

100% PROJECT MANUAL

COMMERCE 2.0 MGD GROVE CREEK WPCP

COMMERCE, GEORGIA

for

CITY OF COMMERCE

BID DOCUMENTS

March 2025



Prepared By



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GMC PROJECT NUMBER: CATL230033



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ARCHITECTURE ■ ENGINEERING ■ ENVIRONMENTAL ■ GEOTECHNICAL ■ INTERIOR
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**COMMERCE 2.0 MGD GROVE CREEK
WATER POLLUTION CONTROL PLANT**

FOR

CITY OF COMMERCE

COMMERCE, GEORGIA

GMC PROJECT NO. CATL230033

TABLE OF CONTENTS

<u>SECTION</u>	<u>TITLE</u>
<u>DIVISION 00 – PROCUREMENT AND CONTRACTING REQUIREMENTS</u>	
00 10 00	Advertisement for Bids
00 20 00	Instructions to Bidders
00 25 00	Instructions for Submitting Bid Proposals
00 32 00	Information Available to Bidders
00 32 00	Grove Creek WPCP - Geotechnical Report
00 41 13	Bid Form
00 43 13	Bid Bond
00 45 13	Qualifications Statement
00 48 00	Noncollusion Affidavit
00 49 00	Immigration and Security Form
00 51 00	Notice of Award
00 52 13	Agreement between Owner and Contractor for Construction Contract
00 55 00	Notice to Proceed
00 61 13.13	Performance Bond
00 61 13.15	Payment Bond
00 62 76	Application for Payment
00 63 63	Change Order
00 65 16	Certificate of Substantial Completion
00 72 00	General Conditions of the Contract for Construction
00 73 00	Supplementary Conditions
00 85 00	GEFA-SRF-Supplemental - General-Conditions
00 85 50	SLFRF ARPA - Water Sewer Infrastructure Terms and Conditions

DIVISION 01 – GENERAL REQUIREMENTS

01 10 00	Summary
01 15 00	Measurement and Payment
01 21 00	Allowances
01 26 00	Contract Modification Procedures
01 29 00	Payment Procedures
01 29 00A	Contractor Progress Lien Waiver
01 29 00B	Subcontractor Progress Lien Waiver
01 31 00	Project Management and Coordination
01 32 00	Construction Progress Documentation
01 32 33	Photographic Documentation
01 33 00	Submittal Procedures
01 40 00	Quality Requirements
01 42 00	References
01 50 00	Temporary Facilities and Controls
01 60 00	Product Requirements
01 70 00	Execution and Closeout Requirements
01 78 23	Operation and Maintenance Data
01 78 39	Project Record Documents
01 79 00	Demonstration and Training
01 81 00	Geotechnical Data

DIVISION 02 – (NOT USED)

DIVISION 03 – CONCRETE

03 20 00	Anchorage in Concrete
03 30 00	Cast-in-Place Concrete
03 39 00	Concrete Curing
03 60 00	Grouting

DIVISION 04 – MASONRY

04 00 10	Unity Masonry Assemblies
----------	--------------------------

DIVISION 05 – METALS

05 12 00	Structural Steel
05 35 15	Cold-Formed Metal Framing
05 40 00	Aluminum Handrail

05 50 00	Metal Fabrications
05 51 19	Metal Grating Stairs
05 52 13	Pipe and Tube Railings
05 53 13	Bar Gratings
05 60 00	Aluminum Hatches

DIVISION 06 – WOOD, PLASTICS, AND COMPOSITES

06 10 53	Miscellaneous Rough Carpentry
06 16 00	Sheathing
06 60 00	FRP Weir Plates, Scum Baffles and Brackets

DIVISION 07 – THERMAL AND MOISTURE PROTECTION

07 21 00	Thermal Insulation
07 41 13	Standing-Seam Metal Roof Panels
07 42 93	Soffit Panels
07 54 23	Thermoplastic-Polyolefin (TPO) Roofing
07 62 00	Sheet Metal Flashing and Trim
07 84 00	Firestopping
07 92 00	Joint Sealants

DIVISION 08 – OPENINGS

08 11 13	Hollow Metal Doors and Frames
08 51 13	Aluminum Windows
08 71 00	Door Hardware

DIVISION 09 – FINISHES

09 22 16	Non-Structural Metal Framing
09 29 00	Gypsum Board
09 51 13	Acoustical Panel Ceilings
09 96 00	High-Performance Coatings

DIVISION 10 – SPECIALTIES

10 14 00	Signage
----------	---------

DIVISION 11 - 12 – (NOT USED)

DIVISION 13 – SPECIAL CONSTRUCTION

13 10 00	Bypass Pumping
13 31 00	Fiberglass Reinforced Building Enclosure
13 34 23.11	Fabricated Electrical Houses

DIVISION 14 – 22 (NOT USED)

DIVISION 23 – HEATING, VENTILATING, AND AIR CONDITIONING (NOT USED)

DIVISION 24 – 25 (NOT USED)

DIVISION 26 – ELECTRICAL

26 05 00	Common Work Results for Electrical
26 05 19	Conductors
26 05 26	Grounding and Bonding
26 05 33	Raceways and Boxes
26 05 73	Short Circuit/Coordination Study
26 22 13	Low Voltage Transformers
26 24 16	Panelboards
26 27 26	Wiring Devices
26 28 11	Molded Case Circuit Breakers
26 28 16	Safety Switches
26 29 23	Variable Frequency Drives
26 32 13	Generators
26 35 26	Active Harmonic Filter
26 36 23	Automatic Transfer Switches
26 50 00	Lighting

DIVISION 27 – COMMUNICATIONS

27 05 26	Grounding and Bonding for Communications Systems
27 05 28	Pathways for Communications Systems
27 05 28.29	Hangers and Supports for Communications Systems
27 11 00	Communications Equipment Room Fittings
27 13 23	Communications Optical Fiber Backbone Cabling
27 15 13	Communications Copper Horizontal Cabling
27 15 23	Communications Optical Fiber Horizontal Cabling

DIVISION 28 – 30 (NOT USED)

DIVISION 31 – EARTHWORK

31 05 16	Aggregates for Earthwork
31 10 00	Site Clearing
31 20 00	Earth Moving
31 23 16.13	Excavation and Trenching
31 23 16.26	Rock Removal
31 23 19	Dewatering
31 25 00	Erosion and Sedimentation Controls
31 50 00	Excavation Support and Protection

DIVISION 32 – EXTERIOR IMPROVEMENTS

32 05 19	Geosynthetics for Exterior Improvements
32 12 16	Asphalt Paving
32 13 13	Concrete Paving
32 31 13	Chain Link Fence and Gates
32 91 13	Soil Preparation
32 92 00	Turf and Grasses
32 92 19	Seeding and Restoration

DIVISION 33 – UTILITIES

33 01 30.13	Sewer and Manhole Testing
33 01 30.51	Pumping and Bypassing
33 01 30.61	Sewer and Pipe Joint Sealing
33 01 30.62	Manhole Grout Sealing
33 05 05.31	Hydrostatic Testing
33 05 13	Manholes and Structures
33 05 16.13	Precast Concrete Utility Structures
33 05 26	Utility Identification
33 31 00	Sanitary Utility Sewerage Piping
33 41 13	Public Storm Utility Drainage Piping

DIVISION 34 – 39 (NOT USED)

DIVISION 40 – PROCESS INTERCONNECTIONS

40 05 06	Couplings Adapters Specials for Process Piping
40 05 07	Hangers and Supports for Process Piping

