

SECTION 05500 - METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes, but not limited to, the following metal fabrications:
 - 1. Rough hardware.
 - 2. Loose bearing and leveling plates.
 - 3. Loose steel lintels.
 - 4. Shelf and relieving angles.
 - 5. Miscellaneous framing and supports for the following:
 - a. Applications where framing and supports are not specified in other sections.
 - 7. Miscellaneous steel trim.

- B. Related Sections: The following Sections contain requirements that relate to this Section:
 - 1. 06100 Rough Carpentry

1.3 SUBMITTALS

- A. General: Submit each item in this Article according to the Conditions of the Contract and Division 1 Specification Sections.
- B. Product data for each manufactured item.
- C. Shop drawings detailing fabrication and erection of each metal fabrication indicated. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items. Provide templates for anchors and bolts specified for installation under other Sections.
- D. Welder certificates signed by Contractor certifying that welders comply with requirements specified under the "Quality Assurance" Article.
- E. Qualification data for firms and persons specified in the "Quality Assurance" Article to demonstrate their capabilities and experience. Include a list of completed projects with project name, addresses, names of architects and owners, and other information specified.

1.4 QUALITY ASSURANCE

- A. Fabricator Qualifications: Firm experienced in producing metal fabrications similar to those indicated for this Project with a record of successful in-service performance, and with sufficient production capacity to produce required units without delaying the Work.

- B. Welding Standards: Comply with applicable provisions of AWS D1.1 "Structural Welding Code--Steel," AWS D1.2 "Structural Welding Code--Aluminum," and AWS D1.3 "Structural Welding Code--Sheet Steel."

- 1. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.

1.5 PROJECT CONDITIONS

- A. Field Measurements: Check actual locations of walls and other construction to which metal fabrications must fit by accurate field measurements before fabrication. Show recorded measurements on final shop drawings. Coordinate fabrication schedule with construction progress to avoid delaying the Work.

PART 2 - PRODUCTS

2.1 FERROUS METALS

- A. Metal Surfaces, General: For metal fabrications exposed to view in the completed Work, provide materials selected for their surface flatness, smoothness, and freedom from surface blemishes. Do not use materials with exposed pitting, seam marks, roller marks, rolled trade names, or roughness.
- B. Steel Shapes: ASTM 572-50 or equivalent.
- C. Steel Plates, and Bars: ASTM A 36.
- D. Rolled Steel Floor Plates: ASTM A 786.
- E. Steel Tubing: Product type (manufacturing method) and as follows:
 - 1. Hot-Formed Steel Tubing: ASTM A 501.
 - a. For exterior installations and where indicated, provide tubing with hot-dip galvanized coating per ASTM A 53.
- F. Steel Pipe: ASTM A 53, standard weight (schedule 40), unless otherwise indicated, or another weight required by structural loads.
 - 1. Galvanized finish for exterior installations and where indicated.
- G. Gray-Iron Castings: ASTM A 48, Class 30.
- H. Malleable-Iron Castings: ASTM A 47, Grade 32510.
- I. Cast-in-Place Anchors in Concrete: Anchors of type indicated below, fabricated from corrosion-resistant materials capable of sustaining, without failure, the load imposed within a safety factor of 4, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.
 - 1. Threaded or wedge type; galvanized ferrous castings, either ASTM A 47 malleable iron or ASTM A 27 cast steel. Provide bolts, washers, and shims as required, hot-dip galvanized per ASTM A 153.

- J. Welding Rods and Bare Electrodes: Select according to AWS specifications for the metal alloy to be welded.

2.2 PAINT

- A. Shop Primer for Ferrous Metal: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with performance requirements of FS TT-P-664, selected for good resistance to normal atmospheric corrosion, compatibility with finish paint systems indicated, and capability to provide a sound foundation for field-applied topcoats despite prolonged exposure.
- B. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in galvanized steel, with dry film containing not less than 94 percent zinc dust by weight, and complying with DOD-P-21035 or SSPC-Paint 20.
- C. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12, except containing no asbestos fibers.
- D. Verify primer Locations. No primer in Rooms 119, 120 & 121.

