

## **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 overhead doors.
  - 2. Steel framing and supports for countertops.
  - 3. Steel tube reinforcement for low partitions.
  - 4. Steel framing and supports for mechanical and electrical equipment.
  - 5. Steel framing and supports for applications where framing and supports are not specified in other Sections.
  - 6. Slotted channel framing.
  - 7. Metal ladders.
  - 8. Metal bollards.
- B. Products furnished, but not installed, under this Section include the following:
  - 1. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.
- C. Related Requirements:
  - 1. Section 042000 "Unit Masonry" for installing anchor bolts and other items built into unit masonry.
  - 2. Section 051200 "Structural Steel Framing" for steel framing, supports, and other steel items attached to the structural-steel framing.

#### **1.3 COORDINATION**

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written instructions to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of metal fabrications that are anchored to or that receive other work. 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.

#### **1.4 ACTION SUBMITTALS**

A. Product Data: For the following:

1. Nonslip aggregates and nonslip-aggregate surface finishes.
2. Fasteners.
3. Shop primers.
4. Shrinkage-resisting grout.
5. Slotted channel framing.

B. Shop Drawings: Show fabrication and installation details. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items. Provide Shop Drawings for the following:

1. Steel framing and supports for overhead doors.
2. Steel framing and supports for countertops.
3. Steel tube reinforcement for low partitions.
4. Steel framing and supports for mechanical and electrical equipment.
5. Steel framing and supports for applications where framing and supports are not specified in other Sections.
6. Metal ladders.
7. Metal bollards.

#### **1.5 FIELD CONDITIONS**

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

### **PART 2 - PRODUCTS**

#### **2.1 PERFORMANCE REQUIREMENTS**

A. 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.

## 2.2 METALS

- 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.
- B. Steel Plates, Shapes, and Bars: ASTM A36/A36M.
- C. Stainless Steel Sheet, Strip, and Plate: ASTM A240/A240M or ASTM A666, Type 304.
- D. Stainless Steel Bars and Shapes: ASTM A276/A276M, Type 304.
- E. Steel Tubing: ASTM A500/A500M, cold-formed steel tubing.
- F. Steel Pipe: ASTM A53/A53M, Standard Weight (Schedule 40) unless otherwise indicated.
- G. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.
  - 1. Size of Channels: 1-5/8 by 1-5/8 inches.
  - 2. Material: Galvanized steel, ASTM A653/A653M, commercial steel, Type B structural steel, Grade 33, with G90 coating; 0.108-inch nominal thickness.
- H. Cast Iron: Either gray iron, ASTM A48/A48M, or malleable iron, ASTM A47/A47M, unless otherwise indicated.
- I. Aluminum Plate and Sheet: ASTM B209, Alloy 6061-T6.
- J. Aluminum Extrusions: ASTM B221, Alloy 6063-T6.
- K. Aluminum-Alloy Rolled Tread Plate: ASTM B632/B632M, Alloy 6061-T6.
- L. Aluminum Castings: ASTM B26/B26M, Alloy 443.0-F.

## 2.3 FASTENERS

- A. General: Unless otherwise indicated, provide Type 304 stainless steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B633 or ASTM F1941/F1941M, Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.
  - 1. Provide stainless steel fasteners for fastening aluminum stainless steel or nickel silver.
  - 2. Provide bronze fasteners for fastening bronze.

- B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A307, Grade A; with hex nuts, ASTM A563; and, where indicated, flat washers.
- C. High-Strength Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A325, Type 3, heavy-hex steel structural bolts; ASTM A563, Grade DH3, heavy-hex carbon-steel nuts; and where indicated, flat washers.
- D. Stainless Steel Bolts and Nuts: Regular hexagon-head annealed stainless steel bolts, ASTM F593; with hex nuts, ASTM F594; and, where indicated, flat washers; Alloy Group 1.
- E. Anchor Bolts: ASTM F1554, Grade 36, of dimensions indicated; with nuts, ASTM A563; and, where indicated, flat washers.
  - 1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.
- F. Anchors, General: Capable of sustaining, without failure, a load equal to six times the load imposed when installed in unit masonry and four times the load imposed when installed in concrete, as determined by testing in accordance with ASTM E488/E488M, conducted by a qualified independent testing agency.
- G. Cast-in-Place Anchors in Concrete: Either threaded or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A47/A47M malleable iron or ASTM A27/A27M cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F2329/F2329M.
- H. Post-Installed Anchors: Chemical anchors.
  - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B633 or ASTM F1941/F1941M, Class Fe/Zn 5, unless otherwise indicated.
  - 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy Group 1 stainless steel bolts, ASTM F593, and nuts, ASTM F594.
- I. Slotted-Channel Inserts: Cold-formed, hot-dip galvanized-steel box channels (struts) complying with MFMA-4, 1-5/8 by 7/8 inches by length indicated with anchor straps or studs not less than 3 inches long at not more than 8 inches o.c. Provide with temporary filler and tee-head bolts, complete with washers and nuts, all zinc-plated to comply with ASTM B633, Class Fe/Zn 5, as needed for fastening to inserts.

