ultrasonic Inspection: ASTM E 164.

END OF SECTION

SECTION 05 21 00 - STEEL JOISTS

PART 1 – GENERAL

1.1 RELATED DOCUMENTS

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

1.2 SUMMARY

A. Section Includes: All steel joist work as shown on the drawings.

1.3 QUALITY ASSURANCE

A. Standard Specifications: Except as modified or supplemented herein, materials, designs, fabrication, painting and erection of all steel joists and bridging for same shall be in accordance with the latest edition of the folowing publications of the Steel Joist Institute, as applicable:

1. Standard Specifications for Open Web Steel Joists, K- Series.
2. Standard Specifications for Long Span Steel LH-Series and Deep Long Span Steel Joists, DHL-Series.
3. Standard Specifications for Joist Girdes.
4. Recommended Code of Standard Practice for Steel Joists and Girders.

B. Welders: The Contractor shall employ a testing agency to review and approve all welders for field welds in accordance with American Welding Society standards and qualified for the type of welding whch they will perform. Refer to Division 01 requirements.

1.4 SUBMITTALS

A. Manufacturer's Data: For information only, submit 2 copies of manufactuere's specifications and installation instructions for each type of joist, joist girder and its axxessories. Include manufacturer's certification that joists comply with "Standard Specifications".

B. Shop Drawings: Submit detailed drawings showing layout and erection of joists, special connections, joiniting and accessories. Include the mark, number, size and properties, panel point locatons, type, locations and spacing of joists and bridging. Submit three prints to the Engineer. One will be kept as a record copy and two marked-up prints will be returned to the Architect. The Engineer will have up to ten (10) working days from the time of receipt of the submittal to complete his review and return the submittal to the Architect.

C. Design Computations: Furnish design computations bearing the seal and signature of a Civlil Ebngineer with State of Louisiana registration for all joists and bridging required to be designed for wind uplift. Refer to Division 1 requirements.

D. LEED Submittal:

1. Product Data for LEED Credits:
   a. MRc2- Construction Waste Management 75%.
   b. MRc4- Recycled Steel Content 85% minimum. Report all recycled content.
   c. MRc5-Regional Materials-report all locally produced materials as applicable.
   d. IEQc4.1-Low Emitting Materials-required if adhesives and sealants are within weatherproofing system.
   e. IEQc4.2-Low Emitting Materials- required if paints and coatings are within weatherproofing system.

PART 2 – PRODUCTS

2.1 MANUFACTURE

A. See Article "Standard Specifications" preceeding. Manufacturer of steel joists must be a member of the Steel Joist Institute or must be approved ty the Architect prior to receipt of bids. Where ends of K-Series joists bear less than 2-1/2" on beams, joist manufacturer shall design the joist ends to provide for he reduced bearing. Staggering of joists will not be permitted.

2.2 MATERIALS

A. GENERAL

1. Comply with "Standard Specificaations".
2. In designing joists and bridging, the uplift requirements, if any, required by the drawings must be met.

PART 3 - EXECUTION

3.1 GENERAL

A. Comply with "Standard Specifications".

3.2 FIELD CONNECTIONS

A. All field connections of steel to steel, including bridging, shall be welded.

B. The Contractor's independent Testing Laboratory shall visually inspect all connections in field to determine quality, size, and compliance with reviewed erection drawings. Where the quality of a weld is in question, the Architect will be advised. The Contractor may then be required to remove and reweld the connectiono or if the Contracltor desiers he may have the weld inspected further by radiography. the cost of this radiography inspection will be borne by the Contractor whether or not the wled is acceptable.

3.3 FIELD PAINTING

A. After erection, all field connections welds, and abraded places shall be touched-up with same paints as shop coat. Refer to Section – Painting, for addition field coats of paints.ield-Bolted Connections: Inspect in accordance with AISC specifications.

END OF SECTION

SECTION 05 30 00 - STEEL DECK

PART 1 - GENERAL

1.1 SUMMARY

A. All steel decking as shown on the drawings.

1.2 QUALITY ASSURANCE

A. Standard Specifications: Except as modified or supplemented herein, the decking shall be designed in accordance with the latest edition of AISI "Specifications for the Design of Cold-Formed Steel Structural Members and all applicable requirements contained in "Design Manual for Composite Decks, Form Decks and Roof Decks" of the Steel Deck Institute, Inc.

B. Testing – The Contractor shall provide an approved independent testing laboratory to witness all welded connections. Refer to Division 01 requirements.

1.3 SUBMITTALS

A. Manufacturer's Data: For information only, submit 2 copies of manufacturer's specifications and installation instructions for each type of decking and accessories. Include manufacturer's certifications as may be required to show compliance with these specifications.

B. Shop Drawings: Submit detailed drawings showing layout and types of deck panels, anchorage details, and conditions requiring closure panels, supplementary framing, cut openings, special jointing or other accessories. Submit three prints to the Engineer. One will be kept as a record copy and two marked-up prints will be returned to the Architect. The Engineer will have up to ten (10) working days from the time of receipt of the submittal to complete his review and return the submittal to the Architect.

C. LEED Submittal:

1. Product Data for LEED Credits:
   a. MRc2- Construction Waste Management 75%.
   b. MRc4- Recycled Content 85% minimum.
   c. MRc5-Regional Materials-report if applicable.
   d. IEQc4.1-Low Emitting Materials-required if adhesives and sealants are within weatherproofing system.
   e. IEQc4.2-Low Emitting Materials- required if paints and coatings are within weatherproofing system.

PART 2 - PRODUCTS

2.1 MATERIALS

A. Deck, Dimensions and Properties: Dimensions and properties of the various types of deck are shown on the drawings. Deck configurations shall be similar to that of the decks called for on the drawings. Allowable stresses shall be equal to that of the deck specified on the drawings.

B. Deck Coating: Galvanized, ASTM A525, G90.

C. Miscellaneous Steel Shapes: ASTM A36.

D. Sheet Metal Accessories: ASTM A 526, commercial quality, galvanized.

PART 3 - EXECUTION

3.1 INSTALLATION

A. Deck sheets shall be erected and welded to supports in accordance with the manufacturer's specifications and erection layouts and as required to resist the uplift loads, if any, noted on the drawings.

B. Side joints must be fastened together in accordance with manufacturer's specifications. Cutting openings through the deck less than 16 square feet in area, and all skew cutting shall be performed in the field. Deck shall be continuous over three (3) or more spans.

C. Except where other permanent type edge closures are shown on the drawings, provide sheet metal edge closures around the perimeter of all steel deck areas, including openings, where concrete is to be applied to the deck. Deck closures shall be of proper gage and configuration to retain the wet concrete.

3.2 TOUCH-UP

A. All damaged coating, including welds, shall be touched up with an approved coating before placing fill.

END OF SECTION

SECTION 05 40 00 - COLD-FORMED METAL FRAMING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

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

1.2 SUMMARY

A. Section Includes:

1. Exterior non-load-bearing wall framing.

B. Related Requirements:

1. Section 09 22 16 "Non-Structural Metal Framing" for interior non-load-bearing, metal-stud framing and ceiling-suspension assemblies.