2.3 FASTENERS

- A. General: Provide plated fasteners complying with ASTM B 633, Class Fe/Zn 25 for electrodeposited zinc coating, for exterior use or where built into exterior walls. Select fasteners for the type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A, with hex nuts, ASTM A 563 and, where indicated, flat washers.
- C. Machine Screws: ANSI B18.6.
- D. Lag Bolts: ANSI B18.2.1.
- E. Wood Screws: Flat head, carbon steel, ANSI B18.6.1.
- F. Plain Washers: Round, carbon steel, ANSI B18.22.1.
- G. Lock Washers: Helical, spring type, carbon steel, ANSI B18.21.1.
- H. Expansion Anchors: Anchor bolt and sleeve assembly of material indicated below with capability to sustain, without failure, a load equal to 6 times the load imposed when installed in unit masonry and equal to 4 times the load imposed when installed in concrete as determined by testing per ASTM E 488 conducted by a qualified independent testing agency.
 - 1. Material: Carbon steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.
 - 2. Material: Group 1 alloy 304 or 316 stainless-steel bolts and nuts complying with ASTM F 593 and ASTM F 594.
- I. Toggle Bolts: FS FF-B-588, tumble-wing type, class and style as required.

2.4 GROUT

- A. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- B. Products: Subject to compliance with requirements, provide one of the following:
 - 1. Nonshrink, Nonmetallic Grouts:
 - a. B-6 Construction Grout; W. R. Bonsal Co.
 - b. Diamond-Crete Grout; Concrete Service Materials Co.
 - c. Supreme; Cormix Construction Chemicals.
 - d. Sure-grip High Performance Grout; Dayton Superior Corp.
 - e. Euco N-S Grout; Euclid Chemical Co.
 - f. Five Star Grout; Five Star Products.
 - g. Vibropruf #11; Lambert Corp.
 - h. Crystex; L & M Construction Chemicals, Inc.
 - i. Masterflow 928 and 713; Master Builders Technologies, Inc.
 - j. Sealtight 588 Grout; W. R. Meadows, Inc.
 - k. SonogROUT 14; Sonneborn Building Products--ChemRex, Inc.
 - l. Kemset; The Spray-Cure Company.

2.5 CONCRETE FILL

- A. Concrete Materials and Properties: Comply with requirements of Division 3 Section "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi, unless higher strengths are indicated.

2.6 FABRICATION, GENERAL

- A. Form metal fabrications from materials of size, thickness, and shapes indicated but not less than that needed to comply with performance requirements indicated. Work to dimensions indicated or accepted on shop drawings, using proven details of fabrication and support. Use type of materials indicated or specified for various components of each metal fabrication.
- B. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
- C. Allow for thermal movement resulting from the following maximum change (range) in ambient temperature in the design, fabrication, and installation of installed metal assemblies to prevent buckling, opening up of joints, and overstressing of welds and fasteners. Base design calculations on actual surface temperatures of metals due to both solar heat gain and nighttime sky heat loss.
 - 1. Temperature Change (Range): 100 deg F.
- D. Shear and punch metals cleanly and accurately. Remove burrs.
- E. Ease exposed edges to a radius of approximately 1/32 inch, unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- F. Remove sharp or rough areas on exposed traffic surfaces.
- G. 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 that no roughness shows after finishing, and contour of welded surface matches those adjacent.
- H. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners wherever possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.
- I. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
- J. Shop Assembly: Preassemble items in shop to greatest extent possible to minimize field splicing and assembly. 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.
- K. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- L. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.

2.7 ROUGH HARDWARE

- A. Furnish bent, or otherwise custom-fabricated, bolts, plates, anchors, hangers, dowels, and other miscellaneous steel and iron shapes as required for framing and supporting woodwork, and for anchoring or securing woodwork to concrete or other structures. Straight bolts and other stock rough hardware items are specified in Division 6 Sections.
- B. Fabricate items to sizes, shapes, and dimensions required. Furnish malleable-iron washers for heads and nuts that bear on wood structural connections, and furnish steel washers elsewhere.

2.8 LOOSE STEEL LINTELS

- A. Fabricate loose structural steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions as indicated.
- B. Weld adjoining members together to form a single unit where indicated.

2.9 SHELF AND RELIEVING ANGLES

- A. Fabricate shelf and relieving angles from steel angles of sizes indicated and for attachment to concrete framing. Provide slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and not more than 24 inches o.c., unless otherwise indicated.

- B. For cavity walls, provide vertical channel brackets to support shelf/relieving angles from back-up masonry and concrete. Align expansion joints in angles with indicated control and expansion joints in cavity wall exterior wythe.
- C. Galvanize shelf angles to be installed on exterior concrete framing.
- D. Furnish wedge-type concrete inserts, complete with fasteners, to attach shelf angles to cast-in-place concrete.