## **2.4 MISCELLANEOUS MATERIALS**

- A. Shop Primers: Provide primers that comply with Section 099113 "Exterior Painting."

## 2.5 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 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 are 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.
- J. 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, with a minimum 6-inch embedment and 2-inch hook, not less than 8 inches from ends and corners of units and 24 inches o.c., unless otherwise indicated.

## 2.6 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. Fabricate supports for operable partitions from continuous steel beams of sizes indicated with attached bearing plates, anchors, and braces as indicated. Drill or punch bottom flanges of beams to receive partition track hanger rods; locate holes where indicated on operable partition Shop Drawings.
- D. Galvanize exterior framing and supports.
- E. Prime interior framing and supports.

## 2.7 METAL LADDERS

- A. General:
  - 1. Comply with ANSI A14.3
- B. Steel Ladders:
  - 1. Space siderails 16 inches apart unless otherwise indicated.
  - 2. Siderails: Continuous, 3/8-by-2-1/2-inch steel flat bars, with eased edges.
  - 3. Rungs: 3/4-inch diameter, steel bars.
  - 4. Fit rungs in centerline of side rails; 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. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
      - 1) Harsco Industrial IKG, a division of Harsco Corporation.
      - 2) ROSS TECHNOLOGY CORP.
      - 3) W.S. Molnar Company.

7. Source Limitations: Obtain nonslip surfaces from single source from single manufacturer.
8. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted steel brackets.
9. Galvanize ladders, including brackets.

## **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. Galvanize and prime exterior miscellaneous steel trim.

## **2.9 METAL BOLLARDS**

- A. Fabricate metal bollards from galvanized schedule 40 steel pipe.

## **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. Galvanize bearing and leveling plates.

## **2.11 GENERAL FINISH REQUIREMENTS**

- A. Finish metal fabrications after assembly.
- B. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

## **2.12 STEEL AND IRON FINISHES**

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A153/A153M for steel and iron hardware and with ASTM A123/A123M for other steel and iron products.

1. Do not quench or apply post galvanizing treatments that might interfere with paint adhesion.
- B. Preparation for Shop Priming Galvanized Items: After galvanizing, thoroughly clean galvanized surfaces of grease, dirt, oil, flux, and other foreign matter, and treat with metallic phosphate process.
- C. Shop prime iron and steel items not indicated to be galvanized unless they are to be embedded in concrete or masonry, or unless otherwise indicated.
  1. Shop prime with primers specified in Section 099113 "Exterior Painting" unless indicated.
- D. Preparation for Shop Priming: Prepare surfaces to comply with SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
  1. Exterior Items: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
  2. Items Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
  3. Other Steel Items: SSPC-SP 3, "Power Tool Cleaning."
  4. Galvanized-Steel Items: SSPC-SP 16, "Brush-off Blast Cleaning of Coated and Uncoated Galvanized Steel, Stainless Steels, and Non-Ferrous Metals."
- E. 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.

## **2.13 ALUMINUM FINISHES**

- A. As-Fabricated Finish: AA-M12.
- B. Clear Anodic Finish: AAMA 611, Class I, AA-M12C22A41.

## **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 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 INSTALLATION OF 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.
- B. Anchor supports for operable partitions and overhead doors securely to, and rigidly brace from, building structure.

### **3.3 INSTALLATION OF METAL BOLLARDS**

- A. Anchor bollards in place with concrete footings. Center and align bollards in holes 3 inches above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace bollards in position until concrete has cured.
- B. Fill bollards solidly with concrete, and provide a prefabricated bollard cap installed per manufacturer's recommendations. Basis of Design: TopGard Pipe Bollard Cap from Top Gard LLC.

### **3.4 INSTALLATION OF BEARING AND LEVELING PLATES**

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of 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 shrinkage-resistant grout. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

### **3.5 REPAIRS**

- A. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A780/A780M.

**END OF SECTION 055000**