1.3 PREINSTALLATION MEETINGS

A. Preinstallation Conference: Conduct conference at Project site.

1.4 ACTION SUBMITTALS

A. Product Data: For each type of cold-formed steel framing product and accessory.

B. Shop Drawings:

1. Include layout, spacings, sizes, thicknesses, and types of cold-formed steel framing; fabrication; and fastening and anchorage details, including mechanical fasteners.
2. Indicate reinforcing channels, opening framing, supplemental framing, strapping, bracing, bridging, splices, accessories, connection details, and attachment to adjoining work.

C. Delegated-Design Submittal: For cold-formed steel framing.

1.5 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Product Test Reports: For each listed product, for tests performed by manufacturer and witnessed by a qualified testing agency.

1. Steel sheet.
2. Expansion anchors.
3. Power-actuated anchors.
4. Mechanical fasteners.

5. Miscellaneous structural clips and accessories.

C. Research Reports: For non-standard cold-formed steel framing, from ICC-ES.

D. LEED Submittals:

1. Product Data for Credit MR 4: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.

2. Product Certificates for Credit MR 5: For products and materials required to comply with requirements for regional materials indicating location and distance from Project of material manufacturer and point of extraction, harvest, or recovery for each raw material. Include statement indicating cost for each regional material and the fraction by weight that is considered regional.

1.6 QUALITY ASSURANCE

A. Product Tests: Mill certificates or data from a qualified independent testing agency, or in-house testing with calibrated test equipment indicating steel sheet complies with requirements, including base-metal thickness, yield strength, tensile strength, total elongation, chemical requirements, and metallic-coating thickness.

B. 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."

C. Comply with AISI S230 "Standard for Cold-Formed Steel Framing - Prescriptive Method for One and Two Family Dwellings."

1.7 DELIVERY, STORAGE, AND HANDLING

A. Protect cold-formed steel framing from corrosion, moisture staining, deformation, and other damage during delivery, storage, and handling.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

1. AllSteel & Gypsum Products, Inc.
2. Clark Western Building Systems, Inc.
3. Craco Manufacturing, Inc.
4. Custom Stud, Inc.
5. Dietrich Metal Framing; a Worthington Industries Company.
6. Formetal Co. Inc. (The).
7. Marino/WARE.
8. Southeastern Stud & Components, Inc.
9. State Building Products, Inc.
10. Steel Construction Systems.
11. Steel Structural Systems.

12. Super Stud Building Products, Inc.
13. The Steel Network, Inc.
14. United Steel Manufacturing

2.2 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a Louisiana Registered Professional Engineer, as defined in Section 01 40 00 "Quality Requirements," to design cold-formed steel framing.

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

1. Design Loads: As indicated on Drawing S0.01.
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 1/360 of the wall height.

3. Design framing systems to provide for movement of framing members located outside the insulated building envelope 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 (67 deg C).
4. Design framing system to maintain clearances at openings, to allow for construction tolerances, and to accommodate live load deflection of primary building structure as follows:

    a. Upward and downward movement of 1/2 inch (13 mm).

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

C. Cold-Formed Steel Framing Design Standards:

1. Wall Studs: AISI S211.

D. AISI Specifications and Standards: Unless more stringent requirements are indicated, comply with AISI S100 and AISI S200.

E. Fire-Resistance Ratings: Comply with ASTM E 119; testing by a qualified testing agency. Identify products with appropriate markings of applicable testing agency.

1. Indicate design designations from UL's "Fire Resistance Directory" or from the listings of another qualified testing agency.

2.3 COLD-FORMED STEEL FRAMING, GENERAL

A. 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 (Z180), A60 (ZF180), AZ50 (AZ150), or GF30 (ZGF90).

2.4 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: 0.0677 inch (1.72 mm).
2. Flange Width: 2-1/2 inches (63 mm).

B. Steel Track: Manufacturer's standard U-shaped steel track, of web depths indicated, unpunched, with unstiffened flanges, and as follows:

1. Minimum Base-Metal Thickness: Matching steel studs.
2. Flange Width: 2-1/2 inches (63 mm).

C. Single Deflection Track: Manufacturer's single, deep-leg, U-shaped steel track; unpunched, with unstiffened flanges, of web depth to contain studs while allowing free vertical movement, with flanges designed to support horizontal loads and transfer them to the primary structure, and as follows:

1. Minimum Base-Metal Thickness: 0.0677 inch (1.72 mm).
2. Flange Width: 1 inch (25 mm) plus the design gap for one-story structures and 1 inch (25 mm) plus twice the design gap for other applications Insert dimension.

2.5 FRAMING ACCESSORIES

A. Fabricate steel-framing accessories from steel sheet, ASTM A 1003/A 1003M, Structural Grade, Type H, metallic coated, of same grade and coating weight used for framing members.

B. Provide accessories of manufacturer's standard thickness and configuration, unless otherwise indicated, as follows:

1. Supplementary framing.
2. Bracing, bridging, and solid blocking.
3. Web stiffeners.
4. Anchor clips.
5. End clips.
6. Foundation clips.
7. Stud kickers and knee braces.
8. Hole reinforcing plates.
9. Backer plates.

2.6 ANCHORS, CLIPS, AND FASTENERS

A. Steel Shapes and Clips: ASTM A 36/A 36M, zinc coated by hot-dip process according to ASTM A 123/A 123M.

B. Anchor Bolts: ASTM F 1554, Grade 36, threaded carbon-steel hex-headed bolts and carbon-steel nuts; and flat, hardened-steel washers; zinc coated by hot-dip process according to ASTM A 153/A 153M, Class C.

C. Expansion Anchors: Fabricated from corrosion-resistant materials, with allowable load or strength design capacities calculated according to ICC-ES AC193 and ACI 318 greater than or equal to the design load, as determined by testing per ASTM E 488 conducted by a qualified testing agency.

D. Power-Actuated Anchors: Fastener system of type suitable for application indicated, fabricated from corrosion-resistant materials, with allowable load capacities calculated in accordance with ICC-ES AC70, greater than or equal to the design load, as determined by testing per ASTM E 1190 conducted by a qualified testing agency.

E. Mechanical Fasteners: ASTM C 1513, corrosion-resistant-coated, self-drilling, self-tapping steel drill screws.

1. Head Type: Low-profile head beneath sheathing, manufacturer's standard elsewhere.

F. Welding Electrodes: Comply with AWS standards.

2.7 MISCELLANEOUS MATERIALS

A. Galvanizing Repair Paint: SSPC-Paint 20 or MIL-P-21035.

B. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, and plasticizing and water-reducing agents, complying with ASTM C 1107, with fluid consistency and 30-minute working time.

C. Shims: Load bearing, high-density multimonomer plastic, nonleaching; or of cold-formed steel of same grade and coating as framing members supported by shims.

D. Sealer Gaskets: Closed-cell neoprene foam, 1/4 inch (6.4 mm) thick, selected from manufacturer's standard widths to match width of bottom track or rim track members.

2.8 FABRICATION

A. Fabricate cold-formed steel framing and accessories plumb, square, and true to line, and with connections securely fastened, according to referenced AISI's specifications and standards, manufacturer's written instructions, and requirements in this Section.