40 05 13	Common Requirements for Process Piping
40 05 19	Ductile Iron Process Pipe
40 05 23	Stainless Steel Process Pipe and Tubing
40 05 31	Thermoplastic Process Pipe
40 05 51	Common Requirements for Process Valves
40 05 53	Identification for Process Piping
40 05 57	Actuators for Process Valves and Gates
40 05 59	Aluminum Slide Gates
40 05 62	Plug Valves
40 05 63	Ball Valves
40 05 64	Butterfly Valves
40 05 65.23	Swing and Disc Check Valves
40 05 78.21	Air Release Valves for Wastewater Service
40 42 13	Process Piping Insulation
40 70 00	Instrumentation Devices
40 71 13	Magnetic Flow Meters
40 71 69	Parshall Flume
40 72 13	Ultrasonic Level Meters
40 72 43.00	Pressure and Differential Pressure Type Level Meters
40 72 76	Level Switches
40 73 13	Pressure & Differential Pressure Gauges
40 73 64	Annular Pressure Seals
40 75 00	Refrigerated Auto Sampler
40 75 13	PH ORP Sensors
40 75 43	Fluorescent Dissolved Oxygen Measuring
40 90 00	Instrumentation and Control for Process Systems
40 94 03	Programmable Logic Controller Subsystem (PLCS)

DIVISION 41 - MATERIAL PROCESSING & HANDLING EQUIP

41 15 13	Chemical IBC Tote Scale
41 22 14	Jib Cranes
41 22 24	Electrified Monorail Hoist

DIVISION 42 (NOT USED)

DIVISION 43 – PROCESS GAS AND LIQUID HANDLING, PURIFICATION AND STORAGE EQUIPMENT

43 23 13	Reuse Vertical Turbine Pumps
43 25 13	Submersible Centrifugal Pumps
43 26 13	Submersible Chopper Pumps
43 41 46	Polyethylene Tanks and Accessories
43 53 54	Blowers

DIVISION 44 – 45 (NOT USED)

DIVISION 46 – WATER AND WASTEWATER EQUIPMENT

46 05 53	Identification for Water and Wastewater Equipment
46 21 15	Rotary Drum Screens
46 23 23	Grit Removal Equipment
46 33 41	Liquid Chemical Feed Systems
46 33 83	Liquid Chemical Feed Accessories and Safety Equipment
46 41 26	Floating Mechanical Aerators
46 43 21	Circular Secondary Clarifier Equipment
46 51 15	Orbal Aeration System
46 51 16	Submersible Aspirating Aerator Equipment
46 51 23	Fixed Header Aeration System
46 61 23	Disc Cloth Tertiary Filtration
46 66 16	Non-Contact UV Disinfection Equipment
46 73 22	Decanter Assembly
46 76 21	Belt Filter Presses

DIVISION 47 – 48 (NOT USED)

APPENDIX

State of Georgia DNR/EPD NPDES General Permit No. GAR 100001	1 – 48
State of Georgia DNR/EPD NPDES General Permit No. GAR 100002	1 - 50
State of Georgia DNR/EPD NPDES Fact Sheet	1 – 9
State of Georgia DNR/EPD NPDES Fact Sheet Addendum	1 – 2
NPDES General Construction Permit References	1 Page
Grove Creek WPCP – NPDES GA0050355 Draft Permit Package - City – 2025	56 Pages

SECTION 05 12 00 – STRUCTURAL STEEL

PART 1 - GENERAL

1.1 SUMMARY

- A. This section includes the following:
 - 1. Structural Steel
 - 2. Architecturally exposed structural steel
 - 3. Prefabricated building columns

1.2 RELATED DOCUMENTS:

- A. Drawings and general provisions of Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.
- B. Related work specified elsewhere includes:
 - 1. Section 03 20 00 – Anchorage in Concrete
 - 2. Section 03 30 00 – Cast-in-Place Concrete
 - 3. Section 05 50 00 – Metal Fabrication
 - 4. Section 09 96 00 – High Performance Coatings

1.3 DEFINITIONS

- A. Structural Steel: Elements of structural-steel frame, as classified by AISC's "Code of Standard Practice for Steel Buildings and Bridges," that support design loads.
- B. Architecturally Exposed Structural Steel: Structural steel designated as architecturally exposed structural steel in the Contract Documents.

1.4 PERFORMANCE REQUIREMENTS

- A. Connections: Provide details of connections required by the Contract Documents to be selected or completed by structural-steel fabricator to withstand ASD-service loads indicated and comply with other information and restrictions indicated.
 - 1. Select and complete connections using AISC's "ARD/LRFD Steel Construction Manual" 13th Edition.
 - 2. Engineering Responsibility: Fabricator's responsibilities include using a qualified professional engineer to prepare structural analysis data for structural-steel connections.
- B. Construction: Type FR, fully restrained.
- C. Construction: Type 1, rigid frame.

1.5 SUBMITTALS

- A. Product Data: For each type of product indicated. Submit in accordance with Section 01 33 00.
- B. Shop Drawings: Show fabrication of structural-steel components.
 - 1. Include details of cuts, connections, splices, camber, holes, and other pertinent data.
 - 2. Include embedment drawings.
 - 3. Indicate welds by standard AWS symbols, distinguishing between shop and field welds, and show size, length, and type of each weld.
 - 4. Indicate type, size, and length of bolts, distinguishing between shop and field bolts. Identify pretensioned and slip-critical high-strength bolted connections.
 - 5. For structural-steel connections indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
- C. Welding certificates
- D. Mill Test Reports: Signed by manufacturers certifying that the following products comply with requirements:
 - 1. Structural steel including chemical and physical properties.
 - 2. Bolts, nuts, and washers including mechanical properties and chemical analysis.
 - 3. Direct-tension indicators.
 - 4. Tension-control, high-strength bolt-nut-washer assemblies.
 - 5. Shear stud connectors.
 - 6. Shop primers.
- E. Source quality-control test reports.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: A qualified installer who participates in the AISC Quality Certification Program and is designated an AISC-Certified Erector, Category CSE.
- B. Fabricator Qualifications: A qualified fabricator who participates in the AISC Quality Certification Program and is designated an AISC-Certified Plant, Category Sbd.
- C. Shop-Painting Applicators: Qualified according to AISC's Sophisticated Paint Endorsement P1 or SSPC-QP 3, "Standard Procedure for Evaluating Qualifications of Shop Painting Applicators."
- D. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel."
- E. Comply with applicable provisions of the following specifications and documents:
 - 1. AISC's "Code of Standard Practice for Steel Buildings and Bridges."
 - 2. AISC's "Seismic Provisions for Structural Steel Buildings" and "Supplement No. 2."
 - 3. AISC's "Specification for Structural Steel Buildings--Allowable Stress Design (ASD)/ Load and Resistance Factor Design (LRFD)."
 - 4. AISC's "Specification for the Design of Steel Hollow Structural Sections."
 - 5. RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 1 Section "Project Management and Coordination."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Store materials to permit easy access for inspection and identification. Keep steel members off ground and spaced by using pallets, dunnage, or other supports and spacers. Protect steel members and packaged materials from erosion and deterioration.
 - 1. Store fasteners in a protected place. Clean and re-lubricate bolts and nuts that become dry or rusty before use.
 - 2. Do not store materials on structure in a manner that might cause distortion, damage, or overload to members or supporting structures. Repair or replace damaged materials or structures as directed.

1.8 COORDINATION

- A. Furnish anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, sheet metal templates, instructions, and directions for installation.

