

**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. Support for Wall and Ceiling Mounted Items: (SD055000-01, SD055000-02, SD102113-01, SD102600-01, SD123100-01 & SD123100-02)
 - 2. Covers and Frames for Pits and Trough.
 - 3. Gratings
 - 4. Gas Racks
 - 5. Ladders
 - 6. Railings:
 - 7. Catwalks and Platforms

1.2 RELATED WORK

- A. Colors, finishes, and textures: Section 09 06 00, SCHEDULE FOR FINISHES.
- B. Prime and finish painting: Section 09 91 00, PAINTING.
- C. Fuel storage tanks and fuel piping racks: Section 23 10 00, FACILITY FUEL SYSTEMS.
- D. Busways Supports: Section 26 05 33, RACEWAYS AND BOXES FOR ELECTRICAL SYSTEMS.

1.3 SUBMITTALS

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Manufacturer's Literature and Data:

Grating, each type	Floor plate
Through cover plates	Fuel tank platform
Ladders	Fuel piping rack
Manhole Covers	Bus duct hangers

- 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. Anodized finish as specified.
 - 2. Live load designs as specified.
- E. Design Calculations for specified live loads including dead loads.
- 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):
 - B18.6.1-97Wood Screws
 - B18.2.2-87(R2005) .Square and Hex Nuts
- C. American Society for Testing and Materials (ASTM):
 - A36/A36M-12.....Structural Steel
 - A47-99(R2009)Malleable Iron Castings
 - A48-03(R2012)Gray Iron Castings

- A53-12Pipe, Steel, Black and Hot-Dipped, Zinc-Coated
Welded and Seamless
- A123-12Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel
Products
- A240/A240M-14.....Standard Specification for Chromium and Chromium-
Nickel Stainless Steel Plate, Sheet and Strip for
Pressure Vessels and for General Applications.
- A269-10Seamless and Welded Austenitic Stainless Steel
Tubing for General Service
- A307-12Carbon Steel Bolts and Studs, 60,000 PSI Tensile
Strength
- A391/A391M-07(R2012) ... Grade 80 Alloy Steel Chain
- A786/A786M-09.....Rolled Steel Floor Plate
- B221-13Aluminum and Aluminum-Alloy Extruded Bars, Rods,
Wire, Shapes, and Tubes
- B456-11Electrodeposited Coatings of Copper Plus Nickel Plus
Chromium and Nickel Plus Chromium
- B632-08Aluminum-Alloy Rolled Tread Plate
- C1107-13.....Packaged Dry, Hydraulic-Cement Grout (Nonshrink)
- D3656-13.....Insect Screening and Louver Cloth Woven from Vinyl-
Coated Glass Yarns
- F436-11Hardened Steel Washers
- F468-06(R2012)Nonferrous Bolts, Hex Cap Screws, Socket Head Cap
Screws and Studs for General Use
- F593-13Stainless Steel Bolts, Hex Cap Screws, and Studs
- F1667-11Driven Fasteners: Nails, Spikes and Staples
- D. American Welding Society (AWS):
 - D1.1-10.....Structural Welding Code Steel
 - D1.2-08.....Structural Welding Code Aluminum
 - D1.3-08.....Structural Welding Code Sheet Steel
- E. National Association of Architectural Metal Manufacturers (NAAMM)
 - AMP 521-01.....Pipe Railing Manual
 - AMP 500-06.....Metal Finishes Manual
 - MBG 531-09Metal Bar Grating Manual
 - MBG 532-09Heavy Duty Metal Bar Grating Manual
- F. Structural Steel Painting Council (SSPC)/Society of Protective Coatings:

- SP 1-04.....No. 1, Solvent Cleaning
- SP 2-04.....No. 2, Hand Tool Cleaning
- SP 3-04.....No. 3, Power Tool Cleaning
- G. Federal Specifications (Fed. Spec):
 - RR-T-650E.....Treads, Metallic and Nonmetallic, Nonskid

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. Ladders and Rungs: 120 kg (250 pounds) at any point.
- C. Railings and Handrails: 900 N (200 pounds) in any direction at any point.
- D. Floor Plates, Gratings, Covers, Catwalks, and Platforms: 500 kg/m² (100 pounds per square foot).
- E. Manhole Covers: 1200 kg/m² (250 pounds per square foot).

