

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:
 - 2. Loose Lintels
 - 3. Shelf Angles
 - 4. Elevator Machine Beams, Hoist Beams, and Divider Beams
 - 5. Pipe Bollards
 - 6. Pipe Guards
 - 7. Abrasive Metal Nosings and Thresholds
 - 8. Barrier Cable System
 - 9. Perforated Metal Screen Wall

1.2 RELATED WORK

- A. Prime and finish painting: Section 09 91 00, PAINTING.
- B. Metal stair railings: Section 05 52 13 - PIPE AND TUBE RAILINGS.

1.3 SUBMITTALS

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS AND PRODUCT DATA.
- B. 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.
 - a. Provide engineering calculations, signed and sealed by a qualified professional engineer, confirming that the fabrications will perform satisfactorily and will carry the specified live and dead loads.
 - 2. Mark items requiring field assembly for erection identification and furnish erection drawings and instructions.
 - 3. Provide templates and rough-in measurements as required.
- C. Manufacturer's Certificates:
 - 1. Anodized finish as specified.
 - 2. Live load designs as specified.

- D. 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-08..... Structural Steel
- A47-99(R2004)..... Malleable Iron Castings
- A48-03(R2008)..... Gray Iron Castings
- A53-07..... Pipe, Steel, Black and Hot-Dipped, Zinc-Coated
Welded and Seamless
- A123-08..... Zinc (Hot-Dip Galvanized) Coatings on Iron and
Steel Products
- A269-08..... Seamless and Welded Austenitic Stainless Steel
Tubing for General Service
- A307-07..... Carbon Steel Bolts and Studs, 60,000 PSI
Tensile Strength
- A653/A653M-08..... Steel Sheet, Zinc Coated (Galvanized) or Zinc-
Iron Alloy Coated (Galvannealed) by the Hot-Dip
Process

- B221-08..... Aluminum and Aluminum-Alloy Extruded Bars,
Rods, Wire, Shapes, and Tubes
- C1107-08..... Packaged Dry, Hydraulic-Cement Grout
(Nonshrink)
- F436-09..... Hardened Steel Washers
- F468-06..... Nonferrous Bolts, Hex Cap Screws, and Studs for
General Use
- F593-02(2008)..... Stainless Steel Bolts, Hex Cap Screws, and
Studs
- F1667-05..... Driven Fasteners: Nails, Spikes and Staples
- D. American Welding Society (AWS):
- D1.1-04..... Structural Welding Code Steel
- D1.2-03..... Structural Welding Code Aluminum
- D1.3-98..... Structural Welding Code Sheet Steel
- E. National Association of Architectural Metal Manufacturers (NAAMM)
- AMP 500-505-1988..... Metal Finishes Manual
- F. Structural Steel Painting Council (SSPC):
- SP 1-05..... No. 1, Solvent Cleaning
- SP 2-05..... No. 2, Hand Tool Cleaning
- SP 3-05..... No. 3, Power Tool Cleaning

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. RAILINGS AND HANDRAILS: 900 N (200 POUNDS) IN ANY DIRECTION AT ANY POINT.
- C. PERFORATED METAL SCREEN WALL: WIND AND SEISMIC LOADS AS INDICATED ON DRAWING S0.1.

2.2 MATERIALS

- A. Structural Steel: ASTM A36.
- B. Stainless Steel: ASTM A167, 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. Cast-Iron: ASTM A48, Class 30, commercial pattern.
- 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. Malleable Iron Castings: ASTM A47.

G. Primer Paint: As specified in Section 09 91 00, PAINTING.

H. 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 with in 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.

I. Perforated Metal Screen: ASTM A 240, Type 304 or 316.

J. 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 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.

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 member's 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 standards as listed in article Applicable Publications.
- 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.

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. Provide as indicated.