2.10 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports for applications indicated that are not a part of structural steel framework as required to complete the Work.
- B. Fabricate units to sizes, shapes, and profiles indicated and required to receive other adjacent construction retained by framing and supports. Fabricate from structural steel shapes, plates, and steel bars of welded construction using mitered joints for field connection. Cut, drill, and tap units to receive hardware, hangers, and similar items.
 - 1. Equip units with integrally welded anchors for casting into concrete or building into masonry. Furnish inserts if units must be installed after concrete is placed.
 - a. Except as otherwise indicated, space anchors 24 inches o.c. and provide minimum anchor units in the form of steel straps 1-1/4 wide by 1/4 inch thick by 8 inches long.
- C. Galvanize miscellaneous framing and supports in the following locations:
 - 1. Exterior locations.

2.11 MISCELLANEOUS STEEL TRIM

- A. Unless otherwise indicated, fabricate units from structural steel shapes, plates, and bars of profiles shown with continuously welded joints, and smooth exposed edges. Miter corners and use concealed field splices wherever possible.
- B. Provide cutouts, fittings, and anchorages as required to coordinate assembly and installation with other work. Provide anchors, welded to trim, for embedding in concrete or masonry construction, spaced not more than 6 inches from each end, 6 inches from corners, and 24 inches o.c., unless otherwise indicated.
- C. Galvanize miscellaneous steel trim in the following locations, (Per Addendum #1: delete this section C. It is not necessary that the exterior miscellaneous steel (lintels, tube steel ring) be galvanized, unless they are called out as such. However, exterior HM door frames and HM doors are still galvanized as per specs.)
 - 1. Exterior locations.
 - 2. Interior locations where indicated.

2.12 FINISHES, GENERAL

- A. Comply with NAAMM "Metal Finishes Manual" for recommendations relative to applying and designing finishes.

- B. Finish metal fabrications after assembly.

2.13 STEEL AND IRON FINISHES

- A. Galvanizing: For those items indicated for galvanizing, apply zinc coating by the hot-dip process complying with the following requirements:
 - 1. ASTM A 153 for galvanizing iron and steel hardware.
 - 2. ASTM A 123 for galvanizing both fabricated and unfabricated iron and steel products made of uncoated rolled, pressed, and forged shapes, plates, bars, and strip 0.0299 inch thick or thicker.
- B. Preparation for Shop Priming: Prepare uncoated ferrous metal surfaces to comply with minimum requirements indicated below for SSPC surface preparation specifications and environmental exposure conditions of installed metal fabrications:
 - 1. Exteriors (SSPC Zone 1B): SSPC-SP 6 "Commercial Blast Cleaning."
 - 2. Interiors (SSPC Zone 1A): SSPC-SP 3 "Power Tool Cleaning."
- C. Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finishes or to be embedded in concrete, sprayed-on fireproofing, or masonry, unless otherwise indicated. Comply with requirements of SSPC-PA 1 "Paint Application Specification No. 1" for shop painting.
 - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 PREPARATION

- A. Coordinate and furnish anchorages, setting drawings, diagrams, templates, instructions, and directions for installing anchorages, including concrete inserts, sleeves, anchor bolts, and miscellaneous items having integral anchors that are to be embedded in concrete or masonry construction. Coordinate delivery of such items to Project site.
- B. Set sleeves in concrete with tops flush with finish surface elevations. Protect sleeves from water and concrete entry.

3.2 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing miscellaneous metal fabrications to in-place construction. Include threaded fasteners for concrete and masonry inserts, toggle bolts, through-bolts, lag bolts, wood screws, and other connectors as required.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing miscellaneous metal fabrications. Set metal fabrication accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete masonry or similar construction.

- D. 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 the surfaces of exterior units that have been hot-dip galvanized after fabrication and are intended for bolted or screwed field connections.
- E. 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 that no roughness shows after finishing, and contour of welded surface matches those adjacent.
- F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with a heavy coat of bituminous paint.

3.3 SETTING LOOSE PLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of bearing plates.
- B. Set loose leveling and bearing plates on wedges or other adjustable devices. After the bearing members have been positioned and plumbed, tighten the anchor bolts. Do not remove wedges or shims, but if protruding, cut off flush with the edge of the bearing plate before packing with grout.

3.4 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting to comply with SSPC-PA 1 requirements for touching up shop-painted surfaces.
 - 1. Apply by brush or spray to provide a 2.0- minimum dry film thickness.

END OF SECTION 05500