2.2 MATERIALS

- A. Structural Steel: ASTM A36.
- B. Stainless Steel: ASTM A240, Type 302 or 304.
- C. Aluminum, Extruded: ASTM B221, Alloy 6063-T5 unless otherwise specified. For structural shapes use alloy 6061-T6 and alloy 6061-T4511.
- D. Floor Plate:
 - 1. Steel ASTM A786.
 - 2. Aluminum: ASTM B632.
- E. Steel Pipe: ASTM A53.
 - 1. Galvanized for exterior locations.
 - 2. Type S, Grade A unless specified otherwise.
 - 3. NPS (inside diameter) as shown.
- F. Cast-Iron: ASTM A48, Class 30, commercial pattern.
- G. Malleable Iron Castings: A47.
- H. Primer Paint: As specified in Section 09 91 00, PAINTING.
- I. Stainless Steel Tubing: ASTM A269, type 302 or 304.
- J. Modular Channel Units:
 - 1. Factory fabricated, channel shaped, cold formed sheet steel shapes, complete with fittings bolts and nuts required for assembly.

2. Form channel within turned pyramid shaped clamping ridges on each side.
 3. 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.
 4. Factory finish channels and parts with oven baked primer when exposed to view. Channels fabricated of ASTM A525, G90 galvanized steel may have primer omitted in concealed locations. Finish screws and nuts with zinc coating.
 5. 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.
- K. Grout: ASTM C1107, pourable type.
- L. Insect Screening: ASTM D3656.

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. Cut openings in gratings and floor plates for the passage of ducts, sumps, pipes, conduits and similar items. Provide reinforcement to support cut edges.
 - h. Fabricate surfaces and edges free from sharp edges, burrs and projections which may cause injury.
 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 AMP 500 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.
4. Stainless Steel: NAAMM AMP-504 Finish No. 4.

G. Protection:

1. Insulate aluminum surfaces that will come in contact with concrete, masonry, plaster, or metals other than stainless steel, zinc or white bronze by giving a coat of heavy-bodied alkali resisting bituminous paint or other approved paint in shop.
2. 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 Ceiling Hung Toilet Stall:

1. Use a continuous steel channel above pilasters with hangers centered over pilasters.
2. Make provision for installation of stud bolts in lower flange of channel.

3. Provide a continuous steel angle at wall and channel braces spaced as shown.
4. Use threaded rod hangers.
5. Provide diagonal angle brace where the suspended ceiling over toilet stalls does not extend to side wall of room.

2.6 GUARDS

- A. Wall Corner Guards:
 1. Fabricate from steel angles and furnish with anchors as shown.
 2. Continuously weld anchor to angle.
- B. Edge Guard Angles for Openings in slabs.
 1. Fabricate from steel angles of sizes and with anchorage shown.
 2. Where size of angle is not shown, provide 50 x 50 x 6 mm (2 x 2 x 1/4 inch) steel angle with 32 x 5 mm (1-1/4 x 3/16 inch) strap anchors, welded to back.
 3. Miter or butt angles at corners and weld.
 4. Use one anchor near end and three feet on centers between end anchors.
- C. Wheel Guards:
 1. Construct wheel guards of not less than 16 mm (5/8 inch) thick cast iron.
 2. Provide corner type, with flanges for bolting to walls.

2.7 COVERS AND FRAMES FOR PITS AND TROUGH

- A. Fabricate covers to support live loads specified.
- B. Galvanized steel members after fabrication in accordance with ASTM A123, G-90 coating.
- C. Steel Covers:
 1. Use 6 mm (1/4 inch) thick floor plate for covers unless otherwise shown. Use gratings where shown as specified in paragraph GRATINGS. Use smooth floor plate unless noted otherwise.
 2. Provide clearance at all sides to permit easy removal of covers.
 3. Make cutouts within 6 mm (1/4 inch) of penetration for passage of pipes and ducts.
 4. Drill covers for flat head countersunk screws.
 5. Make cover sections not to exceed 2.3 m² (25 square feet) in area and 90 kg (200 pounds) in weight.

6. Fabricate trough cover sections not be over 900 mm (3 feet) long and if width of trough is more than 900 mm (3 feet) or over, equip one end of each section with an angle or "T" bar stiffener to support adjoining plate.
7. Use two, 13 mm (1/2 inch) diameter steel bar flush drop handles for each cover section.

D. Cast Iron Covers

1. Fabricate covers to support live loads specified.
2. Fabricate from ASTM A48, cast-iron, 13 mm (1/2 inch) minimum metal thickness, cast with stiffeners as required.
3. Fabricate as flush type with frame, reasonably watertight and be equipped with flush type lifting rings. Provide seals where watertight covers noted.
4. Make covers in sections not over 90 kg (200 pounds) except round covers.