PART 2 - PRODUCTS

2.1 STRUCTURAL STEEL MATERIALS

- A. W-Shapes: ASTM A 572, Grade 36.
- B. Channels, Angles, M, S-Shapes: ASTM A 36.
- C. Plate and Bar: ASTM A 36.
- D. Corrosion-Resisting Structural Steel: ASTM A 588, Grade 50 (345).
- E. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B, structural tubing.
- F. Corrosion-Resisting Cold-Formed Hollow Structural Sections: ASTM A 847, structural tubing.
- G. Steel Pipe: ASTM A 53, Type E or S, Grade B.
 - 1. Weight Class: Standard.
 - 2. Finish: Black, except where indicated to be galvanized
- H. Medium-Strength Steel Castings: ASTM A 27, Grade 65-35 (Grade 450-240), carbon steel.
- I. High-Strength Steel Castings: ASTM A 148, Grade 80-50 (Grade 550-345), carbon or alloy steel.
- J. Welding Electrodes: Comply with AWS requirements.

2.2 BOLTS, CONNECTORS, AND ANCHORS

- A. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy hex steel structural bolts; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers.
 - 1. Finish: Hot-dip zinc coating, ASTM A 153, Class C.
 - 2. Direct-Tension Indicators: ASTM F 959, Type 325 compressible-washer type.
 - a. Finish: Mechanically deposited zinc coating, ASTM B 695, Class 50.
- B. High-Strength Bolts, Nuts, and Washers: ASTM A 490, Type 1, heavy hex steel structural bolts or tension-control, bolt-nut-washer assemblies with splined ends; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers, plain.
 - 1. Direct-Tension Indicators: ASTM F 959, Type 490 compressible-washer type, plain.
- C. Shear Connectors: ASTM A 108, Grades 1015 through 1020, headed-stud type, cold-finished carbon steel; AWS D1.1, Type B.
- D. Unheaded Anchor Rods: Unless otherwise specified or shown on drawings, ASTM A 36.
 - 1. Configuration: Hooked.
 - 2. Nuts: ASTM A 563 heavy hex carbon steel.
 - 3. Plate Washers: ASTM A 36 carbon steel.
 - 4. Washers: ASTM F 436 hardened carbon steel.
 - 5. Finish: Hot-dip zinc coating, ASTM A 153, Class C.
- E. Headed Anchor Rods: Unless otherwise specified or shown on drawings, ASTM F 1554, Grade 36, straight.
 - 1. Nuts: ASTM A 563 heavy hex carbon steel.
 - 2. Plate Washers: ASTM A 36 carbon steel.
 - 3. Washers: ASTM F 436 hardened carbon steel.
 - 4. Finish: Hot-dip zinc coating, ASTM A 153, Class C.
- F. Threaded Rods: Unless otherwise specified or shown on drawings, ASTM A 193.
 - 1. Nuts: ASTM A 563 heavy hex carbon steel.
 - 2. Washers: ASTM A 36 carbon steel.
 - 3. Finish: Hot-dip zinc coating, ASTM A 153, Class C.
- G. Turnbuckles: ASTM A 108, Grade 1035, cold-finished carbon steel.
- H. Eye Bolts and Nuts: ASTM A 108, Grade 1030, cold-finished carbon steel.
- I. Sleeve Nuts: ASTM A 108, Grade 1018, cold-finished carbon steel.

2.3 PRIMER

- A. Primer: Primer shall be in accordance with Section 09 96 00.
- B. Galvanizing Repair Paint: MPI#18, MPI#19, or SSPC-Paint 20.

2.4 FABRICATION

- A. Structural Steel: Fabricate and assemble in shop to greatest extent possible. Fabricate according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and AISC's "Specification for Structural Steel Buildings--Allowable Stress Design and Load and Resistance Factor Design, 13th Edition"
 - 1. Camber structural-steel members where indicated.
 - 2. Identify high-strength structural steel according to ASTM A 6 and maintain markings until structural steel has been erected.
 - 3. Mark and match-mark materials for field assembly.
 - 4. Complete structural-steel assemblies, including welding of units, before starting shop-priming operations.
- B. Architecturally Exposed Structural Steel: Comply with fabrication requirements, including tolerance limits, of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for structural steel identified as architecturally exposed structural steel.
 - 1. Fabricate with exposed surfaces smooth, square, and free of surface blemishes including pitting, rust, scale, seam marks, roller marks, rolled trade names, and roughness.
 - 2. Remove blemishes by filling or grinding or by welding and grinding, before cleaning, treating, and shop priming.
- C. Thermal Cutting: Perform thermal cutting by machine to greatest extent possible.
 - 1. Plane thermally cut edges to be welded to comply with requirements in AWS D1.1.
- D. Bolt Holes: Cut, drill, mechanically thermal cut, or punch standard bolt holes perpendicular to metal surfaces.
- E. Finishing: Accurately finish ends of columns and other members transmitting bearing loads.
- F. Cleaning: Clean and prepare steel surfaces that are to remain unpainted according to SSPC-SP 3, "Power Tool Cleaning."
- G. Steel Wall-Opening Framing: Select true and straight members for fabricating steel wall-opening framing to be attached to structural steel. Straighten as required to provide uniform, square, and true members in completed wall framing.
- H. Welded Door Frames: Build up welded door frames attached to structural steel. Weld exposed joints continuously and grind smooth. Plug-weld fixed steel bar stops to frames. Secure removable stops to frames with countersunk, cross-recessed head machine screws, uniformly spaced not more than 10 inches (250 mm) o.c., unless otherwise indicated.
- I. Holes: Provide holes required for securing other work to structural steel and for passage of other work through steel framing members.
 - 1. Cut, drill, or punch holes perpendicular to steel surfaces. Do not thermally cut bolt holes or enlarge holes by burning.
 - 2. Base-Plate Holes: Cut, drill, mechanically thermal cut, or punch holes perpendicular to steel surfaces.
 - 3. Weld threaded nuts to framing and other specialty items indicated to receive other work.

2.5 SHOP CONNECTIONS

- A. High-Strength Bolts: Shop install high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.
 - 1. Joint Type: Snug tightened.
- B. Weld Connections: Comply with AWS D1.1 for welding procedure specifications, tolerances, appearance, and quality of welds and for methods used in correcting welding work.
 - 1. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 - 2. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.
 - 3. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Grind butt welds flush.
 - b. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

2.6 SHOP PRIMING

- A. Shop prime steel surfaces except the following:
 - 1. Surfaces embedded in concrete or mortar. Extend priming of partially embedded members to a depth of 2 inches (50 mm).
 - 2. Surfaces to be field welded.
 - 3. Surfaces to be high-strength bolted with slip-critical connections.
 - 4. Surfaces to receive sprayed fire-resistive materials.
 - 5. Galvanized surfaces.
- B. Surface Preparation: Clean surfaces to be painted. Remove loose rust and mill scale and spatter, slag, or flux deposits. Prepare surfaces according to the following specifications and standards:
 - 1. SSPC-SP 2, "Hand Tool Cleaning."
 - 2. SSPC-SP 3, "Power Tool Cleaning."
 - 3. SSPC-SP 5/NACE No. 1, "White Metal Blast Cleaning."
 - 4. SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 5. SSPC-SP 7/NACE No. 4, "Brush-Off Blast Cleaning."
 - 6. SSPC-SP 8, "Pickling."
 - 7. SSPC-SP 10/NACE No. 2, "Near-White Blast Cleaning."
 - 8. SSPC-SP 11, "Power Tool Cleaning to Bare Metal."
 - 9. SSPC-SP 14/NACE No. 8, "Industrial Blast Cleaning."
- C. Priming: Immediately after surface preparation, apply primer according to manufacturer's written instructions and at rate recommended by SSPC to provide a dry film thickness of not less than 1.5 mils (0.038 mm). Use priming methods that result in full coverage of joints, corners, edges, and exposed surfaces.
 - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.
 - 2. Apply two coats of shop paint to inaccessible surfaces after assembly or erection. Change color of second coat to distinguish it from first.