1. Fabricate framing assemblies using jigs or templates.
2. Cut framing members by sawing or shearing; do not torch cut.
3. Fasten cold-formed steel framing members by welding, screw fastening, clinch fastening, pneumatic pin fastening, or riveting as standard with fabricator. Wire tying of framing members is not permitted.

    a. Comply with AWS D1.3/D1.3M requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
    b. Locate mechanical fasteners and install according to Shop Drawings, with screw penetrating joined members by not less than three exposed screw threads.

4. Fasten other materials to cold-formed steel framing by welding, bolting, pneumatic pin fastening, or screw fastening, according to Shop Drawings.

B. Reinforce, stiffen, and brace framing assemblies to withstand handling, delivery, and erection stresses. Lift fabricated assemblies to prevent damage or permanent distortion.

C. Fabrication Tolerances: Fabricate assemblies level, plumb, and true to line to a maximum allowable tolerance variation of 1:960 (1/8 inch in 10 feet) and as follows:

1. Spacing: Space individual framing members no more than plus or minus 1/8 inch (3 mm) from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.
2. Squareness: Fabricate each cold-formed steel framing assembly to a maximum out-of-square tolerance of 1/8 inch (3 mm).

PART 3 - EXECUTION

3.1 EXAMINATION

A. Examine supporting substrates and abutting structural framing for compliance with requirements for installation tolerances and other conditions affecting performance.

1. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

A. Install load bearing shims or grout between the underside of load-bearing wall bottom track and the top of foundation wall or slab at locations with a gap larger than 1/4 inch (6 mm) to ensure a uniform bearing surface on supporting concrete or masonry construction.

B. Install sealer gaskets at the underside of wall bottom track or rim track and the top of foundation wall or slab at stud or joist locations.

3.3 INSTALLATION, GENERAL

A. Cold-formed steel framing may be shop or field fabricated for installation, or it may be field assembled.

B. Install cold-formed steel framing according to AISI S200 and to manufacturer's written instructions unless more stringent requirements are indicated.

C. Install shop- or field-fabricated, cold-formed framing and securely anchor to supporting structure.

1. Screw, bolt, or weld wall panels at horizontal and vertical junctures to produce flush, even, true-to-line joints with maximum variation in plane and true position between fabricated panels not exceeding 1/16 inch (1.6 mm).

D. Install cold-formed steel 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 steel framing members by welding, screw fastening, clinch fastening, or riveting. Wire tying of framing members is not permitted.

a. Comply with AWS D1.3/D1.3M requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
b. Locate mechanical fasteners and install according to Shop Drawings, and complying with requirements for spacing, edge distances, and screw penetration.

E. Install framing members in one-piece lengths unless splice connections are indicated for track or tension members.

F. Install temporary bracing and supports to secure framing and support loads comparable in intensity to those for which structure was designed. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to framing are secured.

G. Do not bridge building expansion joints with cold-formed steel framing. Independently frame both sides of joints.

H. Install insulation, specified in Section 07 21 00 "Thermal Insulation," in built-up exterior framing members, such as headers, sills, boxed joists, and multiple studs at openings, that are inaccessible on completion of framing work.

I. Fasten hole reinforcing plate over web penetrations that exceed size of manufacturer's approved or standard punched openings.

J. Erection Tolerances: Install cold-formed steel framing level, plumb, and true to line to a maximum allowable tolerance variation of 1:960 (1/8 inch in 10 feet) and as follows:

1. Space individual framing members no more than plus or minus 1/8 inch (3 mm) from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.

3.4 EXTERIOR NON-LOAD-BEARING WALL INSTALLATION

A. Install continuous tracks sized to match studs. Align tracks accurately and securely anchor to supporting structure as indicated.

B. Fasten both flanges of studs to top and bottom track, unless otherwise indicated. Space studs as follows:

1. Stud Spacing: 12 inches (305 mm) at cornersw and 16 inches (406 mm) in field.

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.

E. Install horizontal bridging in wall studs, spaced vertically in rows indicated on Shop Drawings but not more than 48 inches (1220 mm) apart. Fasten at each stud intersection.

1. Bridging: Proprietary bridging bars installed according to manufacturer's written instructions.

F. Install miscellaneous framing and connections, including stud kickers, web stiffeners, clip angles, continuous angles, anchors, and fasteners, to provide a complete and stable wall-framing system.

3.5 REPAIRS AND PROTECTION

A. Galvanizing Repairs: Prepare and repair damaged galvanized coatings on fabricated and installed cold-formed steel 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 steel framing is without damage or deterioration at time of Substantial Completion.

END OF SECTION 05 40 00

SECTION 05 50 00 - 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 and grilles.
2. Steel shapes for supporting elevator door sills.
3. Metal ladders.
4. Miscellaneous steel trim including loading-dock edge angles.
5. Metal bollards.
6. Abrasive metal nosings.
7. Metal downspout boots.
8. Loose bearing and leveling plates for applications where they are not specified in other Sections.

B. Products furnished, but not installed, under this Section:

1. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
2. Steel weld plates and angles for casting into concrete for applications where they are not specified in other Sections.

C. Related Sections:

1. Section 03 30 00 "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.
2. Section 04 20 00 "Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
3. Section 05 12 00 "Structural Steel Framing."
4. Section 05 51 00 "Metal Stairs."
5. Section 05 52 13 "Pipe and Tube Railings."

1.3 COORDINATION

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

B. Coordinate installation of anchorages and steel weld plates and angles for casting into concrete. 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. Metal nosings and treads.
2. Nonslip aggregates and nonslip-aggregate surface finishes.
3. Paint products.
4. Grout.

B. Shop Drawings: Show fabrication and installation details for metal fabrications.

1. Steel framing and supports for overhead doors and grilles.
2. Elevator machine beams, hoist beams,.
3. Steel shapes for supporting elevator door sills.
4. Metal ladders.
5. Elevator pit sump covers.
6. Miscellaneous steel trim including loading-dock edge angles.
7. Metal bollards.
8. Abrasive metal nosings.
9. Metal downspout boots.

C. Samples for Verification: For each type and finish of extruded nosing.

D. Delegated-Design Submittal: For installed products, including but not limited to ladders, indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

A. Qualification Data: For qualified professional engineer.

B. Welding certificates.

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

D. LEED Submittals:

1. Product Data for Credit MR 4: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.

2. Product Certificates for Credit MR 5: For products and materials required to comply with requirements for regional materials indicating location and distance from Project of material manufacturer and point of extraction, harvest, or recovery for each raw material. Include statement indicating cost for each regional material and the fraction by weight that is considered regional.
3. Laboratory Test Reports for Credit IEQ 4.2: For primers, documentation indicating that products comply with the testing and product requirements of the California Department of Public Health's (formerly, the California Department of Health Services') "Standard Method for the Testing and Evaluation of Volatile Organic Chemical Emissions from Indoor Sources Using Small-Scale Environmental Chambers."

1.6 QUALITY ASSURANCE

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

B. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.7 PROJECT CONDITIONS

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

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design ladders.

B. 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, GENERAL

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.

