

**SECTION 05 50 00**  
**METAL FABRICATIONS**

**PART 1 - GENERAL**

**1.1 DESCRIPTION**

- A. This section specifies items and assemblies fabricated from structural steel shapes and other materials as shown and specified.
- B. Items specified.
  - 1. Gas Racks
  - 2. Trap Doors with Ceiling Hatch
  - 3. Slotted channel framing.
  - 4. Gratings.

**1.2 RELATED WORK**

- A. Prime and finish painting: Section 09 91 00, PAINTING.
- B. Stainless steel corner guards: Section 10 26 00, WALL AND DOOR PROTECTION.

**1.3 SUBMITTALS**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Manufacturer's Literature and Data: Gas racks, trap doors, grating each type, and slotted channel framing.
- C. Shop Drawings:
  - 1. Each item specified, showing complete detail, location in the project, material and size of components, method of joining various components and assemblies, finish, and location, size and type of anchors.
  - 2. Mark items requiring field assembly for erection identification and furnish erection drawings and instructions.
  - 3. Provide templates and rough-in measurements as required.
- D. Manufacturer's Certificates:
  - 1. Live load designs as specified.
- E. Design Calculations for specified live loads including dead loads for items not designed already.
- F. Furnish setting drawings and instructions for installation of anchors to be preset into concrete and masonry work, and for the positioning of items having anchors to be built into concrete or masonry construction.

#### 1.4 QUALITY ASSURANCE

- A. Each manufactured product shall meet, as a minimum, the requirements specified, and shall be a standard commercial product of a manufacturer regularly presently manufacturing items of type specified.
- B. Each product type shall be the same and be made by the same manufacturer.
- C. Assembled product to the greatest extent possible before delivery to the site.
- D. Include additional features, which are not specifically prohibited by this specification, but which are a part of the manufacturer's standard commercial product.

#### 1.5 APPLICABLE PUBLICATIONS

- A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only.
- B. American Society of Mechanical Engineers (ASME):
  - B18.6.1-81(R1997) .....Wood Screws
  - B18.2.2-87(R2005) .....Square and Hex Nuts
- C. American Society for Testing and Materials (ASTM):
  - A36/A36M-05 .....Structural Steel
  - A47-99(R2004) .....Malleable Iron Castings
  - A53-06 .....Pipe, Steel, Black and Hot-Dipped, Zinc-Coated  
Welded and Seamless
  - A123-02 .....Zinc (Hot-Dip Galvanized) Coatings on Iron and  
Steel Products
  - A269-07 .....Seamless and Welded Austenitic Stainless Steel  
Tubing for General Service
  - A307-07 .....Carbon Steel Bolts and Studs, 60,000 PSI  
Tensile Strength
  - A786/A786M-05 .....Rolled Steel Floor Plate
  - C1107-07 .....Packaged Dry, Hydraulic-Cement Grout  
(Nonshrink)
  - F436-07 .....Hardened Steel Washers
  - F468-06 .....Nonferrous Bolts, Hex Cap Screws, and Studs for  
General Use
  - F593-02 .....Stainless Steel Bolts, Hex Cap Screws, and  
Studs
  - F1667-05 .....Driven Fasteners: Nails, Spikes and Staples

- D. National Association of Architectural Metal Manufacturers (NAAMM)
  - AMP521-01 .....Pipe Railing Manual
  - AMP 500-505-1988 .....Metal Finishes Manual

## **PART 2 - PRODUCTS**

### **2.1 DESIGN CRITERIA**

- A. In addition to the dead loads, design fabrications to support the following live loads unless otherwise specified.
- B. Slotted Channel Framing:
  - 1. Design system such that deflection will not exceed 1/720th of span in any plane.
  - 2. Design support structure such that standard modular 24 inch ceiling fixtures and equipment may be used.
  - 3. Design system to support either a concentrated load of 1,500 pounds at any single point along the exposed rails or the maximum that will be encountered by positioning the equipment at extremities of its travel (maximum load configuration), whichever is greater.
  - 4. Design the system with a factor of safety of 3 based on ultimate strength under static loading conditions.

