

**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. Loose Lintels

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. 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. Assembled product to the greatest extent possible before delivery to the site.

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):

B18.2.2-87(R2005) Square and Hex Nuts

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- C. American Society for Testing and Materials (ASTM):
- A36/A36M-12.....Structural Steel
 - A123-12.....Zinc (Hot-Dip Galvanized) Coatings on Iron and
Steel Products
 - C1107-13.....Packaged Dry, Hydraulic-Cement Grout
(Nonshrink)
 - F436-11.....Hardened Steel Washers
 - F468-06(R2012).....Nonferrous Bolts, Hex Cap Screws, Socket Head
Cap Screws and Studs for General Use
- D. American Welding Society (AWS):
- D1.1-10.....Structural Welding Code Steel
 - D1.3-08.....Structural Welding Code Sheet Steel
- E. 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

PART 2 - PRODUCTS

2.1 MATERIALS

- A. Structural Steel: ASTM A36.
- B. Primer Paint: As specified in Section 09 91 00, PAINTING.
- C. Grout: ASTM C1107, pourable type.
- D. Fasteners:
 - 1. Bolts with Nuts:
 - a. ASTM F468 for nonferrous bolts.
 - 2. Washers: ASTM F436, type to suit material and anchorage.

2.2 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.

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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.

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 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.

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- 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. 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. Anchors:
- a. 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.
- 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.

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- 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.

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.

2.3 LOOSE LINTELS

- A. Furnish lintels of sizes shown. Where size of lintels is not shown, provide the sizes specified.
- 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.
- C. Provide one angle lintel for each 100 mm (4 inches) of masonry thickness as follows except as otherwise specified or shown.
 - 1. Openings 750 mm to 1800 mm (2-1/2 feet to 6 feet) - 100 x 90 x 8 mm (4 x 3-1/2 x 5/16 inch).
 - 2. Openings 1800 mm to 3000 mm (6 feet to 10 feet) - 150 x 90 x 9 mm (6 x 3-1/2 x 3/8 inch).
- D. For 150 mm (6 inch) thick masonry openings 750 mm to 3000 mm (2-1/2 feet to 10 feet) use one angle 150 x 90 x 9 mm (6 x 3-1/2 x 3/8 inch).
- E. Provide bearing plates for lintels where shown.
- F. Weld or bolt upstanding legs of double angle lintels together with 19 mm (3/4 inch bolts) spaced at 300 mm (12 inches) on centers.
- G. Insert spreaders at bolt points to separate the angles for insertion of metal windows, and other anchorage.
- H. Where shown or specified, punch upstanding legs of single lintels to suit size and spacing of anchor bolts.

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