2.3 FERROUS METALS

A. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 25 percent.

B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

C. Steel Tubing: ASTM A 500, cold-formed steel tubing.

D. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40) unless otherwise indicated.

E. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

2.4 FASTENERS

A. General: Unless otherwise indicated, provide Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.

B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A (ASTM F 568M, Property Class 4.6); with hex nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.

C. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593 (ASTM F 738M); with hex nuts, ASTM F 594 (ASTM F 836M); and, where indicated, flat washers; Alloy [**Group 1 (A1)**] [**Group 2 (A4)**].

D. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; and, where indicated, flat washers.

1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.

E. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).

F. Plain Washers: Round, ASME B18.22.1 (ASME B18.22M).

G. Lock Washers: Helical, spring type, ASME B18.21.1 (ASME B18.21.2M).

H. Anchors, General: Anchors capable of sustaining, without failure, a load equal to six times the load imposed when installed in unit masonry and four times the load imposed when installed in concrete, as determined by testing according to ASTM E 488, conducted by a qualified independent testing agency.

I. Post-Installed Anchors: Torque-controlled expansion anchors.

1. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

2.5 MISCELLANEOUS MATERIALS

A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

B. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."

C. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.

1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.

D. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.

E. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

F. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.

G. Nonshrink, Metallic Grout: Factory-packaged, ferrous-aggregate grout complying with ASTM C 1107, specifically recommended by manufacturer for heavy-duty loading applications.

H. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.

I. Concrete: Comply with requirements in Section 03 30 00 "Cast-in-Place Concrete" for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa).

2.6 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 (1 mm) 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 will be 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.

1. 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 (3.2 by 38 mm), with a minimum 6-inch (150-mm) embedment and 2-inch (50-mm) hook, not less than 8 inches (200 mm) from ends and corners of units and 24 inches (600 mm) o.c., unless otherwise indicated.

2.7 MISCELLANEOUS FRAMING AND SUPPORTS

A. General: Provide steel framing and supports not specified in other Sections as needed to complete the Work.

B. Fabricate units from steel shapes, plates, and bars of welded construction unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction.

1. Fabricate units from slotted channel framing where indicated.
2. Furnish inserts for units installed after concrete is placed.

C. Galvanize miscellaneous framing and supports where indicated.

D. Prime miscellaneous framing and supports with zinc-rich primer where indicated.

2.8 METAL LADDERS

A. General:

1. For exterior roof ladders comply with ANSI A14.3.
2. For elevator pit ladders, comply with ASME A17.1.

B. Steel Ladders:

1. Space siderails 16 inches (406 mm) minimum clear apart.
2. Space siderails of elevator pit ladders 12 inches (300 mm) apart.
3. Siderails: Continuous, 3/8-by-2-1/2-inch (9.5-by-64-mm) steel flat bars, with eased edges.
4. Rungs: 3/4-inch- (19-mm-) diameter steel bars.
5. Fit rungs in centerline of siderails; plug-weld and grind smooth on outer rail faces.
6. Provide nonslip surfaces on top of each rung by coating with abrasive material metallically bonded to rung.

    a. Products: Subject to compliance with requirements, available products that may be incorporated into the Work include, but are not limited to, the following:

        1) Harsco Industrial IKG, a division of Harsco Corporation; Mebac.
        2) SlipNOT Metal Safety Flooring, a division of W. S. Molnar Company; SlipNOT.

7. Provide platforms as indicated fabricated from welded or pressure-locked steel bar grating, supported by steel angles. Limit openings in gratings to no more than 1/2 inch (12 mm) in least dimension
8. Support each ladder at top and bottom and not more than 60 inches (1500 mm) o.c. with welded or bolted steel brackets.
9. Prime exterior ladders, including brackets and fasteners, with zinc-rich primer.

2.9 ELEVATOR PIT SUMP COVERS

A. Fabricate from 1/8-inch (3.2-mm) rolled-steel floor plate with four 1-inch- (25-mm-) diameter holes for water drainage and for lifting.

B. Provide steel angle supports as indicated.

2.10 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 exterior miscellaneous steel trim.

D. Prime miscellaneous steel trim with zinc-rich primer.

2.11 METAL BOLLARDS

A. Fabricate metal bollards from galvanized Schedule 40 steel pipe.

2.12 ABRASIVE METAL NOSINGS

A. Cast-Metal Units: Cast iron, with an integral-abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.

1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

a. American Safety Tread Co., Inc.
b. Balco Inc.
c. Barry Pattern & Foundry Co., Inc.
d. Granite State Casting Co.
e. Safe-T-Metal Company, Inc.
f. Wooster Products Inc.

2. Nosings: Cross-hatched units, 3 inches (75 mm) wide with 1-inch (25-mm) lip, for casting into concrete steps.

B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.

C. Drill for mechanical anchors and countersink. Locate holes not more than 4 inches (100 mm) from ends and not more than 12 inches (300 mm) o.c., evenly spaced between ends, unless otherwise indicated. Provide closer spacing if recommended by manufacturer.

1. Provide two rows of holes for units more than 5 inches (125 mm) wide, with two holes aligned at ends and intermediate holes staggered.

D. Apply bituminous paint to concealed surfaces of cast-metal units.

2.13 METAL DOWNSPOUT BOOTS

A. Provide downspout boots made from cast aluminum in heights indicated with inlets of size and shape to suit downspouts. Provide units with flanges and holes for countersunk anchor bolts. Provide units with cleanout ports.

1. Outlet: Vertical, to discharge into pipe.

B. Prime cast iron downspout boots with zinc-rich primer.

2.14 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 plates.

2.15 STEEL WELD PLATES AND ANGLES

A. Provide steel weld plates and angles not specified in other Sections, for items supported from concrete construction as needed to complete the Work. Provide each unit with no fewer than two integrally welded steel strap anchors for embedding in concrete.

2.16 FINISHES, GENERAL

A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

B. Finish metal fabrications after assembly.

C. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.17 STEEL AND IRON FINISHES

A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.

B. Shop prime iron and steel items not indicated to be galvanized unless they are to be embedded in concrete, sprayed-on fireproofing, or masonry, or unless otherwise indicated.

1. Shop prime with universal shop primer unless indicated.

C. Preparation for Shop Priming: Prepare surfaces to comply with SSPC-SP 3, "Power Tool Cleaning."

D. 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.

F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with the following:

1. Cast Aluminum: Heavy coat of bituminous paint.
2. Extruded Aluminum: Two coats of clear lacquer.

3.2 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings.

B. Anchor supports for operable partitions securely to and rigidly brace from building structure.

C. Support steel girders on solid grouted masonry, concrete, or steel pipe columns. Secure girders with anchor bolts embedded in grouted masonry or concrete or with bolts through top plates of pipe columns.

1. Where grout space under bearing plates is indicated for girders supported on concrete or masonry, install as specified in "Installing Bearing and Leveling Plates" Article.

3.3 INSTALLING METAL BOLLARDS

A. Anchor bollards in place with concrete footings. Center and align bollards in holes 3 inches (75 mm) 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.

