

SECTION 055113

METAL PAN STAIRS

PART 1 - GENERAL

1.1 DESCRIPTION

- A. Preassembled steel stairs with concrete-filled and treads.
- B. Stainless steel tube railings attached to metal stairs.
- C. Stainless steel tube handrails attached to walls adjacent to metal stairs.
- D. Stainless steel mesh infill.
- E. Railing gates at the level of exit discharge.

1.2 RELATED WORK

- A. Sustainable design requirements and procedures including submittal requirements: Section 018111, SUSTAINABLE DESIGN.
- B. Procedures and requirements for managing and disposing construction and demolition waste: Section 017419, CONSTRUCTION WASTE MANAGEMENT.
- C. Section 033000 "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
- D. Section 051250, ARCHITECTURALLY EXPOSED STRUCTURAL STEEL.
- E. Section 057100, DECORATIVE METAL STAIRS.

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 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. Provide per Section 051200 STRUCTURAL STEEL FRAMING.
- C. LEED Submittals: Submit in accordance with Section 018111.02.

1. LEED submittals are in addition to other submittals. If submitted item is identical to that submitted to comply with other requirements, submit duplicate copies as a separate submittal to verify compliance with indicated LEED requirements.
 2. LEED Product Data Submittal Form: Submit completed product data form provided by the Contracting Officer's Representative; certified by vendor, installer, subcontractor, and/or manufacturer as appropriate.
- D. Samples for Verification: For each type and finish of nosing.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: Fabricator of products.
- B. Qualifications: Qualify procedures and personnel according to the following:
1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
 2. AWS D1.6/D1.6M, "Structural Welding Code - Stainless Steel."

PART 2 - PRODUCTS

2.1 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, 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, unless another grade is required by design loads.
- H. Galvanized-Steel Sheet: ASTM A 653/A 653M, G90 coating, either commercial steel, Type B, or structural steel, Grade 33, unless another grade is required by design loads.
- I. Stainless Steel:
1. Tubing: ASTM A 554, Grade MT 304.
 2. Pipe: ASTM A 312/A 312M, Grade TP 304.
 3. Plate and Sheet: ASTM A 240/A 240M or ASTM A 666, Type 304.
 4. ~~Perforated Metal: Stainless steel sheet, ASTM A 240/A 240M or ASTM A 666, Type 304. (ADD#01)~~
 5. Welded Wire Mesh: Stainless steel with 1" x 1" openings, welded 0.135" gage wire in square mesh pattern. (ADD#01)

2.2 ABRASIVE NOSINGS

- A. Cast-Metal Units: Cast aluminum, with an integral abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.
 - 1. Configuration: Cross-hatched units, 3 inches wide without lip.
- B. Extruded Units: Aluminum units with abrasive filler consisting of aluminum oxide, silicon carbide, or a combination of both, in an epoxy-resin binder. Fabricate units in lengths necessary to accurately fit openings or conditions.
 - 1. Provide ribbed units, with abrasive filler strips projecting 1/16 inch above aluminum extrusion.
- C. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- D. Apply clear lacquer to concealed surfaces of extruded units set into concrete.

2.3 FASTENERS

- A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941, 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: Provide per Section 051200 STRUCTURAL STEEL FRAMING.
- C. Anchor Bolts: Provide per Section 051200 STRUCTURAL STEEL FRAMING.
- D. Post-Installed Anchors: Provide per Section 051200 STRUCTURAL STEEL FRAMING.

2.4 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. Shop Primers: Provide primers that comply with Section 099113 "Exterior Painting" and Section 099123 "Interior Painting." Section 099600 "High-Performance Coatings." Section 099113 "Exterior Painting," Section 099123 "Interior Painting," and Section 099600 "High-Performance Coatings."
- C. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- D. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- E. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187/D 1187M.