E. Steel Frames:

1. Form frame from structural steel angles as shown. Where not shown use 63 x 63 x 6 mm (2-1/2 x 2-1/2 x 1/4 inch) angles for frame openings over 1200 mm (4 feet) long and 50 x 50 x 6 mm (2 x 2 x 1/4 inch) for frame openings less than 1200 mm (4 feet).
2. Fabricate intermediate supporting members from steel "T's" or angles; located to support cover section edges.
3. Where covers are required use steel border bars at frames so that top of cover will be flush with frame and finish floor.
4. Weld steel strap anchors to frame. Space straps not over 600 mm (24 inches) o.c., not shown otherwise between end anchors. Use 6 x 25 x 200 mm (1/4 x 1 x 8 inches) with 50 mm (2 inch) bent ends strap anchors unless shown otherwise.
5. Drill and tap frames for screw anchors where plate covers occur.

F. Cast Iron Frames:

1. Fabricate from ASTM A48 cast iron to shape shown.
2. Provide anchors for embedding in concrete, spaced near ends and not over 600 mm (24 inches) apart.

2.8 GRATINGS

- A. Fabricate gratings to support live loads specified and a concentrated load as specified.
- B. Provide clearance at all sides to permit easy removal of grating.

- C. 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.
- D. Fabricate in sections not to exceed 2.3 m² (25 square feet) in area and 90 kg (200 pounds) in weight.
- E. Fabricate sections of grating with end-banding bars.
- F. 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.
- G. Steel Bar Gratings:
 - 1. Fabricate grating using steel bars, frames, supports and other members shown in accordance with Metal Bar Grating Manual.
 - 2. Galvanize steel members after fabrication in accordance with ASTM A123, G-90 for exterior gratings, gratings in concrete floors, and interior grating where specified.
 - 3. Interior gratings: Prime paint unless specified galvanized.

2.9 LADDERS

- A. Steel Ladders:
 - 1. Fixed-rail type with steel rungs shouldered and headed into and welded to rails.
 - 2. Fabricate angle brackets of 50 mm (2 inch) wide by 13 mm (1/2 inch) thick steel; brackets spaced maximum of 1200 mm (4 feet) apart and of length to hold ladder 175 mm (7 inches) from wall to center of rungs. Provide turned ends or clips for anchoring.
 - 3. Provide holes for anchoring with expansion bolts through turned ends and brackets.
 - 4. Where shown, fabricate side rails curved, twisted and formed into a gooseneck.
 - 5. Galvanize exterior ladders after fabrication, ASTM A123, G-90.
- B. Ladder Rungs:
 - 1. Fabricate from 25 mm (one inch) diameter steel bars.
 - 2. Fabricate so that rungs will extend at least 100 mm (4 inches) into wall with ends turned 50 mm (2 inches), project out from wall 175

mm (7 inches), be 400 mm (16 inches) wide and be designed so that foot cannot slide off end.

3. Galvanized after fabrication, ASTM A123, G-90 rungs for exterior use and for access to pits.

2.10 RAILINGS

- A. In addition to the dead load design railing assembly to support live load specified.
- B. Fabrication General:
 1. Provide continuous welded joints, dressed smooth and flush.
 2. Standard flush fittings, designed to be welded, may be used.
 3. Exposed threads will not be approved.
 4. Form handrail brackets to size and design shown.
 5. Exterior Post Anchors:
 - a. Fabricate tube or pipe sleeves with closed ends or plates as shown.
 - b. Where inserts interfere with reinforcing bars, provide flanged fittings welded or threaded to posts for securing to concrete with expansion bolts.
 - c. Provide heavy pattern sliding flange base plate with set screws at base of pipe or tube posts.
 6. Interior Post Anchors:
 - a. Provide flanged fittings for securing fixed posts to floor with expansion bolts, unless shown otherwise.
 - b. Weld or thread flanged fitting to posts at base.
 - c. For securing removable posts to floor, provide close fitting sleeve insert or inverted flange base plate with stud bolts or rivets concrete anchor welded to the base plate.
 - d. Provide sliding flange base plate on posts secured with set screws.
 - e. Weld flange base plate to removable posts set in sleeves.
- C. Handrails:
 1. Close free ends of rail with flush metal caps welded in place except where flanges for securing to walls with bolts are shown.
 2. Make provisions for attaching handrail brackets to wall, posts, and handrail as shown.
- D. Steel Pipe Railings:

1. Fabricate of steel pipe with welded joints.
2. Number and space of rails as shown.
3. Space posts for railings not over 1800 mm (6 feet) on centers between end posts.
4. Form handrail brackets from malleable iron.
5. Fabricate removable sections with posts at end of section.
6. Removable Rails:
 - a. Provide "U" shape brackets at each end to hold removable rail as shown. Use for top and bottom horizontal rail when rails are joined together with vertical members.
 - b. Secure rail to brackets with 9 mm (3/8 inch) stainless steel through bolts and nuts at top rail only when rails joined with vertical members.
 - c. Continuously weld brackets to post.
 - d. Provide slotted bolt holes in rail bracket.
 - e. Weld bolt heads flush with top of rail.
 - f. Weld flanged fitting to post where posts are installed in sleeves.
7. Opening Guard Rails:
 - a. Fabricate rails with flanged fitting at each end to fit between wall opening jambs.
 - b. Design flange fittings for fastening with machine screws to steel plate anchored to jambs.
 - c. Fabricate rails for floor openings for anchorage in sleeves.
8. Gates:
 - a. Fabricate from steel pipe as specified for railings.
 - b. Fabricate gate fittings from either malleable iron or wrought steel.
 - c. Hang each gate on suitable spring hinges of clamp on or through bolted type. Use bronze hinges for exterior gates.
 - d. Provide suitable stops, so that gate will swing as shown.
 - e. Provide padlock eyes where shown.
9. Chains:
 - a. Chains: ASTM A391, Grade 63, straight link style, normal size chain bar 8 mm (5/16 inch) diameter, eight links per 25

mm (foot) and with boat type snap hook on one end, and through type eye bolt on other end.

- b. Fabricate eye bolt for attaching chain to pipe posts, size not less than 9 mm (3/8 inch) diameter.
- c. Fabricate anchor at walls, for engagement of snap hook of either a 9 mm (3/8 inch) diameter eye bolt or punched angle.
- d. Galvanize chain and bolts after fabrication.

2.11 CATWALKS

- A. Fabricate catwalks including platforms, railings, ladders, supports and hangers, and arrangement of members as shown on drawings.
- B. Fabricate steel ladders as specified under paragraph LADDERS unless shown otherwise.
- C. Fabricate steel pipe railings as specified under paragraph RAILINGS.
- D. Catwalk and platforms floor surfaces as shown.
 - 1. Steel gratings as specified under paragraph gratings, either bar or plank type.
 - 2. Steel floor plate.
- E. Prime paint catwalk system.

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, covers, corner guards, 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. Isolate aluminum from dissimilar metals and from contact with concrete and masonry materials as required to prevent electrolysis and corrosion.
- H. 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 Trapeze Bars:
 - 1. Secure plates to overhead construction with fasteners as shown.
 - 2. Secure angle brace assembly to overhead construction with fasteners as shown and bolt plate to braces.
 - 3. Fit modular channel unit flush with finish ceiling, and secure to plate with modular channel unit manufacturer's standard fittings through steel shims or spreaders as shown.
 - a. Install closure plates in channel between eye bolts.
 - b. Install eyebolts in channel.

3.3 OTHER FRAMES

- A. Set frame flush with surface unless shown otherwise.
- B. Anchor frames at ends and not over 450 mm (18 inches) on centers unless shown otherwise.
- C. Set in formwork before concrete is placed.

3.4 GUARDS

- A. Steel Angle Corner Guards:
 - 1. Build into masonry as the work progress.
 - 2. Set into formwork before concrete is placed.

3. Set angles flush with edge of opening and finish floor or wall or as shown.
 4. At existing construction fasten angle and filler piece to adjoining construction with 16 mm (5/8 inch) diameter by 75 mm (3 inch) long expansion bolts 450 mm (18 inches) on center.
 5. Install Guard Angles at Edges of Trough Openings in Slab.
- B. Channel Guard at Top Edge of Concrete Platforms:
1. Install in formwork before concrete is placed.
 2. Set channel flush with top of the platform.
- C. Wheel Guards:
1. Set flanges of wheel guard at least 50 mm (2 inches) into pavement.
 2. Anchor to walls as shown, expansion bolt if not shown.

3.5 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.