1. Do not fill removable bollards with concrete.

3.4 INSTALLING NOSINGS, TREADS, AND THRESHOLDS

A. Center nosings on tread widths unless otherwise indicated.

B. For nosings embedded in concrete steps or curbs, align nosings flush with riser faces and level with tread surfaces.

3.5 INSTALLING BEARING AND LEVELING PLATES

A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of plates.

B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.

1. Use nonshrink grout, either metallic or nonmetallic, in concealed locations where not exposed to moisture; use nonshrink, nonmetallic grout in exposed locations unless otherwise indicated.
2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.6 ADJUSTING AND CLEANING

A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in Section 09 91 13 "Exterior Painting."

C. 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

SECTION 05 51 13 - 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.

1.2 SUMMARY

A. Section Includes:

1. Preassembled steel stairs with concrete-filled and abrasive-coating-finished, formed-metal treads.
2. Steel tube railings attached to metal stairs.
3. Steel tube handrails attached to walls adjacent to metal stairs.

B. Related Requirements:

1. Section 03 30 00 "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
2. Section 05 52 13 "Pipe and Tube Railings" for pipe and tube railings.

1.3 COORDINATION

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

B. Coordinate installation of anchorages for metal stairs. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

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

1.4 ACTION SUBMITTALS

A. Product Data: For metal pan stairs and the following:

1. Prefilled metal-pan-stair treads.
2. Abrasive nosings.
3. Paint products.

B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

C. Samples for Verification: For each type and finish of nosing.

D. Delegated-Design Submittal: For stairs and 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.

C. LEED Submittals:

1. Product Data for Credit MR 4: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.

2. Product Certificates for Credit MR 5: For products and materials required to comply with requirements for regional materials indicating location and distance from Project of material manufacturer and point of extraction, harvest, or recovery for each raw material. Include statement indicating cost for each regional material and the fraction by weight that is considered regional.
3. Laboratory Test Reports for Credit IEQ 4.2: For primers, documentation indicating that products comply with the testing and product requirements of the California Department of Public Health's (formerly, the California Department of Health Services') "Standard Method for the Testing and Evaluation of Volatile Organic Chemical Emissions from Indoor Sources Using Environmental Chambers."

1.6 QUALITY ASSURANCE

A. Installer Qualifications: Fabricator of products.

B. 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."

PART 2 - PRODUCTS

2.1 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Alfab, Inc.
2. American Stair, Inc.
3. Lapeyre Stair Inc.
4. Pacific Stair Corporation.
5. Worthington Metal Fabricators.

2.2 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer, as defined in Section 01 40 00 "Quality Requirements," to design stairs and railings.

B. Structural Performance of Stairs: Metal stairs shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Uniform Load: 100 lbf/sq. ft. (4.79 kN/sq. m).
2. Concentrated Load: 300 lbf (1.33 kN) applied on an area of 4 sq. in. (2580 sq. mm).
3. Uniform and concentrated loads need not be assumed to act concurrently.
4. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
5. Limit deflection of treads, platforms, and framing members to L/360 or 1/4 inch (6.4 mm), whichever is less.

C. Structural Performance of Railings: Railings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Handrails and Top Rails of Guards:

a. Uniform load of 50 lbf/ft. (0.73 kN/m) applied in any direction.
b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
c. Uniform and concentrated loads need not be assumed to act concurrently.

2. Infill of Guards:

a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
b. Infill load and other loads need not be assumed to act concurrently.

2.3 METALS

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

B. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 25 percent.

C. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

D. Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513.

E. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

F. Uncoated, Cold-Rolled Steel Sheet: ASTM A 1008/A 1008M, either commercial steel, Type B, or structural steel, Grade 25 (Grade 170), unless another grade is required by design loads; exposed.

G. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, either commercial steel, Type B, or structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.

2.4 ABRASIVE NOSINGS

A. Cast-Metal Units: Cast iron, with an integral abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.

1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

a. American Safety Tread Co., Inc.
b. Balco, Inc.
c. Barry Pattern & Foundry Co., Inc.

d. Granite State Casting Co.
e. Safe-T-Metal Company, Inc.
f. Wooster Products Inc.

2. Configuration: Cross-hatched units, 4 inches (100 mm) wide without lip.

B. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.

C. Apply bituminous paint to concealed surfaces of cast-metal units set into concrete.

D. Apply clear lacquer to concealed surfaces of extruded units set into concrete.

2.5 FASTENERS

A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 12 for exterior use, and Class Fe/Zn 5 where built into exterior walls. Select fasteners for type, grade, and class required.

B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A (ASTM F 568M, Property Class 4.6); with hex nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.

C. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563 (ASTM A 563M); 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 E 488/E 488M, conducted by a qualified independent testing agency.

1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.

2.6 MISCELLANEOUS MATERIALS

A. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Public Health's (formerly, the California Department of Health Services') "Standard Method for the Testing and Evaluation of Volatile Organic Chemical Emissions from Indoor Sources Using Environmental Chambers."

B. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.

1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.

C. Concrete Materials and Properties: Comply with requirements in Section 03 30 00 "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa) unless otherwise indicated.

D. Welded Wire Reinforcement: ASTM A 185/A 185M, 6 by 6 inches (152 by 152 mm), W1.4 by W1.4, unless otherwise indicated.

2.7 FABRICATION, GENERAL

A. Provide complete stair assemblies, including metal framing, hangers, struts, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.

1. Join components by welding unless otherwise indicated.
2. Use connections that maintain structural value of joined pieces.

B. Preassembled Stairs: Assemble stairs in shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.

C. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch (1 mm) unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.

D. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.

E. Form exposed work with accurate angles and surfaces and straight edges.

F. Weld connections to comply with the following:

1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
2. Obtain fusion without undercut or overlap.
3. Remove welding flux immediately.
4. Weld exposed corners and seams continuously unless otherwise indicated.
5. At exposed connections, finish exposed welds to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 3 welds: partially dressed weld with spatter removed.

G. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts unless otherwise indicated. Locate joints where least conspicuous.

2.8 STEEL-FRAMED STAIRS

A. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," Commercial Class, unless more stringent requirements are indicated.

B. Stair Framing:

1. Fabricate stringers of steel channels.

a. Provide closures for exposed ends of channel stringers.

2. Construct platforms of steel channel headers and miscellaneous framing members as needed to comply with performance requirements.
3. Weld stringers to headers; weld framing members to stringers and headers.
4. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.

C. Metal 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-rolled steel sheet.

2. Directly weld metal pans to stringers; locate welds on top of subtreads where they are 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. Attach abrasive nosings to risers.
6. 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.

2.9 STAIR RAILINGS

A. Steel Tube Railings: Fabricate railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.

1. Rails and Posts: 1-1/4-inch- (32-mm-) round top and bottom rails and 1-1/4-inch- (32-mm-) round posts.
2. Picket Infill: 1/2-inch- (13-mm-) round pickets spaced less than 4 inches (100 mm) clear.

B. Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.

1. Finish welds to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 2 welds: completely sanded joint, some undercutting and pinholes are okay as shown in NAAMM AMP 521.