### **2.2 MATERIALS**

- A. Structural Steel: ASTM A36.
- B. Stainless Steel: ASTM A167, Type 302 or 304.
- C. Floor Plate:
  - 1. Steel ASTM A786.
- D. Steel Pipe: ASTM A53.
  - 1. Galvanized for exterior locations.
  - 2. Type S, Grade A unless specified otherwise.
  - 3. NPS (inside diameter) as shown.
- E. Cast-Iron: ASTM A48, Class 30, commercial pattern.
- F. Malleable Iron Castings: A47.
- G. Primer Paint: As specified in Section 09 91 00, PAINTING.
- H. Stainless Steel Tubing: ASTM A269, type 302 or 304.
- I. Grout: ASTM C1107, pourable type.

### **2.3 HARDWARE**

- A. Rough Hardware:
  - 1. Furnish rough hardware with a standard plating, applied after punching, forming and assembly of parts; galvanized, cadmium plated, or zinc-coated by electro-galvanizing process. Galvanized G-90 where specified.

2. Use G90 galvanized coating on ferrous metal for exterior work unless non-ferrous metal or stainless is used.

B. Fasteners:

1. Bolts with Nuts:

- a. ASME B18.2.2.
- b. ASTM A307 for 415 MPa (60,000 psi) tensile strength bolts.
- c. ASTM F468 for nonferrous bolts.
- d. ASTM F593 for stainless steel.

2. Screws: ASME B18.6.1.

3. Washers: ASTM F436, type to suit material and anchorage.

4. Nails: ASTM F1667, Type I, style 6 or 14 for finish work.

**2.4 FABRICATION GENERAL**

A. Material

1. Use material as specified. Use material of commercial quality and suitable for intended purpose for material that is not named or its standard of quality not specified.
2. Use material free of defects which could affect the appearance or service ability of the finished product.

B. Size:

1. Size and thickness of members as shown.
2. When size and thickness is not specified or shown for an individual part, use size and thickness not less than that used for the same component on similar standard commercial items or in accordance with established shop methods.

C. Connections

1. Except as otherwise specified, connections may be made by welding, riveting or bolting.
2. Field riveting will not be approved.
3. Design size, number and placement of fasteners, to develop a joint strength of not less than the design value.
4. Holes, for rivets and bolts: Accurately punched or drilled and burrs removed.
5. Size and shape welds to develop the full design strength of the parts connected by welds and to transmit imposed stresses without permanent deformation or failure when subject to service loadings.
6. Use Rivets and bolts of material selected to prevent corrosion (electrolysis) at bimetallic contacts. Plated or coated material will not be approved.

7. Use stainless steel connectors for removable members machine screws or bolts.

D. Fasteners and Anchors

1. Use methods for fastening or anchoring metal fabrications to building construction as shown or specified.
2. Where fasteners and anchors are not shown, design the type, size, location and spacing to resist the loads imposed without deformation of the members or causing failure of the anchor or fastener, and suit the sequence of installation.
3. Use material and finish of the fasteners compatible with the kinds of materials which are fastened together and their location in the finished work.
4. Fasteners for securing metal fabrications to new construction only, may be by use of threaded or wedge type inserts or by anchors for welding to the metal fabrication for installation before the concrete is placed or as masonry is laid.
5. Fasteners for securing metal fabrication to existing construction or new construction may be expansion bolts, toggle bolts, power actuated drive pins, welding, self drilling and tapping screws or bolts.