- D. Painting: Apply a 1-coat, non-asphaltic primer complying with SSPC-PS Guide 7.00, "Painting System Guide 7.00: Guide for Selecting One-Coat Shop Painting Systems," to provide a dry film thickness of not less than 1.5 mils (0.038 mm).

2.7 GALVANIZING

- A. Hot-Dip Galvanized Finish: Apply zinc coating by the hot-dip process to structural steel according to ASTM A 123.
 - 1. Fill vent holes and grind smooth after galvanizing.
 - 2. Galvanize lintel and shelf angles attached to structural-steel frame and located in exterior walls.

2.8 SOURCE QUALITY CONTROL

- A. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.
- B. Bolted Connections: Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- C. Welded Connections: In addition to visual inspection, shop-welded connections will be tested and inspected according to AWS D1.1 and the following inspection procedures, at testing agency's option:
 - 1. Liquid Penetrant Inspection: ASTM E 165.
 - 2. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
 - 3. Ultrasonic Inspection: ASTM E 164.
 - 4. Radiographic Inspection: ASTM E 94.
- D. In addition to visual inspection, shop-welded shear connectors will be tested and inspected according to requirements in AWS D1.1 for stud welding and as follows:
 - 1. Bend tests will be performed if visual inspections reveal either a less-than- continuous 360-degree flash or welding repairs to any shear connector.
 - 2. Tests will be conducted on additional shear connectors if weld fracture occurs on shear connectors already tested, according to requirements in AWS D1.1.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Verify elevations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments, with steel erector present, for compliance with requirements.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Provide temporary shores, guys, braces, and other supports during erection to keep structural steel secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural steel, connections, and bracing are in place, unless otherwise indicated.
 - 1. Do not remove temporary shoring supporting composite deck construction until cast-in-place concrete has attained its design compressive strength.

3.3 ERECTION

- A. Set structural steel accurately in locations and to elevations indicated and according to AISC's "Code of Standard Practice for Steel Buildings and Bridges" and "Specification for Structural Steel Buildings--Allowable Stress Design / Load and Resistance Factor Design."
- B. Base and Bearing Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting base and bearing plates. Clean bottom surface of base and bearing plates.
 - 1. Set base and bearing plates for structural members on wedges, shims, or setting nuts as required.
 - 2. Weld plate washers to top of base plate.
 - 3. Snug-tighten anchor rods after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of base or bearing plate before packing with grout.
 - 4. Promptly pack grout solidly between bearing surfaces and base or bearing plates so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for shrinkage-resistant grouts.
- C. Maintain erection tolerances of structural steel and architecturally exposed structural steel within AISC's "Code of Standard Practice for Steel Buildings and Bridges."
- D. Align and adjust various members forming part of complete frame or structure before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that will be in permanent contact with members. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
 - 1. Level and plumb individual members of structure.
 - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure is completed and in service.
- E. Splice members only where indicated.
- F. Remove erection bolts on welded, architecturally exposed structural steel; fill holes with plug welds; and grind smooth at exposed surfaces.
- G. Do not use thermal cutting during erection unless approved by ENGINEER. Finish thermally cut sections within smoothness limits in AWS D1.1.
- H. Do not enlarge unfair holes in members by burning or using drift pins. Ream holes that must be enlarged to admit bolts.

- I. Shear Connectors: Prepare steel surfaces as recommended by manufacturer of shear connectors. Use automatic end welding of headed-stud shear connectors according to AWS D1.1 and manufacturer's written instructions.

3.4 FIELD CONNECTIONS

- A. High-Strength Bolts: Install high-strength bolts according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.
 1. Joint Type: Slip critical.
- B. Weld Connections: Comply with AWS D1.1 for welding procedure specifications, tolerances, appearance, and quality of welds and for methods used in correcting welding work.
 1. Comply with AISC's "Code of Standard Practice for Steel Buildings and Bridges" and "Specification for Structural Steel Buildings--Allowable Stress Design / Load and Resistance Factor Design Specification" for bearing, adequacy of temporary connections, alignment, and removal of paint on surfaces adjacent to field welds.
 2. Remove backing bars or runoff tabs, back gouge, and grind steel smooth.
 3. Assemble and weld built-up sections by methods that will maintain true alignment of axes without exceeding tolerances of AISC's "Code of Standard Practice for Steel Buildings and Bridges" for mill material.
 4. Verify that weld sizes, fabrication sequence, and equipment used for architecturally exposed structural steel will limit distortions to allowable tolerances. Prevent weld show-through on exposed steel surfaces.
 - a. Grind butt welds flush.
 - b. Grind or fill exposed fillet welds to smooth profile. Dress exposed welds.

3.5 PREFABRICATED BUILDING COLUMNS

- A. Install prefabricated building columns to comply with AISC's "Specification for Structural Steel Buildings--Allowable Stress Design / Load and Resistance Factor" manufacturer's written recommendations, and requirements of testing and inspecting agency that apply to the fire-resistance rating indicated.

3.6 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to inspect connections and welds as necessary.
- B. Bolted Connections: Shop-bolted connections will be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
- C. Welded Connections: Field welds will be visually inspected according to AWS D1.1.
 1. In addition to visual inspection, field welds will be tested according to AWS D1.1 and the following inspection procedures, at testing agency's option:
 - a. Liquid Penetrant Inspection: ASTM E 165.

- b. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
 - c. Ultrasonic Inspection: ASTM E 164.
 - d. Radiographic Inspection: ASTM E 94.
- D. In addition to visual inspection, test and inspect field-welded shear connectors according to requirements in AWS D1.1 for stud welding and as follows:
 - 1. Perform bend tests if visual inspections reveal either a less-than- continuous 360-degree flash or welding repairs to any shear connector.
 - 2. Conduct tests on additional shear connectors if weld fracture occurs on shear connectors already tested, according to requirements in AWS D1.1.
- E. Correct deficiencies in Work that test reports and inspections indicate does not comply with the Contract Documents.

3.7 REPAIRS AND PROTECTION

- A. Repair damaged galvanized coatings on galvanized items with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Touchup Painting: After installation, promptly clean, prepare, and prime or reprime field connections, rust spots, and abraded surfaces of prime-painted joists and accessories, bearing plates, and abutting structural steel.
 - 1. Clean and prepare surfaces by SSPC-SP 2 hand-tool cleaning or SSPC-SP 3 power-tool cleaning.
 - 2. Apply a compatible primer of same type as shop primer used on adjacent surfaces.
- C. Touchup Painting: Cleaning and touchup painting are specified in Section 09 96 00.

END OF SECTION 05 12 00

SECTION 05 35 15 - COLD-FORMED METAL FRAMING

1.1 SUMMARY

A. Section Includes:

1. Load-bearing wall framing.
2. Soffit framing.

B. Related Requirements:

1. Section 05 50 00 - Metal Fabrications for miscellaneous steel shapes, masonry shelf angles, and connections used with cold-formed metal framing.
2. Section 07 21 00 - Thermal Insulation for insulation installation between cold-formed metal framing.
3. Section 09 22 16 - Non-Structural Metal Framing for standard, interior non-load-bearing, metal-stud framing, with height limitations and ceiling-suspension assemblies.