C. Form changes in direction of railings as follows:

1. By bending or by inserting prefabricated elbow fittings.

D. For changes in direction made by bending, use jigs to produce uniform curvature for each repetitive configuration required. Maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.

E. Close exposed ends of railing members with prefabricated end fittings.

F. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated. Close ends of returns unless clearance between end of rail and wall is 1/4 inch (6 mm) or less.

G. Connect posts to stair framing by direct welding unless otherwise indicated.

H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.

1. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
2. Provide type of bracket with predrilled hole for exposed bolt anchorage and that provides 2-1/4-inch (57-mm) clearance from inside face of handrail to finished wall surface.

I. Fillers: Provide fillers made from steel plate, or other suitably crush-resistant material, where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses and to produce adequate bearing area to prevent bracket rotation and overstressing of substrate.

2.10 FINISHES

A. Finish metal stairs after assembly.

B. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with SSPC-SP 3, "Power Tool Cleaning."

C. Apply shop primer to uncoated surfaces of metal stair components, except those with galvanized finishes and those to be embedded in concrete or masonry unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.

PART 3 - EXECUTION

3.1 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. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.

B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.

C. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete unless otherwise indicated.

D. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.

E. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.

F. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.

G. Place and finish concrete fill for treads and platforms to comply with Section 03 30 00 "Cast-in-Place Concrete."

1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.

3.2 INSTALLING RAILINGS

A. Adjust railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and rail ends to building construction as follows:

1. Anchor posts to steel by welding to steel supporting members.
2. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.

B. Attach handrails to wall with wall brackets. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as required to comply with performance requirements.

3.3 ADJUSTING AND CLEANING

A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

END OF SECTION 05 51 13

SECTION 05 52 13 - PIPE AND TUBE 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 pipe and tube railings.
2. Aluminum pipe and tube railings.

B. Related Sections:

1. Section 05 51 13 "Metal Pan Stairs" for steel tube railings associated with metal stairs.
2. Section 09 22 16 "Non-Structural Metal Framing" for metal backing for anchoring railings.

1.3 PERFORMANCE REQUIREMENTS

A. Delegated Design: Design railings, including comprehensive engineering analysis by a qualified professional engineer, as defined in Section 014000, using performance requirements and design criteria indicated.

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.
2. Aluminum: The lesser of minimum yield strength divided by 1.65 or minimum ultimate tensile strength divided by 1.95.

C. Structural Performance: Railings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Handrails and Top Rails of Guards:

a. Uniform load of 50 lbf/ ft. (0.73 kN/m) applied in any direction.
b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
c. Uniform and concentrated loads need not be assumed to act concurrently.

2. Infill of Guards:

a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
b. Infill load and other loads need not be assumed to act concurrently.

D. 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.

E. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.

1.4 ACTION SUBMITTALS

A. Product Data: For the following:

1. Manufacturer's product lines of mechanically connected railings.
2. Railing brackets.
3. Grout, anchoring cement, and paint products.

B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

C. 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.

1.5 INFORMATIONAL SUBMITTALS

A. Qualification Data: For qualified professional engineer.

B. Mill Certificates: Signed by manufacturers of stainless-steel products certifying that products furnished comply with requirements.

C. Welding certificates.

D. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, according to ASTM E 894 and ASTM E 935.

E. LEED Submittals:

1. Product Data for Credit MR 4: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.
2. Laboratory Test Reports for Credit IEQ 4: For primers, documentation indicating that products comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."

1.6 QUALITY ASSURANCE

A. Source Limitations: Obtain each type of railing from single source from single manufacturer.

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

C. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
2. AWS D1.2/D1.2M, "Structural Welding Code - Aluminum."

1.7 PROJECT CONDITIONS

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

1.8 COORDINATION AND SCHEDULING

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

B. Coordinate installation of anchorages for 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 such 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 satisfy structural performance requirements.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:

1. Steel Pipe and Tube Railings:

    a. See Section 05 51 13 "Metal Pan Stairs."

2. Aluminum Pipe and Tube Railings:

    a. Blum, Julius & Co., Inc.
    b. Braun, J. G., Company; a division of the Wagner Companies.
    c. Hollaender Manufacturing Company.
    d. Moultrie Manufacturing Company.
    e. Superior Aluminum Products, Inc.
    f. Thompson Fabricating, LLC.
    g. Tri Tech, Inc.
    h. Tuttle Railing Systems; Div. of Tuttle Aluminum & Bronze, Inc.
    i. Wagner, R & B, Inc.; a division of the Wagner Companies.

2.2 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: Cast or formed metal of same type of material and finish as supported rails unless otherwise indicated.

2.3 STEEL AND IRON

A. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 25 percent.

B. Tubing: ASTM A 500 (cold formed) or ASTM A 513.

C. Pipe: ASTM A 53/A 53M, Type F or Type S, Grade A, Standard Weight (Schedule 40), unless another grade and weight are required by structural loads.

1. Provide galvanized finish for exterior installations.

D. Plates, Shapes, and Bars: ASTM A 36/A 36M.

E. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

F. Location: Install galvanized steel railings at loading dock/service area only.

2.4 ALUMINUM

A. Aluminum, General: Provide alloy and temper recommended by aluminum producer and finisher for type of use and finish indicated, and with not less than the strength and durability properties of alloy and temper designated below for each aluminum form required.

B. Extruded Bars and Tubing: ASTM B 221 (ASTM B 221M), Alloy 6063-T5/T52.

C. Extruded Structural Pipe and Round Tubing: ASTM B 429/B 429M, Alloy 6063-T6.

1. Provide Standard Weight (Schedule 40) pipe, unless otherwise indicated.

D. Drawn Seamless Tubing: ASTM B 210 (ASTM B 210M), Alloy 6063-T832.

E. Plate and Sheet: ASTM B 209 (ASTM B 209M), Alloy 6061-T6.

F. Die and Hand Forgings: ASTM B 247 (ASTM B 247M), Alloy 6061-T6.

G. Castings: ASTM B 26/B 26M, Alloy A356.0-T6.

2.5 FASTENERS

A. General: Provide the following:

1. Hot-Dip Galvanized Railings: Type 304 stainless-steel or hot-dip zinc-coated steel fasteners complying with ASTM A 153/A 153M or ASTM F 2329 for zinc coating.
2. Aluminum Railings: Type 304 stainless-steel fasteners.

B. 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.

C. Fasteners for Interconnecting Railing Components:

1. Provide concealed fasteners for interconnecting railing components and for attaching them to other work, unless otherwise indicated.
2. Provide concealed fasteners for interconnecting railing components and for attaching them to other work, unless exposed fasteners are unavoidable or are the standard fastening method for railings indicated.
3. Provide tamper-resistant flat-head machine screws for exposed fasteners unless otherwise indicated.

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 E 488, conducted by a qualified independent testing agency.

1. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

2.6 MISCELLANEOUS MATERIALS

A. 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.

B. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."

C. Etching Cleaner for Galvanized Metal: Complying with MPI#25.

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 D 1187.

F. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.

G. Anchoring Cement: Factory-packaged, nonshrink, nonstaining, hydraulic-controlled expansion cement formulation for mixing with water at Project site to create pourable anchoring, patching, and grouting compound.