E. Workmanship

1. General:
  - a. Fabricate items to design shown.
  - b. Furnish members in longest lengths commercially available within the limits shown and specified.
  - c. Fabricate straight, true, free from warp and twist, and where applicable square and in same plane.
  - d. Provide holes, sinkages and reinforcement shown and required for fasteners and anchorage items.
  - e. Provide openings, cut-outs, and tapped holes for attachment and clearances required for work of other trades.
  - f. Prepare members for the installation and fitting of hardware.
  - g. Fabricate surfaces and edges free from sharp edges, burrs and projections which may cause injury.
  - h. Cut openings in gratings for the passage of ducts, sumps, pipes, conduits and similar items. Provide reinforcement to support cut edges.
2. Welding:

- a. Weld in accordance with AWS.
  - b. Welds shall show good fusion, be free from cracks and porosity and accomplish secure and rigid joints in proper alignment.
  - c. Where exposed in the finished work, continuous weld for the full length of the members joined and have depressed areas filled and protruding welds finished smooth and flush with adjacent surfaces.
  - d. Finish welded joints to match finish of adjacent surface.
3. Joining:
- a. Miter or butt members at corners.
  - b. Where frames members are butted at corners, cut leg of frame member perpendicular to surface, as required for clearance.
4. Anchors:
- a. Where metal fabrications are shown to be preset in concrete, weld 32 x 3 mm (1-1/4 by 1/8 inch) steel strap anchors, 150 mm (6 inches) long with 25 mm (one inch) hooked end, to back of member at 600 mm (2 feet) on center, unless otherwise shown.
  - b. Where metal fabrications are shown to be built into masonry use 32 x 3 mm (1-1/4 by 1/8 inch) steel strap anchors, 250 mm (10 inches) long with 50 mm (2 inch) hooked end, welded to back of member at 600 mm (2 feet) on center, unless otherwise shown.
5. Cutting and Fitting:
- a. Accurately cut, machine and fit joints, corners, copes, and miters.
  - b. Fit removable members to be easily removed.
  - c. Design and construct field connections in the most practical place for appearance and ease of installation.
  - d. Fit pieces together as required.
  - e. Fabricate connections for ease of assembly and disassembly without use of special tools.
  - f. Joints firm when assembled.
  - g. Conceal joining, fitting and welding on exposed work as far as practical.
  - h. Do not show rivets and screws prominently on the exposed face.
  - i. The fit of components and the alignment of holes shall eliminate the need to modify component or to use exceptional force in the assembly of item and eliminate the need to use other than common tools.

F. Finish:

1. Finish exposed surfaces in accordance with NAAMM Metal Finishes Manual.
2. Steel and Iron: NAAMM AMP 504.
  - a. Zinc coated (Galvanized): ASTM A123, G90 unless noted otherwise.
  - b. Surfaces exposed in the finished work:
    - 1) Finish smooth rough surfaces and remove projections.
    - 2) Fill holes, dents and similar voids and depressions with epoxy type patching compound.
  - c. Shop Prime Painting:
    - 1) Surfaces of Ferrous metal:
      - a) Items not specified to have other coatings.
      - b) Galvanized surfaces specified to have prime paint.
      - c) Remove all loose mill scale, rust, and paint, by hand or power tool cleaning as defined in SSPC-SP2 and SP3.
      - d) Clean of oil, grease, soil and other detrimental matter by use of solvents or cleaning compounds as defined in SSPC-SP1.
      - e) After cleaning and finishing apply one coat of primer as specified in Section 09 91 00, PAINTING.
    - 2) Non ferrous metals: Comply with MAAMM-500 series.
3. Stainless Steel: NAAMM AMP-504 Finish No. 4.

G. Protection:

1. Spot prime all abraded and damaged areas of zinc coating which expose the bare metal, using zinc rich paint on hot-dip zinc coat items and zinc dust primer on all other zinc coated items.

**2.5 SUPPORTS**

A. General:

1. Fabricate ASTM A36 structural steel shapes as shown.
2. Use clip angles or make provisions for welding hangers and braces to overhead construction.
3. Field connections may be welded or bolted.

