

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. Railings
 - 2. Trash Racks

1.2 RELATED WORK

- A. Prime and finish painting: Section 09 91 00, PAINTING.

1.3 SUBMITTALS

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- 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.
 - 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. Live load designs as specified.
- D. Design Calculations for specified live loads including dead loads.
- E. 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. Assemble 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 or items required for a complete and functional assembly.

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. The latest edition of the publication shall apply.
- B. American Society of Mechanical Engineers (ASME):
- B18.6.1-97.....Wood 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
 - A53-12.....Pipe, Steel, Black and Hot-Dipped, Zinc-Coated
Welded and Seamless
 - A123-12.....Zinc (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.
 - A269-10.....Seamless and Welded Austenitic Stainless Steel
Tubing for General Service
 - A307-12.....Carbon 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
 - B221-13.....Aluminum and Aluminum-Alloy Extruded Bars,
Rods, Wire, Shapes, and Tubes
 - B456-11.....Electrodeposited Coatings of Copper Plus Nickel
Plus Chromium and Nickel Plus Chromium
 - B632-08.....Aluminum-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
 - F436-11.....Hardened Steel Washers

- F468-06(R2012).....Nonferrous Bolts, Hex Cap Screws, Socket Head
Cap Screws and Studs for General Use
- F593-13.....Stainless Steel Bolts, Hex Cap Screws, and
Studs
- F1667-11.....Driven 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 531-09.....Metal Bar Grating Manual
- MBG 532-09.....Heavy 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. Railings and Handrails: 300 pounds in any direction at any point.

2.2 MATERIALS

- A. Structural Steel: ASTM A36. Trash rack steel shall be galvanized.
- B. Steel Pipe: ASTM A53.
1. Type S, Grade A.
2. NPS (inside diameter) to be 31.75 mm (1.25 inch).
- C. Primer Paint: As specified in Section 09 91 00, PAINTING.
- D. 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 for trash rack (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.

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. Connections shall be made by welding or bolting.
2. Design size, number and placement of fasteners, to develop an adequate joint strength.
3. Holes for bolts: Accurately punched or drilled and burrs removed.
4. 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.
5. Use bolts of material to prevent corrosion (electrolysis) at bimetallic contacts. Plated or coated material will not be approved.
6. 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 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. Unless otherwise indicated, fasteners and anchors shall be stainless steel.
5. 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.
6. Fasteners for securing metal fabrication to existing construction or new construction may be expansion bolts or welding.

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. Prepare members for the installation and fitting of hardware.
 - f. 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. 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. Joints firm when assembled.
- f. Conceal joining, fitting and welding on exposed work as far as practical.

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 Painting:
 - 1) Surfaces of Ferrous metal:
 - a) Remove all loose mill scale, rust, and paint, by hand or power tool cleaning as defined in SSPC-SP2 and SP3.
 - b) Clean of oil, grease, soil and other detrimental matter by use of solvents or cleaning compounds as defined in SSPC-SP1.
 - c) After cleaning, apply primer and finish coat (two finish coats minimum) as specified in Section 09 91 00, PAINTING.

G. Protection:

3. 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 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. Exterior Post Anchors.
 - a. Provide heavy pattern sliding flange base plate with set screws at base of pipe or tube posts.
- C. 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.

2.6 TRASH RACK

- A. Trash rack shall be constructed as indicated on the drawings.
- B. Trash rack shall be galvanized and unpainted.
- C. Trash rack shall be attached securely to concrete drainage structure with a minimum of three equally spaced hinges along top of trash rack.

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. Field weld in accordance with AWS.
 - 1. Design and finish as specified for shop welding.
 - 2. Use continuous weld unless specified otherwise.
- C. Install anchoring devices and fasteners as shown and as necessary for securing metal fabrications to construction as specified.
- D. Spot prime all abraded and damaged areas of zinc coating.

3.2 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. Secure fixed flanged fittings to concrete with expansion bolts.

3.3 TRASH RACK

- A. Trash rack shall be installed as indicated on the drawings.

3.4 CLEANING

- 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 items as recommended by the metal manufacture and protect from damage until completion of the project.

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