1. Water-Resistant Product: At exterior locations provide formulation that is resistant to erosion from water exposure without needing protection by a sealer or waterproof coating and that is recommended by manufacturer for exterior use.

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. Fabricate connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

F. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.

G. Connections: Fabricate railings with either welded or nonwelded connections unless otherwise indicated.

H. 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 surfaces smooth and blended so no roughness shows after finishing and welded surface matches contours of adjoining surfaces.

I. Welded Connections for Aluminum Pipe: Fabricate railings to interconnect members with concealed internal welds that eliminate surface grinding, using manufacturer's standard system of sleeve and socket fittings.

J. Nonwelded Connections: Connect members with concealed mechanical fasteners and fittings. Fabricate members and fittings to produce flush, smooth, rigid, hairline joints.

1. Fabricate splice joints for field connection using an epoxy structural adhesive if this is manufacturer's standard splicing method.

K. Form changes in direction as follows:

1. As detailed.
2. By bending or by inserting prefabricated elbow fittings.

L. Bend members in jigs to produce uniform curvature for each configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.

M. Close exposed ends of railing members with prefabricated end fittings.

N. 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.

O. 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 prevent bracket or fitting rotation and crushing of substrate.

P. 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 FINISHES, GENERAL

A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

B. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.

C. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. 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. Galvanized Railings:

1. Hot-dip galvanize exterior steel and iron railings, including hardware, after fabrication.
2. Hot-dip galvanize indicated steel and iron railings, including hardware, after fabrication.
3. Comply with ASTM A 123/A 123M for hot-dip galvanized railings.
4. Comply with ASTM A 153/A 153M for hot-dip galvanized hardware.
5. Fill vent and drain holes that will be exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.

B. For galvanized railings, provide hot-dip galvanized fittings, brackets, fasteners, sleeves, and other ferrous components.

2.10 ALUMINUM FINISHES

A. Clear Anodic Finish: AAMA 611, AA-M12C22A41, Class I, 0.018 mm or thicker.

PART 3 - EXECUTION

3.1 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. Corrosion Protection: Coat concealed surfaces of aluminum that will be in contact with grout, concrete, masonry, wood, or dissimilar metals, with a heavy coat of bituminous paint.

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.

3.2 RAILING CONNECTIONS

A. Nonwelded Connections: Use mechanical or adhesive joints for permanently connecting railing components. 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.

3.3 ATTACHING RAILINGS

A. Anchor railing ends at walls with round flanges anchored to wall construction and connected to railing ends using nonwelded connections.

B. Attach railings to wall 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 flange tapped for concealed anchorage to threaded hanger bolt.
2. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads.

C. 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 hollow masonry anchorage, use toggle bolts.

3.4 ADJUSTING AND CLEANING

A. Clean aluminum by washing thoroughly with clean water and soap and rinsing with clean water.

B. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

3.5 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.

END OF SECTION 05 52 13

SECTION 05 75 00 - DECORATIVE FORMED METAL

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. Proscenium panels.
2. Column covers.

B. Related Sections:

1. Section 05 50 00 "Metal Fabrications" for non-decorative metal fabrications.
2. Section 07 71 00 "Roof Specialties" for items made of formed metal for parapets and copings.

1.3 PERFORMANCE REQUIREMENTS

A. Delegated Design: Design exterior decorative formed metal items, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

B. Structural Performance: Decorative formed metal items, including anchors and connections, shall withstand the effects of gravity loads and the following loads and stresses without exceeding the allowable design working stress of materials involved and without exhibiting permanent deformation in any components:

1. Wind Loads on Exterior Items: As indicated on Drawings.

C. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.

1. Temperature Change: 120 deg F (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.

D. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.

1.4 ACTION SUBMITTALS

A. Product Data: For each type of product indicated. Include finishing materials.

B. Shop Drawings: Show fabrication and installation details for decorative formed metal.

1. Include plans, elevations, component details, and attachments to other work.

2. Indicate materials and profiles of each decorative formed metal member, fittings, joinery, finishes, fasteners, anchorages, and accessory items.

C. Samples for Initial Selection: For products involving selection of color, texture, or design.

D. Samples for Verification: For each type of exposed finish required, prepared on 6-inch- (150-mm-) square Samples of metal of same thickness and material indicated for the Work.

E. 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.

1.5 INFORMATIONAL SUBMITTALS

A. Coordination Drawings: For decorative formed metal elements that house items specified in other Sections. Show dimensions of housed items, including locations of housing penetrations and attachments, and necessary clearances.

B. Mill Certificates: Signed by stainless-steel manufacturers certifying that products furnished comply with requirements.

C. Welding certificates.

D. LEED Submittals:

1. Product Data for Credit MR 4: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.
2. Product Data for Credit IEQ 4.1: For adhesives and sealants, documentation including printed statement of VOC content.
3. Laboratory Test Reports for Credit IEQ 4: For adhesives, sealants and paints and coatings, documentation indicating that products comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."

1.6 QUALITY ASSURANCE

A. Fabricator Qualifications: A firm experienced in producing decorative formed metal similar to that indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.

B. Organic-Coating Applicator Qualifications: A firm experienced in successfully applying organic coatings of type indicated to metals of types indicated and that employs competent control personnel to conduct continuing, effective quality-control program to ensure compliance with requirements.

C. Installer Qualifications: Fabricator of products.

D. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
2. AWS D1.3, "Structural Welding Code - Sheet Steel."
3. AWS D1.6, "Structural Welding Code - Stainless Steel."

E. Preinstallation Conference: Conduct conference at Project site

1.7 DELIVERY, STORAGE, AND HANDLING

A. Deliver decorative formed metal products wrapped in protective coverings and strapped together in suitable packs or in heavy-duty cartons. Remove protective coverings before they stain or bond to finished surfaces.

B. Store products on elevated platforms in a dry location.

1.8 PROJECT CONDITIONS

A. Field Measurements: Verify actual locations of walls, columns, beams, and other construction contiguous with decorative formed metal by field measurements before fabrication and indicate measurements on Shop Drawings.

1.9 COORDINATION

A. Coordinate installation of anchorages for decorative formed metal items. 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.

B. Coordinate installation of decorative formed metal with adjacent construction to ensure that wall assemblies, flashings, trim, and joint sealants, are protected against damage from the effects of weather, age, corrosion, and other causes.

PART 2 - PRODUCTS

2.1 SHEET METAL

A. General: Provide sheet metal without pitting, seam marks, roller marks, stains, discolorations, or other imperfections where exposed to view on finished units.

B. Retain "Recycled Content of Steel Products" Paragraph below if required for LEED Credit MR 4. USGBC allows a default value of 25 percent to be used for steel, without documentation; higher percentages can be claimed if they are supported by appropriate documentation. The Steel Recycling Institute indicates that steel sheet typically has 23 percent postconsumer recycled content and 1.5 percent preconsumer recycled content.Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than **[25]** <**Insert number**> percent.