1.2 ACTION SUBMITTALS

A. Product Data: For each type of product.

B. Shop Drawings:

1. Include layout, spacings, sizes, thicknesses, and types of cold-formed steel framing; fabrication; and fastening and anchorage details, including mechanical fasteners.
2. Indicate reinforcing channels, opening framing, supplemental framing, strapping, bracing, bridging, splices, accessories, connection details, and attachment to adjoining work.

1.3 QUALITY ASSURANCE

A. Product Tests: Mill certificates or data from a qualified independent testing agency indicating steel sheet complies with requirements, including base-metal thickness, yield strength, tensile strength, total elongation, chemical requirements, and metallic-coating thickness.

B. Code-Compliance Certification of Studs and Tracks: Provide documentation that framing members are certified according to the product-certification program of the Steel Stud Manufacturers Association.

C. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1, "Structural Welding Code - Steel."
2. AWS D1.3, "Structural Welding Code - Sheet Steel."

D. Comply with AISI S230 "Standard for Cold-Formed Steel Framing - Prescriptive Method for One and Two Family Dwellings."

PART 2 - PRODUCTS

2.1 MANUFACTURERS

A. Subject to compliance with requirements, provide metal framing by one of the following:

1. Clarke Dietrich.
2. MarinoWARE
3. MRI Steel Framing, LLC.
4. Steel Construction Systems.
5. Telling Industries.
6. Or Approved Equal

2.2 PERFORMANCE REQUIREMENTS

A. Structural Performance: Provide cold-formed steel framing capable of withstanding design loads within limits and under conditions indicated.

1. Design Loads: As indicated on Drawings.
2. Deflection Limits: Design framing systems to withstand design loads without deflections greater than the following:
 - a. Exterior Load-Bearing Wall Framing: Horizontal deflection of 1/360 of the wall height.
 - b. Interior Load-Bearing Wall Framing: Horizontal deflection of 1/360 of the wall height under a horizontal load of 5 lbf/sq. ft.
3. Design framing system to maintain clearances at openings, to allow for construction tolerances, and to accommodate live load deflection of primary building structure as follows:
 - a. Upward and downward movement of ½ inch
4. Cold-Formed Steel Framing Standards: Unless more stringent requirements are indicated, framing shall comply with AISI S100, AISI S200, and the following:
5. Wall Studs: AISI S211.
6. Headers: AISI S212.
7. Lateral Design: AISI S213.

B. Fire-Resistance Ratings: Comply with ASTM E 119; testing by a qualified testing agency. Identify products with appropriate markings of applicable testing agency.

1. Indicate design designations from UL's "Fire Resistance Directory" or from the listings of another qualified testing agency acceptable to authorities having jurisdiction.

2.3 COLD-FORMED STEEL FRAMING MATERIALS

A. Steel Sheet: ASTM A 1003, Structural Grade, Type H, metallic coated, of grade and coating designation as follows:

1. Grade: ST33H .
2. Coating: G60.

- B. Steel Sheet for Clips: ASTM A 653, structural steel, zinc coated, of grade and coating as follows:

1. Grade: 33.
2. Coating: G60.

2.4 LOAD-BEARING WALL FRAMING

- A. Steel Studs: Manufacturer's standard C-shaped steel studs, of web depths indicated, punched, with stiffened flanges, and as follows:

1. Minimum Base-Metal Thickness: 0.0677 inch.
2. Flange Width: 1-5/8 inches.

- B. Steel Track: Manufacturer's standard U-shaped steel track, of web depths indicated, unpunched, with straight flanges, and as follows:

1. Minimum Base-Metal Thickness: 0.0677.
2. Flange Width: 1-1/4 inches.

- C. Steel Box or Back-to-Back Headers: Manufacturer's standard C-shapes used to form header beams, of web depths indicated, unpunched, with stiffened flanges, and as follows:

1. Minimum Base-Metal Thickness: 0.0677 inch .
2. Flange Width: 1-5/8 inches.

2.5 SOFFIT FRAMING

- A. Exterior Soffit Frame: Manufacturer's standard C-shaped steel sections, of web depths indicated, with stiffened flanges, and as follows:

1. Minimum Base-Metal Thickness: 0.0538 inch.
2. Flange Width: 1-5/8 inches, minimum.

2.6 FRAMING ACCESSORIES

- A. Fabricate steel-framing accessories from ASTM A 1003, Structural Grade, Type H, metallic coated steel sheet, of same grade and coating designation used for framing members.

- B. Provide accessories of manufacturer's standard thickness and configuration, unless otherwise indicated, as follows:

1. Supplementary framing.
2. Bracing, bridging, and solid blocking.
3. Web stiffeners.
4. Anchor clips.

5. End clips.
6. Foundation clips.
7. Gusset plates.
8. Stud kickers and knee braces.
9. Joist hangers and end closures.
10. Hole-reinforcing plates.
11. Backer plates.

2.7 ANCHORS, CLIPS, AND FASTENERS

- A. Steel Shapes and Clips: ASTM A 36, zinc coated by hot-dip process according to ASTM A 123.
- B. Anchor Bolts: ASTM F 1554, Grade 36, threaded carbon steel carbon-steel nuts, and flat, hardened-steel washers; zinc coated by hot-dip process according to ASTM A 153.
- C. Power-Actuated Anchors: Fastener systems with working capacity greater than or equal to the design load, according to an evaluation report acceptable to authorities having jurisdiction, based on ICC-ES AC70.
- D. Mechanical Fasteners: ASTM C 1513, corrosion-resistant-coated, self-drilling, self-tapping, steel drill screws.
 1. Head Type: Low-profile head beneath sheathing; manufacturer's standard elsewhere.
- E. Welding Electrodes: Comply with AWS standards.

2.8 MISCELLANEOUS MATERIALS

- A. Nonmetallic, Nonshrink Grout: Factory-packaged, nonmetallic, noncorrosive, nonstaining grout, complying with ASTM C 1107, and with a fluid consistency and 30-minute working time.
- B. Shims: Load-bearing, high-density, multimonomer, nonleaching plastic; or cold-formed steel of same grade and metallic coating as framing members supported by shims.
- C. Sealer Gaskets: Closed-cell neoprene foam, 1/4 inch thick, selected from manufacturer's standard widths to match width of bottom track or rim track members as required.

2.9 FABRICATION

- A. Fabricate cold-formed steel framing and accessories plumb, square, and true to line, and with connections securely fastened, according to referenced AISI's specifications and standards, manufacturer's written instructions, and requirements in this Section.
 1. Fabricate framing assemblies using jigs or templates.
 2. Cut framing members by sawing or shearing; do not torch cut.
 3. Fasten cold-formed steel framing members by welding, screw fastening, clinch fastening, pneumatic pin fastening, or riveting as standard with fabricator. Wire tying of framing members is not permitted.

- a. Comply with AWS D1.3 requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners and install according to Shop Drawings, with screws penetrating joined members by no fewer than three exposed screw threads.
- 4. Fasten other materials to cold-formed steel framing by welding, bolting, pneumatic pin fastening, or screw fastening, according to Shop Drawings.
- B. Reinforce, stiffen, and brace framing assemblies to withstand handling, delivery, and erection stresses. Lift fabricated assemblies by means that prevent damage or permanent distortion.
- C. Tolerances: Fabricate assemblies level, plumb, and true to line to a maximum allowable variation of 1/8 inch in 10 feet and as follows:
 - 1. Spacing: Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.
 - 2. Squareness: Fabricate each cold-formed steel framing assembly to a maximum out-of-square tolerance of 1/8 inch.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine substrates, areas, conditions, and abutting structural framing for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Install load-bearing shims or grout between the underside of load-bearing wall bottom track and the top of foundation wall or slab at locations with a gap larger than 1/4 inch to ensure a uniform bearing surface on supporting concrete or masonry construction.
- B. Install sealer gaskets at the underside of wall bottom track or rim track and at the top of foundation wall or slab at stud or joist locations.

