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: (12, 14A, 14C)

2. Frames: (24E)

1.2 RELATED WORK

A. Colors, finishes, and textures: Refer to Room Finish Schedule indicated on the Drawings.

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

C. 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. 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. Design Calculations for specified live loads including dead loads.

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):

1. B18.6.1-81(R1997) Wood Screws
2. B18.2.2-87(R2005) Square and Hex Nuts

C. American Society for Testing and Materials (ASTM):

1. A36/A36M-05 Structural Steel
2. A47-99(R2004) Malleable Iron Castings
3. A48-03 Gray Iron Castings
4. A53-06 Pipe, Steel, Black and Hot-Dipped, Zinc-Coated Welded and Seamless
5. A123-02 Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
6. A167-99(R2004) Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet and Strip
7. A269-07 Seamless and Welded Austenitic Stainless Steel Tubing for General Service
8. A307-07 Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength
9. A653/A653M-07 Steel Sheet, Zinc Coated (Galvanized) or Zinc-Iron Alloy Coated (Galvannealed) by the Hot-Dip Process
10. B221-06 Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Shapes, and Tubes
11. B456-03 Electrodeposited Coatings of Copper Plus Nickel Plus Chromium and Nickel Plus Chromium
12. C1107-07 Packaged Dry, Hydraulic-Cement Grout (Nonshrink)
13. D3656-04 Insect Screening and Louver Cloth Woven from Vinyl-Coated Glass Yarns
14. F436-07 Hardened Steel Washers
15. F468-06 Nonferrous Bolts, Hex Cap Screws, and Studs for General Use
16. F593-02 Stainless Steel Bolts, Hex Cap Screws, and Studs
17. F1667-05 Driven Fasteners: Nails, Spikes and Staples

D. American Welding Society (AWS):

1. D1.1-04 Structural Welding Code Steel
2. D1.2-03 Structural Welding Code Aluminum
3. D1.3-98 Structural Welding Code Sheet Steel

E. National Association of Architectural Metal Manufacturers (NAAMM)

1. AMP 500-505-1988 Metal Finishes Manual

F. Structural Steel Painting Council (SSPC):

1. SP 1-05 No. 1, Solvent Cleaning
2. SP 2-05 No. 2, Hand Tool Cleaning
3. SP 3-05 No. 3, Power Tool Cleaning

PART 2 - PRODUCTS

2.1 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. 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. 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.
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.

J. Grout: ASTM C1107, pourable type.

2.2 HARDWARE

A. 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.

2.3 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 (1 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. 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.

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.

2.4 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.

?. Make provision for installation of stud bolts in lower flange of channel.

?. Provide a continuous steel angle at wall and channel braces spaced as shown.

?. Use threaded rod hangers.

?. Provide diagonal angle brace where the suspended ceiling over toilet stalls does not extend to side wall of room.

?. Provide supports for ceiling hung pilasters at dressing booths and entrance screen to toilet room similar to support for toilet stall pilasters.

C. 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 flatted 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.

6. Use steel angles for thru wall counters. Drill angle for fasteners at ends and not over 100 mm (4 inches) on center between ends.

D. Supports at Ceiling for Radiographic (x-ray) Equipment:

1. Fabricate hangers braces, and track of modular channel units assembly as shown.

2. Fabricate steel plates for anchor to structure above.

3. Drill bent plates for bolting at mid height at concrete beams.

E. Supports for Items at Various Conditions at Suspended Ceilings:

1. Fabricate of structural steel shapes as shown.

2. Drill for anchor bolts of suspended item.

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 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. Ceiling Hung Toilet Stalls:

1. Securely anchor hangers of continuous steel channel above pilasters to structure above.

2. Bolt continuous steel angle at wall to masonry or weld to face of each metal stud.

3. Secure brace for steel channels over toilet stall pilasters to wall angle supports with bolts at each end spaced as shown.

4. Install diagonal angle brace where the suspended ceiling over toilet stalls does not extend to side wall of room.

5. Install stud bolts in lower flange of channel before installing furred down ceiling over toilet stalls.

6. Install support for ceiling hung pilasters at entrance screen to toilet room similar to toilet stall pilasters.

C. 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.

D. Support at Ceiling for X-ray Tube Stand and Radiographic Equipment:

1. Bolt modular steel channel frames to hangers as shown, anchored to structure above.

2. Fasten frames with modular channel manufacturers fittings, bolts, and nuts. Space modular channel supports and hangers as shown and as required to suit equipment furnished.

3. Install closure plates in channels at ceiling where channel opening is visible. Coordinate and cut plates to fit tight against equipment anchors after equipment anchors are installed.

E. Supports for Cubicle Curtain Track:

1. Install assembly where shown after ceiling suspension grid is installed.

2. Drill angle for bolt and weld nut to angle prior to installation of tile.

3.3 DOOR FRAMES

A. Secure clip angles at bottom of frames to concrete slab with expansion bolts as shown.

B. Level and plumb frame; brace in position required.

C. Set frames in formwork for frames cast into concrete.

D. Where frames are set in prepared openings, bolt to wall with spacers and expansion bolts.

3.4 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.

3.5 STEEL COMPONENTS FOR MILLWORK ITEMS

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

3.6 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.

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