SECTION 055000
METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

A. Drawings and General Provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section Includes:
   1. Steel framing and supports for mechanical and electrical equipment.
   2. Steel framing and supports for applications where framing and supports are not specified in other Sections.
   3. Loose bearing and leveling plates for applications where they are not specified in other Sections.
   4. Metal ladders.

B. Products furnished, but not installed, under this Section:
   1. Loose steel lintels.
   2. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
   3. Steel weld plates and angles for casting into concrete for applications where they are not specified in other Sections.

C. Related Sections:
   1. Section 033000 "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.
   2. Section 042000 "Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
   3. Section 051200 "Structural Steel Framing".
   4. Section 055100 "Metal Stairs".
5. Section 055213 "Pipe and Tube Railings".
6. Section 055300 "Metal Gratings".

1.3 PERFORMANCE REQUIREMENTS

A. Delegated Design: Design ladders, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

B. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.

   1. Temperature Change: 120 deg F (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.

1.4 ACTION SUBMITTALS

A. Product Data: For the following:

   1. Nonslip aggregates and nonslip-aggregate surface finishes.

B. Shop Drawings: Show fabrication and installation details for metal fabrications.

   1. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.

C. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Qualification Data: For qualified professional engineer.

1.6 QUALITY ASSURANCE

A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel".
B.  Welding Qualifications: Qualify procedures and personnel according to the following:

1.  AWS D1.1/D1.1M, "Structural Welding Code - Steel".
2.  AWS D1.2/D1.2M, "Structural Welding Code - Aluminum".

1.7  PROJECT CONDITIONS

A.  Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication.

1.8  COORDINATION

A.  Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.

B.  Coordinate installation of anchorages and steel weld plates and angles for casting into concrete. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

PART 2 - PRODUCTS

2.1  METALS, GENERAL

A.  Metal Surfaces, General: Provide materials with smooth, flat surfaces unless otherwise indicated. For metal fabrications exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.

2.2  FERROUS METALS

A.  Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than twenty-five (25%) percent.

B.  Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.

C.  Steel Tubing: ASTM A 500, cold-formed steel tubing.

D.  Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40) unless otherwise indicated.
2.3 NONFERROUS METALS


2.4 FASTENERS

A. General: Unless otherwise indicated, provide Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.
   1. Provide stainless-steel fasteners for fastening aluminum.

2.5 MISCELLANEOUS MATERIALS

A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
B. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.
   1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.
C. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.

2.6 FABRICATION, GENERAL

A. Shop Assembly: Preassemble items in the shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
B. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch (1 mm) unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
C. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
D. Form exposed work with accurate angles and surfaces and straight edges.
E. Weld corners and seams continuously to comply with the following:
   1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
   2. Obtain fusion without undercut or overlap.
   3. Remove welding flux immediately.
   4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.

F. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners or welds where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) fasteners unless otherwise indicated. Locate joints where least conspicuous.

G. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

H. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.

I. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
   1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches (3.2 by 38 mm), with a minimum 6-inch (150-mm) embedment and 2-inch (50-mm) hook, not less than 8 inches (200 mm) from ends and corners of units and 24 inches (600 mm) o.c., unless otherwise indicated.

2.7 MISCELLANEOUS FRAMING AND SUPPORTS

A. General: Provide steel framing and supports not specified in other Sections as needed to complete the Work.

B. Fabricate units from steel shapes, plates, and bars of welded construction unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction.
   1. Fabricate units from slotted channel framing where indicated.
   2. Furnish inserts for units installed after concrete is placed.

C. Prime miscellaneous framing and supports.
2.8 MISCELLANEOUS STEEL TRIM

A. Unless otherwise indicated, fabricate units from steel shapes, plates, and bars of profiles shown with continuously welded joints and smooth exposed edges. Miter corners and use concealed field splices where possible.

B. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work.

1. Provide with integrally welded steel strap anchors for embedding in concrete or masonry construction.

C. Prime miscellaneous steel trim.

2.9 METAL LADDERS

A. General:

1. Comply with ANSI A14.3 unless otherwise indicated.

B. Steel Ladders:

1. Space siderails 18 inches apart unless otherwise indicated.

2. Siderails: Continuous, 3/8-by-2-1/2-inch (9.5-by-64-mm) steel flat bars, with eased edges.

3. Rungs: 3/4-inch- (19-mm-) square steel bars.

4. Fit rungs in centerline of siderails; plug-weld and grind smooth on outer rail faces.

5. Provide nonslip surfaces on top of each rung, either by coating rung with aluminum-oxide granules set in epoxy-resin adhesive or by using a type of manufactured rung filled with aluminum-oxide grout.

6. Provide nonslip surfaces on top of each rung by coating with abrasive material metallically bonded to rung.

a. Products: Subject to compliance with requirements, provide one of the following:

1) IKG Industries, a division of Harsco Corporation; Mebac.
2) SlipNOT Metal Safety Flooring, a W. S. Molnar company; SlipNOT.

7. Support each ladder at top and bottom and not more than 60 inches (1500 mm) o.c. with welded or bolted steel brackets.

8. Prime interior ladders, including brackets and fasteners.
2.10  LOOSE BEARING AND LEVELING PLATES

A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts and for grouting.

B. Prime plates.

2.11  LOOSE STEEL LINTELS

A. Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated. Fabricate in single lengths for each opening unless otherwise indicated. Weld adjoining members together to form a single unit where indicated.

B. Size loose lintels to provide bearing length at each side of openings equal to 1/12 of clear span but not less than 8 inches (200 mm) unless otherwise indicated.

C. Prime loose steel lintels located in exterior walls.

2.12  STEEL WELD PLATES AND ANGLES

A. Provide steel weld plates and angles not specified in other Sections, for items supported from concrete construction as needed to complete the Work. Provide each unit with no fewer than two integrally welded steel strap anchors for embedding in concrete.

2.13  FINISHES, GENERAL

A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

B. Finish metal fabrications after assembly.

C. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.14  STEEL AND IRON FINISHES

A. Shop prime iron and steel items unless they are to be embedded in concrete, sprayed-on fireproofing, or masonry, or unless otherwise indicated.

1. Shop prime with universal shop primer.
B. Preparation for Shop Priming: Prepare surfaces to comply with requirements indicated below:

1. Exterior Items: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning".
2. Other Items: SSPC-SP 3, "Power Tool Cleaning".

C. Shop Priming: Apply shop primer to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel", for shop painting.

1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

2.15 ALUMINUM FINISHES

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

B. As-Fabricated Finish: AA-M10 (Mechanical Finish: as fabricated, unspecified).

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

A. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.

B. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.

C. Field Welding: Comply with the following requirements:

1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
2. Obtain fusion without undercut or overlap.
3. Remove welding flux immediately.
4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
D. Fastening to In-Place Construction: Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction. Provide threaded fasteners for use with concrete and masonry inserts, toggle bolts, through bolts, lag screws, wood screws, and other connectors.

E. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.

F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with the following:

1. Cast Aluminum: Heavy coat of bituminous paint.
2. Extruded Aluminum: Two coats of clear lacquer.

3.2 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings.

3.3 INSTALLING BEARING AND LEVELING PLATES


B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.

1. Use nonshrink grout, either metallic or nonmetallic, in concealed locations where not exposed to moisture; use nonshrink, nonmetallic grout in exposed locations unless otherwise indicated.

2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.4 ADJUSTING AND CLEANING

A. Touch-up Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.

END OF SECTION

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