C. Steel Sheet: Uncoated, cold-rolled, ASTM A 1008/A 1008M, commercial steel, exposed.

D. Stainless-Steel Sheet: ASTM A 240/A 240M or ASTM A 666, Type 316, stretcher-leveled standard of flatness.

2.2 MISCELLANEOUS MATERIALS

A. Fasteners: Fabricated from same basic metal and alloy as fastened metal unless otherwise indicated. Do not use metals that are incompatible with materials joined.

1. Provide concealed fasteners for interconnecting decorative formed metal items and for attaching them to other work unless otherwise indicated.
2. Provide tamper-resistant flat-head machine screws for exposed fasteners unless otherwise indicated.

B. Structural Anchors: For applications indicated to comply with certain design loads, provide anchors with capability to sustain, 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 per ASTM E 488 conducted by a qualified independent testing agency.

C. Nonstructural Anchors: For applications not indicated to comply with design loads, provide of type, size, and material necessary for type of load and installation indicated, as recommended by manufacturer, unless otherwise indicated.

D. Anchor Materials:

1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.
2. Material Where Stainless Steel Is Indicated: Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

E. Backing Materials: Provided or recommended by decorative formed metal manufacturer.

2.3 FABRICATION, GENERAL

A. Shop Assembly: Preassemble decorative formed metal items in 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.

B. Coordinate dimensions and attachment methods of decorative formed metal items with those of adjoining construction to produce integrated assemblies with closely fitting joints and with edges and surfaces aligned unless otherwise indicated.

C. Form metal to profiles indicated, in maximum lengths to minimize joints. Produce flat, flush surfaces without cracking or grain separation at bends. Fold back exposed edges of unsupported sheet metal to form a 1/2-inch- (12-mm-) wide hem on the concealed side, or ease edges to a radius of approximately 1/32 inch (1 mm) and support with concealed stiffeners.

D. Increase metal thickness or reinforce with concealed stiffeners, backing materials, or both, as needed to provide surface flatness equivalent to stretcher-leveled standard of flatness and sufficient strength for indicated use.

1. Support joints with concealed stiffeners as needed to hold exposed faces of adjoining sheets in flush alignment.

E. Build in straps, plates, and brackets as needed to support and anchor fabricated items to adjoining construction. Reinforce decorative formed metal items as needed to attach and support other construction.

F. Provide support framing, mounting and attachment clips, splice sleeves, fasteners, and accessories needed to install decorative formed metal items.

G. Where welding or brazing is indicated, weld or braze joints and seams continuously. Grind, fill, and dress to produce smooth, flush, exposed surfaces in which joints are not visible after finishing is completed.

1. Use welding and brazing procedures that will blend with and not cause discoloration of metal being joined.

2.4 PROSCENIUM PANELS

A. Manufacturers: Subject to compliance with requirements, available manufacturer offering products that may be incorporated into the Work include, but are not limited to, the following:

1. McNichols.

    a. Item Number: 1514511641; 0.25 inch dia. holes; 0.3125 inch hole centers, staggered; margins parallel to edge.

2. Stainless-Steel Sheet: 16 gauge.

    a. Finish: Mill.

2.5 COLUMN COVERS

A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

1. ATAS International, Inc.
2. Construction Services, Inc.
3. Couturier Iron Craft, Inc.
4. Firestone Metal Products, LLC; Una-Clad.
5. Fry Reglet Corporation.
6. Hi-Tech Metals, Inc.
7. Industrial Louvers Inc.
8. Leed Himmel Industries, Inc.
9. Metal Sales & Service, Inc.; Metalwerks Division.
10. MM Systems Corporation.
11. Pittcon Industries.
12. Protean Construction Products, Inc.

B. Snap-Together Type: Form column covers to shapes indicated from metal of type and minimum thickness indicated below. Return vertical edges and bend to form hook that will engage continuous mounting clips.

1. Steel Sheet: 0.060 inch (1.87 mm).

    a. Finish: Powder coat.

2. Stainless-Steel Sheet: 0.074 inch (1.87 mm).

    a. Finish: No. 4.

3. Column covers may be fabricated from prefinished metal sheet in lieu of finishing after fabrication provided unfinished edges are concealed from view.
4. Form returns at vertical joints to provide 1/2-inch- (12-mm-) wide reveal at joints. Provide snap-in metal filler strips at reveals that leave reveals flush.
5. Fabricate column covers without horizontal joints.
6. Fabricate base ring to contrast with column covers.
7. Apply manufacturer's recommended sound-deadening insulation to backs of column covers.

2.6 GENERAL FINISH REQUIREMENTS

A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

B. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.

C. Finish after assembly.

D. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. 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.

2.7 STEEL SHEET FINISHES

A. Surface Preparation: Clean surfaces to comply with SSPC-SP 1, "Solvent Cleaning," to remove dirt, oil, grease, or other contaminants that could impair paint bond. Remove mill scale and rust, if present, from uncoated steel, complying with SSPC-SP 5/NACE No. 1, "White Metal Blast Cleaning," or with SSPC-SP 8, "Pickling."

B. Pretreatment: Immediately after cleaning, apply a conversion coating of type suited to organic coating applied over it.

C. Powder-Coat Finish: Immediately after cleaning and pretreating, apply manufacturer's standard thermosetting polyester or acrylic urethane powder coating with cured-film thickness not less than 1.5 mils (0.04 mm). Prepare, treat, and coat metal to comply with resin manufacturer's written instructions.

1. Color and Gloss: Match Architect's sample.

2.8 STAINLESS-STEEL FINISHES

A. Surface Preparation: Remove tool and die marks and stretch lines, or blend into finish.

B. Polished Finishes: Grind and polish surfaces to produce uniform finish, free of cross scratches.

1. Run grain of directional finishes with long dimension of each piece.

C. Directional Satin Finish: No. 4.

D. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

E. Mill finish for prosceneum panels.

PART 3 - EXECUTION

3.1 EXAMINATION

A. Examine substrates, areas, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of decorative formed metal.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

A. Locate and place decorative formed metal items level and plumb and in alignment with adjacent construction. Perform cutting, drilling, and fitting required to install decorative formed metal.

1. Do not cut or abrade finishes that cannot be completely restored in the field. Return items with such finishes to the shop for required alterations, followed by complete refinishing, or provide new units as required.

B. Use concealed anchorages where possible. Provide brass or lead washers fitted to screws where needed to protect metal surfaces and to make a weathertight connection.

C. Form tight joints with exposed connections accurately fitted together. Provide reveals and openings for sealants and joint fillers as indicated.

D. Install concealed gaskets, joint fillers, insulation, sealants, and flashings, as the Work progresses, to make exterior decorative formed metal items weatherproof.

E. Corrosion Protection: Apply bituminous paint or other permanent separation materials on concealed surfaces where metals would otherwise be in direct contact with substrate materials that are incompatible or could result in corrosion or deterioration of either material or finish.

3.3 ADJUSTING AND CLEANING

A. Unless otherwise indicated, clean metals by washing thoroughly with clean water and soap, rinsing with clean water, and drying with soft cloths.

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.

3.4 PROTECTION

A. Protect finishes of decorative formed metal items from damage during construction period. Remove temporary protective coverings at time of Substantial Completion.

END OF SECTION 05 75 00