3.6 STEEL LINTELS

- A. Use lintel sizes and combinations shown or specified.
- B. Install lintels with longest leg upstanding, except for openings in 150 mm (6 inch) masonry walls install lintels with longest leg horizontal.
- C. Install lintels to have not less than 150 mm (6 inch) bearing at each end for nonbearing walls, and 200 mm (8 inch) bearing at each end for bearing walls.

3.7 SHELF ANGLES

- A. Anchor shelf angles with 19mm (3/4 inch) bolts unless shown otherwise in adjustable malleable iron inserts, set level at elevation shown,
- B. Provide expansion space at end of members.

3.8 SHELF ANGLES

- A. Anchor shelf angles with 19 mm (3/4 inch) bolts unless shown otherwise in adjustable malleable iron inserts, set level at elevation shown.

- B. Provide expansion space at end of members.

3.9 LADDERS

- A. Anchor ladders to walls and floors with expansion bolts through turned lugs or angle clips or brackets.
- B. In elevator pits, set ladders to clear all elevator equipment where shown on the drawings.
 - 1. Where ladders are interrupted by division beams, anchor ladders to beams by welding, and to floors with expansion bolts.
 - 2. Where ladders are adjacent to division beams, anchor ladders to beams with bent steel plates, and to floor with expansion bolts.
- C. Ladder Rungs:
 - 1. Set ladder rungs into formwork before concrete is placed.
 - 2. Set step portion of rung 150 mm (6 inches) from wall.
 - 3. Space rungs approximately 300 mm (12 inches) on centers.
 - 4. Where only one rung is required, locate it 400 mm (16 inches) above the floor.

3.10 RAILINGS

- A. Steel Posts:
 - 1. Secure fixed posts to concrete with expansion bolts through flanged fittings except where sleeves are shown with pourable grout.
 - 2. Install sleeves in concrete formwork.
 - 3. Set post in sleeve and pour grout to surface. Apply beveled bead of urethane sealant at perimeter of post or under flange fitting as specified in Section 07 92 00, JOINT SEALANTS-on exterior posts.
 - 4. Secure removable posts to concrete with either machine screws through flanged fittings which are secured to inverted flanges embedded in and set flush with finished floor, or set posts in close fitting pipe sleeves without grout.
 - 5. Secure sliding flanged fittings to posts at base with set screws.
 - 6. Secure fixed flanged fittings to concrete with expansion bolts.
 - 7. Secure posts to steel with welds.
- B. Anchor to Walls:
 - 1. Anchor rails to concrete or solid masonry with machine screws through flanged fitting to steel plate.
 - a. Anchor steel plate to concrete or solid masonry with expansion bolts.

- b. Anchor steel plate to hollow masonry with toggle bolts.
 - 2. Anchor flanged fitting with toggle bolt to steel support in frame walls.
- C. Removable Rails:
 - 1. Rest rails in brackets at each end and secure to bracket with stainless steel bolts and nuts where part of a continuous railing.
 - 2. Rest rail posts in sleeves where not part of a continuous railing. Do not grout posts.
- D. Gates:
 - 1. Hang gate to swing as shown.
 - 2. Bolt gate hinges to jamb post with clamp on or through bolts.
- E. Chains:
 - 1. Eye bolt chains to pipe posts.
 - 2. Eye bolt anchoring at walls.
 - a. Expansion bolt to concrete or solid masonry.
 - b. Toggle bolt to hollow masonry of frame wall installed support.
- F. Handrails:
 - 1. Anchor brackets for metal handrails as detailed.
 - 2. Install brackets within 300 mm (12 inches) of return of walls, and at evenly spaced intermediate points not exceeding 1200 mm (4 feet) on centers unless shown otherwise.
 - 3. Expansion bolt to concrete or solid masonry.
 - 4. Toggle bolt to installed supporting frame wall and to hollow masonry unless shown otherwise.

3.11 CATWALK AND PLATFORMS

- A. Expansion bolt members to concrete unless shown otherwise.
- B. Bolt or weld structural components together including ladders and stairs to support system.
- C. Weld railings to structural framing.
- D. Bolt or weld walk surface to structural framing.
- E. Smooth field welds and spot prime damaged prime paint surface.
- F. Fasten removable members with stainless steel fasteners.

3.12 STEEL COMPONENTS FOR MILLWORK ITEMS

- A. Coordinate and deliver to Millwork fabricator for assembly where millwork items are secured to metal fabrications.

3.13 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, aluminum and copper alloys, as recommended by the metal manufacture and protected from damage until completion of the project.

END OF SECTION 05 50 00