3.3 INSTALLATION, GENERAL

- A. Cold-formed steel framing may be shop or field fabricated for installation, or it may be field assembled.
- B. Install cold-formed steel framing according to AISI S200, AISI S202, and manufacturer's written instructions unless more stringent requirements are indicated.
- C. Install cold-formed steel framing and accessories plumb, square, and true to line, and with connections securely fastened.

1. Cut framing members by sawing or shearing; do not torch cut.
2. Fasten cold-formed steel framing members by welding, screw fastening, clinch fastening, or riveting. Wire tying of framing members is not permitted.
 - a. Comply with AWS D1.3 requirements and procedures for welding, appearance and quality of welds, and methods used in correcting welding work.
 - b. Locate mechanical fasteners, install according to Shop Drawings, and comply with requirements for spacing, edge distances, and screw penetration.
- D. Install framing members in one-piece lengths unless splice connections are indicated for track or tension members.
- E. Install temporary bracing and supports to secure framing and support loads equal to those for which structure was designed. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to framing are secured.
- F. Do not bridge building expansion joints with cold-formed steel framing. Independently frame both sides of joints.
- G. Install insulation, specified in Section 07 21 00 - Thermal Insulation, in framing-assembly members, such as headers, sills, boxed joists, and multiple studs at openings, that are inaccessible on completion of framing work.
- H. Fasten hole-reinforcing plate over web penetrations that exceed size of manufacturer's approved or standard punched openings.

3.4 LOAD-BEARING WALL INSTALLATION

- A. Install continuous top and bottom tracks sized to match studs. Align tracks accurately and securely anchor at corners and ends, and at spacings as follows:
 1. Anchor Spacing: 32 inches.
- B. Squarely seat studs against top and bottom tracks, with gap not exceeding 1/8 inch between the end of wall-framing member and the web of track. Fasten both flanges of studs to top and bottom tracks. Space studs as follows:
 1. Stud Spacing: 16 inches.
- C. Set studs plumb, except as needed for diagonal bracing or required for nonplumb walls or warped surfaces and similar configurations.
- D. Align studs vertically where floor framing interrupts wall-framing continuity. Where studs cannot be aligned, continuously reinforce track to transfer loads.
- E. Align roof framing over studs according to AISI S200, Section C1. Where framing cannot be aligned, continuously reinforce track to transfer loads.
- F. Anchor studs abutting structural columns or walls, including masonry walls, to supporting structure.

- G. Install headers over wall openings wider than stud spacing. Locate headers above openings. Fabricate headers of compound shapes indicated or required to transfer load to supporting studs, complete with clip-angle connectors, web stiffeners, or gusset plates.
 - 1. Frame wall openings with not less than a double stud at each jamb of frame. Fasten jamb members together to uniformly distribute loads.
 - 2. Install tracks and jack studs above and below wall openings. Anchor tracks to jamb studs with clip angles or by welding, and space jack studs same as full-height wall studs.
- H. Install supplementary framing, blocking, and bracing in stud framing indicated to support fixtures, equipment, services, casework, heavy trim, furnishings, and similar work requiring attachment to framing.
 - 1. If type of supplementary support is not indicated, comply with stud manufacturer's written recommendations and industry standards in each case, considering weight or load resulting from item supported.
- I. Install horizontal bridging in stud system, spaced vertically 48 inches. Fasten at each stud intersection.
 - 1. Channel Bridging: Cold-rolled steel channel, welded or mechanically fastened to webs of punched studs with a minimum of two screws into each flange of the clip angle for framing members up to 6 inches deep.
 - 2. Strap Bridging: Combination of flat, taut, steel sheet straps of width and thickness indicated and stud-track solid blocking of width and thickness to match studs. Fasten flat straps to stud flanges, and secure solid blocking to stud webs or flanges.
 - 3. Bar Bridging: Proprietary bridging bars installed according to manufacturer's written instructions.
- J. Install steel sheet diagonal bracing straps to both stud flanges; terminate at and fasten to reinforced top and bottom tracks. Fasten clip-angle connectors to multiple studs at ends of bracing and anchor to structure.
- K. Install miscellaneous framing and connections, including supplementary framing, web stiffeners, clip angles, continuous angles, anchors, and fasteners, to provide a complete and stable wall-framing system.

3.5 ERECTION TOLERANCES

- A. Install cold-formed steel framing level, plumb, and true to line to a maximum allowable tolerance variation of 1/8 inch in 10 feet and as follows:
 - 1. Space individual framing members no more than plus or minus 1/8 inch from plan location. Cumulative error shall not exceed minimum fastening requirements of sheathing or other finishing materials.

3.6 REPAIRS AND PROTECTION

- A. Galvanizing Repairs: Prepare and repair damaged galvanized coatings on fabricated and installed cold-formed steel framing with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Provide final protection and maintain conditions, in a manner acceptable to manufacturer and Installer, that ensure that cold-formed steel framing is without damage or deterioration at time of Substantial Completion.

END OF SECTION 05 35 15

SECTION 05 40 00 - ALUMINUM HANDRAIL

PART 1 - GENERAL

1.1 SCOPE

- A. The work covered by this section includes furnishing all labor, equipment and materials required to furnish and install aluminum component handrail including all fittings, anchors, bases and accessories, as required by the Contract Documents.
- B. All guardrails shall be furnished with a toe board, except where concrete curbs are shown (if any).
- C. This section shall be used for all handrail except in areas where stairs and handrail are congruent as specified in Section 05 52 13.

1.2 RELATED DOCUMENTS

- A. Related work specified elsewhere includes:
 - 1. Section 03 30 00 – Cast-in-Place Concrete
 - 2. Section 05 50 00 – Metal Fabrications

1.3 SUBMITTALS

- A. Submit complete shop drawings and product data in accordance with the requirements of Section 01 33 00 – Submittal Procedures.
- B. Submit structural calculations, including anchorages.

1.4 STORAGE AND PROTECTION

- A. Handrails shall be properly packaged to prevent scratching and denting during shipment, storage and erection. Maintain protective wrapping until project is completed.

PART 2 - PRODUCTS

2.1 DESIGN REQUIREMENTS

- A. Component aluminum handrail system shall be designed and constructed in strict compliance with the requirements of OSHA and the International Building Code.
- B. Guardrails shall be designed to withstand a uniform horizontal load of 50 pounds per foot with a simultaneous vertical load of 100 pounds per foot applied to the top rail.

- C. Handrail shall be designed to withstand a uniform horizontal load of 50 pounds per foot applied to the top rail.
- D. In addition, guardrails, handrails shall be designed to withstand a concentrated load of 200 pounds applied in any direction, at any point on the railing system.