B. For Wall Mounted Items:

1. For items supported by metal stud partitions.
2. Steel strip or hat channel minimum of 1.5 mm (0.0598 inch) thick.
3. Steel strip minimum of 150 mm (6 inches) wide, length extending one stud space beyond end of item supported.

4. Steel hat channels where shown. Flange cut and flattened for anchorage to stud.
5. Structural steel tube or channel for grab bar at water closets floor to structure above with clip angles or end plates formed for anchors.

## **2.6 TRAP DOOR AND FRAMES WITH CEILING HATCH**

- A. Design to support a live load as specified.
- B. Frames:
  1. Fabricate steel angle frame to set in concrete slabs and design to set flush with finished concrete slab or curb. If not shown use 63 x 63 x 6 mm (2-1/2 x 2-1/2 x 1/4 inch) angles.
  2. Miter steel angles at corners and weld together.
  3. Weld steel bar stops to vertical leg of frame, to support doors flush with the top of the frame.
  4. Weld steel strap anchors on each side not over 600 mm (24 inches) on center to the backs of the frames. If not shown use 6 x 50 x 200 mm (1/4 x 2 x 8 inch) long straps with 50 mm (2 inch bent) ends.
  5. Form frames from steel angles with welded corners for reinforcing and bracing of well lining and support of ceiling hatch.
- C. Covers:
  1. Use 6 mm (1/4 inch) thick steel floor plate.
  2. Where double leaf covers are shown, reinforce at meeting edges.
  3. Use wrought steel hinges with fixed brass pins.
    - a. Weld to cover.
    - b. Secure to frame with machine screws.
  4. Provide two bar type drop handles, flush with cover when closed for each leaf.
- D. Well Lining:
  1. Fabricate well linings, for access through concrete floor slabs and suspended ceilings, from hatch to ceiling hatch or ceiling openings.
  2. Use steel sheet and shapes of size and thickness as shown. If not shown use 1.5 mm (0.0598 inch) thick steel sheet.
  3. If not shown use 50 x 50 x 6 mm (2 x 2 x 1/4 inch) angle braces from ceiling level on each side angled at 45 degrees to structure above.
  4. Use 25 x 25 x 3 mm (1 x 1 x 1/8 inch) angle bottom flange trim welded to well lining where no ceiling hatch occurs.
- E. Ceiling Hatch:



1. Construct hatch with "T" or angle frame designed to support edge of ceiling and hatch, weld to well lining.
2. Form hatch panels of 3 mm (1/8 inch) steel or 1 mm (0.0359 inch) thick steel of pan type construction with 25 mm (one inch) of mineral fiber insulation between.
3. Use counter balance device, hinges, latch, hangers and other accessories required for installation and operation of hatch with not over 90 N (20 pounds) of force.
4. Fabricate panels flush and reinforced to remain flat.
5. Locate hatch panel flush with frame.

F. Finish with baked on prime coat.

## **2.7 SLOTTED CHANNEL FRAMING:**

- A. Factory fabricated, channel shaped, cold formed sheet steel shapes, complete with fittings bolts and nuts required for assembly with continuous slot complying with MFMA-3.
- B. Material: Steel complying with ASTM A 1008/A 1008M, commercial steel, Type B; 0.0966-inch (2.5-mm) minimum thickness; coated with rust-inhibitive, baked-on, acrylic enamel.
- C. Form channel within turned pyramid shaped clamping ridges on each side.
- D. Provide case hardened steel nuts with serrated grooves in the top edges designed to be inserted in the channel at any point and be given a quarter turn so as to engage the channel clamping ridges. Provide each nut with a spring designed to hold the nut in place.
- E. Fabricate snap-in closure plates to fit and close exposed channel openings of not more than 0.3 mm (0.0125 inch) thick stainless steel.