- F. Concrete Materials and Properties: Comply with requirements in Section 033000 "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi unless otherwise indicated.
- G. Welded Wire Reinforcement: ASTM A 185/A 185M, 6 by 6 inches, W1.4 by W1.4, unless otherwise indicated.
- H. ~~Perforated-Metal Infill: Type 304 stainless steel, perforated metal panels edged with U-shaped channels made from metal sheet, of same metal as perforated metal, and not less than 0.043 inch thick. Orient perforated metal with pattern as indicated on Drawings.(ADD#01)~~

2.5 FABRICATION, GENERAL

- A. See Section 051200 STRUCTURAL STEEL FRAMING. For framing exposed to view, see Section 051250 ARCHITECTURALLY EXPOSED STRUCTURAL STEEL.
- B. Provide complete stair assemblies, including metal framing, hangers, struts, railings, clips, brackets, bearing plates, and other components as indicated on the drawings.
- C. 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.
- D. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- E. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- F. Form exposed work with accurate angles and surfaces and straight edges.
- G. 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 4 welds: good quality, uniform undressed weld with minimal splatter.
- H. 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.

2.6 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: As indicated on drawings.
- 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 (1.7mm).
 - 1. Steel Sheet: Uncoated cold -rolled steel sheet unless otherwise indicated.
 - 2. Steel Sheet: Galvanized-steel sheet, where indicated.
 - 3. 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.
 - 4. 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.
 - 5. Shape metal pans to include nosing integral with riser.
 - 6. Attach abrasive nosings to risers.
 - 7. At Contractor's option, provide stair assemblies with metal pan subtreads filled with reinforced concrete during fabrication.
 - 8. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.
 - a. Smooth Soffit Construction: Construct subplatforms with flat metal under surfaces to produce smooth soffits.

2.7 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: Stainless steel, see Drawings.
 - 2. ~~Perforated-Metal Infill: Perforated-metal panels edged with U-shaped channels made from metal sheet, of same metal as perforated metal, and not less than 0.043 inch thick. Orient perforated metal with pattern as indicated on Drawings.~~(ADD#01)
 - 3. Mesh Infill: Woven wire mesh crimped into 1-by-1/2-by-1/8-inch steel channel frames. Orient wire mesh with ~~{diamonds vertical}~~~~{wires perpendicular and parallel to top rail}~~~~{wires horizontal and vertical}~~.(ADD#01)
 - 4. Gates: Form gates from steel tube of same size and shape as top rails, with infill to match guards. Provide with cam-type, self-closing hinges for fastening to wall and overlapping stop with rubber bumper to prevent gate from opening in direction opposite egress.
- 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. As detailed.
 2. By inserting prefabricated .
- D. Close exposed ends of railing members with prefabricated end fittings.
- E. 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 or less.
- F. Connect posts to stair framing by direct welding unless otherwise indicated.
- G. 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 galvanized railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
 2. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
 3. Provide type of bracket with flange tapped for concealed anchorage to threaded hanger bolt and that provides 1-1/2-inch clearance from inside face of handrail to finished wall surface.
- H. 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.

2.8 FINISHES

- A. Finish metal stairs after assembly.
- B. 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.
 2. Fill vent and drain holes that are exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.
- C. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with SSPC-SP 3, "Power Tool Cleaning."
- D. 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.

E. Stainless Steel Finishes:

1. Remove tool and die marks and stretch lines, or blend into finish.
2. Grind and polish surfaces to produce uniform, directionally textured, polished finish indicated, free of cross scratches. Run grain with long dimension of each piece.
3. Directional Satin Finish: No. 4.

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 033000 "Cast-in-Place Concrete."
 1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.
- H. Install precast concrete treads with adhesive supplied by manufacturer.

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.

1. For concrete use drilled-in expansion shields and hanger or lag bolts.
2. ~~For wood stud partitions, use hanger or lag bolts set into studs or wood backing between studs. Coordinate with carpentry work to locate backing members.(ADD#01)~~
3. For steel-framed partitions, use self-tapping screws fastened to steel framing or to concealed steel reinforcements.
4. For steel-framed partitions, use toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.

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 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 099100 Painting.
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

3.4 CONSTRUCTION WASTE MANAGEMENT

- A. General: Comply with Contractor's Waste Management Plan and Section 017419, CONSTRUCTION WASTE MANAGEMENT.
- B. To the greatest extent possible, separate reusable and recyclable products from contaminated waste and debris in accordance with the Contractor's Waste Management Plan. Place recyclable and reusable products in designated containers and protect from moisture and contamination.

END OF SECTION