2.2 ACCEPTABLE PRODUCTS/MANUFACTURERS

- A. Component aluminum handrail system shall be
 - 1. "TUFrail" by Thompson Fabricating - Birmingham., AL.
 - 2. "Interna-Rail" by Hollaender Corp. – Cincinnati., Ohio
 - 3. Alumagard - Denver, CO.
 - 4. Or equal

2.3 MATERIAL AND CONSTRUCTION

- A. Handrail shall be the product of a company normally engaged in the manufacture of pipe railing. Railing shall be shop assembled in lengths not to exceed 24 feet for field erection.
- B. Post spacing shall be a maximum of 6'-0". Posts and rails shall be a minimum of 1 1/2" schedule 40 aluminum pipe, alloy 6063-T6 or 6105-T5, ASTM B-429 or B-221.
- C. Handrail shall be made of pipe and fittings mechanically fastened together with stainless steel hardware. Handrail systems which use fittings that are glued or pop-riveted will not be acceptable.
- D. Toe board shall conform to OSHA standards. Toe board shall be a minimum of 4" high and shall attach to the post using clamps which will allow for expansion and contraction between posts. Toe board shall be set 1/4" above the walking surface.
- E. Wedge anchors shall be spaced 10d apart and 5d edge distance for no reduction in pullout strength. A safety factor of 4 shall be used on pullout values published by the manufacturer. Wedge anchors shall be type 304 stainless steel.
- F. Openings in the railing shall guarded by a self-closing gate (OSHA 1910.23). Safety chains are not acceptable.
- G. All handrail and components shall be clear anodized per Aluminum Association M10C22A41 (215-R1). The pipe shall be plastic wrapped to protect the finish.
- H. All aluminum surfaces in contact with concrete, grout or dissimilar metals shall be protected with a coat of bituminous paint, mylar isolators or other approved material.

PART 3 - EXECUTION

3.1 INSTALLATION

- A. Field fabrication of the railing system is not permitted.

- B. Set handrails plumb within 1/8" of vertical and align horizontally to within 1/8" in 12 feet.
- C. Install wedge anchors to proper depth to develop full pullout and shear values. Check all fasteners and bolts in base connections and splices for tightness.
- D. Adequate provisions for expansion and contraction shall be incorporated into the rail. Expansion joints shall be placed at 60-foot intervals and at all concrete expansion joints.
- E. Toe boards shall be shipped loose and attached to the handrail in the field. Attachment to the posts shall be made with clamps which will allow for expansion and contraction while maintaining a straight line.
- F. All defective, damaged or otherwise improperly installed handrail shall be removed and replaced with material which complies with this section at no additional cost to the Owner.
- G. Following installation, aluminum handrail shall be cleaned with a mild soap and clean water. Acid solutions, steel wool or harsh abrasives shall not be used.

END OF SECTION 05 40 00

SECTION 05 50 00 - 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 mechanical and electrical equipment.
3. Steel framing and supports for applications where framing and supports are not specified in other Sections.
4. Shelf angles.
5. Alternating tread devices.
6. Metal ships' ladders
7. Metal floor plate and supports.
8. Metal bollards.
9. Metal downspout boots.
10. Loose bearing and leveling plates for applications where they are not specified in other Sections.
11. Loose steel lintels.

B. Products furnished, but not installed, under this Section include the following:

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 Requirements:

1. Section 03 30 00 – Cast-in-Place Concrete for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.

1.3 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 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. Prefabricated building columns.
 - 3. Metal nosings and treads.
 - 4. Paint products.
 - 5. Grout.
- 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 mechanical and electrical equipment.
 - 3. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 - 4. Alternating tread devices.
 - 5. Metal ships' ladders
 - 6. Metal floor plate and supports.
 - 7. Miscellaneous steel trim
 - 8. Metal bollards.
 - 9. Downspout guards.
 - 10. Abrasive metal nosings treads and thresholds.
 - 11. Metal downspout boots.
 - 12. Loose steel lintels.
- C. Samples for Verification: For each type and finish of extruded nosing and tread.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For professional engineer.
- B. Mill Certificates: Signed by stainless-steel manufacturers, certifying that products furnished comply with requirements.
- C. Welding certificates.
- D. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers, certifying that shop primers are compatible with topcoats.
- E. Research/Evaluation Reports: For post-installed anchors, from ICC-ES.

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code - Steel."
- B. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1, "Structural Welding Code - Steel."
 - 2. AWS D1.2, "Structural Welding Code - Aluminum."
 - 3. AWS D1.6, "Structural Welding Code - Stainless Steel."

1.7 FIELD CONDITIONS

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

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 01 40 00 - Quality Requirements, to design ladders.
- B. Structural Performance of Aluminum Ladders: Aluminum ladders, including landings, shall withstand the effects of loads and stresses within limits and under conditions specified in ANSI A14.3.
- C. Structural Performance of Alternating Tread Devices: Alternating tread devices shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated.
 - 1. Uniform Load: 100 lbf/sq. ft.
 - 2. Concentrated Load: 300 lbf applied on an area of 4 sq. in.
 - 3. Uniform and concentrated loads need not be assumed to act concurrently.
 - 4. Alternating Tread Device Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
- D. 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 °F, ambient; 180 °F, 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 A 36.
- C. Stainless-Steel Sheet, Strip, and Plate: ASTM A 240 or ASTM A 666, Type 316L.
- D. Stainless-Steel Bars and Shapes: ASTM A 276, Type 316L.
- E. Rolled-Steel Floor Plate: ASTM A 786, rolled from plate complying with ASTM A 36 or ASTM A 283, Grade C or D.
- F. Rolled-Stainless-Steel Floor Plate: ASTM A 793.
- G. Steel Tubing: ASTM A 500, cold-formed steel tubing.
- H. Steel Pipe: ASTM A 53, Standard Weight (Schedule 40) unless otherwise indicated.
- I. Zinc-Coated Steel Wire Rope: ASTM A 741.
 - 1. Wire-Rope Fittings: Hot-dip galvanized-steel connectors with capability to sustain, without failure, a load equal to minimum breaking strength of wire rope with which they are used.
- J. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.
 - 1. Size of Channels: As indicated.
 - 2. Material: Galvanized steel, ASTM A 653, structural steel, Grade 33, with G90 coating; 0.079-inch nominal thickness.
 - 3. Material: Cold-rolled steel, ASTM A 1008, structural steel, Grade 33; 0.0677-inch minimum thickness; hot-dip galvanized after fabrication.
- K. Cast Iron: Either gray iron, ASTM A 48, or malleable iron, ASTM A 47, unless otherwise indicated.
- L. Aluminum Plate and Sheet: ASTM B 209, Alloy 6061-T6.
- M. Aluminum Extrusions: ASTM B 221, Alloy 6063-T6.
- N. Aluminum-Alloy Rolled Tread Plate: ASTM B 632, Alloy 6061-T6.
- O. Aluminum Castings: ASTM B 26, Alloy 443.0-F.
- P. Bronze Extrusions: ASTM B 455, Alloy UNS No. C38500 (extruded architectural bronze).
- Q. Bronze Castings: ASTM B 584, Alloy UNS No. C83600 (leaded red brass) or No. C84400 (leaded semired brass).
- R. Nickel Silver Extrusions: ASTM B 151, Alloy UNS No. C74500.
- S. Nickel Silver Castings: ASTM B 584, Alloy UNS No. C97600 (20 percent leaded nickel bronze).