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. Aluminum: NAAMM AMP 501.
 - a. Mill finish, AA-M10, as fabricated, use unless specified otherwise.
 - b. Clear anodic coating, AA-C22A41, chemically etched medium matte, with Architectural Class 1, 0.7 mils or thicker.
 - c. Colored anodic coating, AA-C22A42, chemically etched medium matte with Architectural Class 1, 0.7 mils or thicker.
 - d. Painted: AA-C22R10.
- 3. 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.

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.

2.6 LOOSE LINTELS

- A. Furnish lintels of sizes shown. B. Fabricate lintels with not less than 150 mm (6 inch) bearing at each end for nonbearing masonry walls, and 200 mm (8 inch) bearing at each end for bearing walls.

2.7 SHELF ANGLES

- A. Fabricate from steel angles of size shown.
- B. Fabricate angles with horizontal slotted holes for 19 mm (3/4 inch) bolts spaced at not over 900 mm (3 feet) on centers and within 300 mm (12 inches) of ends.
- C. Attach shelf angle as indicated.

2.8 PIPE BOLLARDS

- A. Fabricate pipe bollards from Schedule 40 or 80 steel pipe, as indicated.
- 1. Where bollards are indicated to receive controls for door operators, provide cutouts for controls and holes for wire.

2. Where bollards are indicated to receive light fixtures, provide cutouts for fixtures and holes for wire.

B. Fabricate bollards with 3/8-inch- thick steel baseplates for bolting to concrete slab. Drill baseplates at all four corners for 3/4-inch anchor bolts.

1. Where bollards are to be anchored to sloping concrete slabs, angle baseplates for plumb alignment of bollards.

C. Prime bollards with zinc-rich primer.

2.9 PIPE GUARDS

A. Fabricate pipe guards from 3/8-inch- thick by 12-inch- wide steel plate, bent to fit flat against the wall or column at both ends and to fit around pipe with 2-inch clearance between pipe and pipe guard. Drill each end for two 3/4-inch anchor bolts.

B. Galvanize and prime pipe guards.

2.10 ABRASIVE METAL NOSINGS AND THRESHOLDS

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. Nosings: Cross-hatched units, 4 inches wide with 1-inch lip, for casting into concrete.

2. Thresholds: Fluted-saddle-type units, 5 inches wide by 1/2 inch high, with tapered edges.

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.

D. Apply clear lacquer to concealed surfaces of extruded units.

2.11 BARRIER CABLE SYSTEM

A. General: 7-wire strand; ASTM A416; minimum ultimate tensile strength of 270,000 psi; 1/2 inch strand diameter.

B. Strand protection against exposed environment: Galvanized coating.

C. Terminal fittings shall be epoxy coated and compatible with strand system furnished.

2.12 Perforated Metal Screen

A. Equal or similar to McNichols Quality Perforated Metal

B. Stainless Steel Type 304

C. Sheet size: As indicated on drawings

- D. Arrangement: 1" round holes, 1.25" on center, staggered pattern or equivalent.
- E. Gauge: 11
- F. End Pattern: Finished

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, trap doors 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.

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.

3.3 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.

3.4 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.

3.5 STEEL COMPONENTS FOR MILLWORK ITEMS

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

3.6 PIPE BOLLARDS

- A. Anchor bollards in concrete in formed or core-drilled holes not less than 8 inches deep and 3/4 inch larger than OD of bollard. Fill annular space around bollard solidly with non-shrink grout; mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward bollard.
- B. Fill bollards solidly with concrete, mounding top surface to shed water.
 1. Do not fill removable bollards with concrete.

3.7 PIPE GUARDS

- A. Provide pipe guards at exposed vertical pipes in parking garage where not protected by curbs or other barriers. Install by bolting to wall or column with expansion anchors. Provide four 3/4-inch bolts at each pipe guard. Mount pipe guards with top edge 26 inches above driving surface.

3.8 NOSINGS 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.

- C. Seal thresholds exposed to exterior with elastomeric sealant complying with Section 07 90 20 "Garage Waterproofing Systems" to provide a watertight installation.

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

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