## **2.8 GRATINGS**

- A. Provide clearance at all sides to permit easy removal of grating.
- B. Make cutouts in gratings with 6 mm (1/4 inch) minimum to 25 mm (one inch) maximum clearance for penetrations or passage of pipes and ducts. Edge band cutouts.
- C. Fabricate in sections not to exceed 2.3 m<sup>2</sup> (25 square feet) in area and 90 kg (200 pounds) in weight.
- D. Fabricate sections of grating with end-banding bars.
- E. Fabricate angle frames and supports, including anchorage as shown.
  1. Fabricate intermediate supporting members from "T's" or angles.
  2. Locate intermediate supports to support grating section edges.
  3. Fabricate frame to finish flush with top of grating.
  4. Locate anchors at ends and not over 600 mm (24 inches) o.c.

5. Butt or miter, and weld angle frame at corners.

F. Steel Bar Gratings:

1. Fabricate grating using steel bars, frames, supports and other members shown in accordance with Metal Bar Grating Manual.
2. Interior gratings: Prime paint unless specified galvanized.

**PART 3 - EXECUTION**

**3.1 INSTALLATION, GENERAL**

- A. Set work accurately, in alignment and where shown, plumb, level, free of rack and twist, and set parallel or perpendicular as required to line and plane of surface.
- B. Items set into concrete or masonry.
  1. Provide temporary bracing for such items until concrete or masonry is set.
  2. Place in accordance with setting drawings and instructions.
  3. Build strap anchors, into masonry as work progresses.
- C. Set frames of gratings and similar items flush with finish floor or wall surface and, where applicable, flush with side of opening.
- D. Field weld in accordance with AWS.
  1. Design and finish as specified for shop welding.
  2. Use continuous weld unless specified otherwise.
- E. Install anchoring devices and fasteners as shown and as necessary for securing metal fabrications to building construction as specified. Power actuated drive pins may be used except for removable items and where members would be deformed or substrate damaged by their use.
- F. Spot prime all abraded and damaged areas of zinc coating as specified and all abraded and damaged areas of shop prime coat with same kind of paint used for shop priming.
- G. Secure escutcheon plate with set screw.

**3.2 INSTALLATION OF SUPPORTS**

- A. Anchorage to structure.
  1. Secure angles or channels and clips to overhead structural steel by continuous welding unless bolting is shown.
  2. Secure supports to concrete inserts by bolting or continuous welding as shown.
  3. Secure supports to mid height of concrete beams when inserts do not exist with expansion bolts and to slabs, with expansion bolts. unless shown otherwise.

4. Secure steel plate or hat channels to studs as detailed.

B. Supports for Wall Mounted items:

1. Locate center of support at anchorage point of supported item.

2. Locate support at top and bottom of wall hung cabinets.

3. Locate support at top of floor cabinets and shelving installed against walls.

4. Locate supports where required for items shown.

**3.3 COVERS AND FRAMES FOR PITS AND TRENCHES**

A. Set frame and cover flush with finish floor.

B. Secure plates to frame with flat head countersunk screws.

C. Set gratings loose in drainage trenches or over pits unless shown anchored.

**3.4 GRATINGS**

A. Set grating flush with finish floor; top of curb, or areaway wall. Set frame so that horizontal leg of angle frame is flush with face of wall except when frame is installed on face of wall.

B. Set frame in formwork before concrete is placed.

C. Where grating terminates at a wall bolt frame to concrete or masonry with expansion bolts unless shown otherwise.

D. Secure removable supporting members in place with stainless steel bolts.

E. Bolt gratings to supports.

**3.5 CLEAN AND ADJUSTING**

A. Adjust movable parts including hardware to operate as designed without binding or deformation of the members centered in the opening or frame and, where applicable, contact surfaces fit tight and even without forcing or warping the components.

B. Clean after installation exposed prefinished and plated items and items fabricated from stainless steel, and copper alloys, as recommended by the metal manufacture and protected from damage until completion of the project.

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