2.3 FASTENERS

- A. General: Unless otherwise indicated, provide Type 316 stainless-steel fasteners for exterior use and use in wastewater treatment facilities. Use Zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.
 - 1. Provide stainless-steel fasteners for fastening aluminum.
 - 2. Provide stainless-steel fasteners for fastening stainless steel.
 - 3. Provide stainless-steel fasteners for fastening nickel silver.
 - 4. Provide bronze fasteners for fastening bronze.
- B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 325, Type 3; with hex nuts, ASTM A 563, Grade C3; and, where indicated, flat washers.
- D. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593; with hex nuts, ASTM F 594; and, where indicated, flat washers; Alloy Group 2.
- E. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; 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: Anchors 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 according to ASTM E 488, conducted by a qualified independent testing agency.
- G. Cast-in-Place Anchors in Concrete: Either threaded type or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A 47 malleable iron or ASTM A 27 cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F 2329.
- H. Post-Installed Anchors: Torque-controlled expansion anchors.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy Group 2 stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.
- 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 B 633, Class Fe/Zn 5, as needed for fastening to inserts.

2.4 MISCELLANEOUS MATERIALS

- A. Shop Primers: Provide primers that comply with manufacturer's recommendations in Section 09 96 00 – High Performance Coatings.
- 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. Epoxy Zinc-Rich Primer: Complying with MPI#20 and compatible with topcoat.
- D. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- E. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.
- F. 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.
- G. Concrete: Comply with requirements in Section 03 30 00 - Cast-in-Place Concrete for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 3000 psi.

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. Fabricate steel girders for wood frame construction from continuous steel shapes of sizes indicated.
 - 1. Provide bearing plates welded to beams where indicated.
 - 2. Drill or punch girders and plates for field-bolted connections where indicated.
 - 3. Where wood nailers are attached to girders with bolts or lag screws, drill or punch holes at 24 inches o.c.
- E. Fabricate steel pipe columns for supporting wood frame construction from steel pipe with steel baseplates and top plates as indicated. Drill or punch baseplates and top plates for anchor and connection bolts and weld to pipe with fillet welds all around. Make welds the same size as pipe wall thickness unless otherwise indicated.
 - 1. Unless otherwise indicated, fabricate from Schedule 40 steel pipe.

2. Unless otherwise indicated, provide 1/2-inch baseplates with four 5/8-inch anchor bolts and 1/4-inch top plates.

- F. Galvanize miscellaneous framing and supports where indicated.
- G. Prime miscellaneous framing and supports with zinc-rich primer.

2.7 SHELF ANGLES

- A. Fabricate shelf angles from steel angles of sizes indicated and for attachment to concrete framing. Provide horizontally slotted holes to receive 3/4-inch bolts, spaced not more than 6 inches from ends and 24 inches o.c., unless otherwise indicated.
 1. Provide mitered and welded units at corners.
 2. Provide open joints in shelf angles at expansion and control joints. Make open joint approximately 2 inches larger than expansion or control joint.
- B. For cavity walls, provide vertical channel brackets to support angles from backup masonry and concrete.
- C. Galvanize shelf angles located in exterior walls.

2.8 METAL LADDERS

- A. General:
 1. Comply with ANSI A14.3.
 2. For elevator pit ladders, comply with ASME A17.1/CSA B44.
- B. Steel Ladders:
 1. Space siderails 18 inches apart unless otherwise indicated.
 2. Siderails: Continuous, 3/8-by-2-1/2-inch steel flat bars, with eased edges.
 3. Rungs: 1-inch-diameter or 1-inch-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 platforms as indicated fabricated from welded or pressure-locked steel bar grating, supported by steel angles. Limit openings in gratings to no more than 3/4 inch in least dimension.
 7. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted steel brackets.
 8. Galvanize exterior ladders, including brackets.
- C. Aluminum Ladders:

1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to the following:
 - a. Halliday Products.
 - b. O'Keeffe's Inc.
 - c. Precision Ladders, LLC.
 - d. Thompson Fabricating, LLC.
 - e. Or approved equal.
2. Space siderails 16 inches apart unless otherwise indicated.
3. Siderails: Continuous extruded-aluminum channels or tubes, not less than 2-1/2 inches deep, 3/4 inch wide, and 1/8 inch thick.
4. Rungs: Extruded-aluminum tubes, not less than 3/4 inch deep and not less than 1/8 inch thick, with ribbed tread surfaces.
5. Fit rungs in centerline of siderails; fasten by welding or with stainless-steel fasteners or brackets and aluminum rivets.
6. Provide platforms as indicated fabricated from pressure-locked aluminum bar grating or extruded-aluminum plank grating, supported by extruded-aluminum framing. Limit openings in gratings to no more than 3/4 inch in least dimension.
7. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted aluminum brackets.
8. Provide minimum 72-inch-high, hinged security door with padlock hasp at foot of ladder to prevent unauthorized ladder use.

2.9 LADDER SAFETY CAGES

A. General:

1. Fabricate ladder safety cages to comply with ANSI A14.3. Assemble by welding or with stainless-steel fasteners.
2. Provide primary hoops at tops and bottoms of cages and spaced not more than 20 feet o.c. Provide secondary intermediate hoops spaced not more than 48 inches o.c. between primary hoops.
3. Fasten assembled safety cage to ladder rails and adjacent construction by welding or with stainless-steel fasteners unless otherwise indicated.

B. Steel Ladder Safety Cages:

1. Primary Hoops: 1/4-by-4-inch flat bar hoops.
2. Secondary Intermediate Hoops: 1/4-by-2-inch flat bar hoops.
3. Vertical Bars: 3/16-by-1-1/2-inch flat bars secured to each hoop.
4. Galvanize ladder safety cages, including brackets and fasteners.

C. Aluminum Ladder Safety Cages:

1. Primary Hoops: 1/4-by-4-inch flat bar hoops.
2. Secondary Intermediate Hoops: 1/4-by-2-inch flat bar hoops.
3. Vertical Bars: 1/4-by-2-inch flat bars secured to each hoop.

2.10 METAL SHIPS' LADDERS AND PIPE CROSSOVERS

- A. Provide metal ships' ladders and pipe crossovers where indicated. Fabricate of open-type construction with channel or plate stringers and pipe and tube railings unless otherwise indicated. Provide brackets and fittings for installation.
 - 1. Treads shall be not less than 5 inches exclusive of nosing or less than 8-1/2 inches including the nosing, and riser height shall be not more than 9-1/2 inches.
 - 2. Fabricate ships' ladders and pipe crossovers, including railings from aluminum.
 - 3. Fabricate treads and platforms from extruded-aluminum plank grating. Limit openings in gratings to no more than 3/4 inch in least dimension.
 - 4. Fabricate treads and platforms from rolled-aluminum-alloy tread plate.
 - 5. Comply with applicable railing requirements.
- B. Galvanize exterior steel ships' ladders and pipe crossovers, including treads, railings, brackets, and fasteners.

2.11 METAL FLOOR PLATE

- A. Fabricate from aluminum diamond floor plate of thickness indicated below:
 - 1. Thickness: As required for loadings indicated.
- B. Provide grating sections where indicated fabricated from extruded-aluminum plank grating. Limit openings in gratings to no more than 3/4 inch in least dimension.
- C. Provide stainless-steel angle supports as indicated.
- D. Include stainless-steel angle stiffeners, and fixed and removable sections as indicated.
- E. Provide flush stainless-steel bar drop handles for lifting removable sections, one at each end of each section.

2.12 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 exterior miscellaneous steel trim.

2.13 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 40 steel pipe.
 - 1. Cap bollards with 1/4-inch-thick steel plate.
 - 2. Where bollards are indicated to receive controls for door operators, provide cutouts for controls and holes for wire.
 - 3. Where bollards are indicated to receive light fixtures, provide cutouts for fixtures and holes for wire.
- B. Fabricate bollards with 3/8-inch-thick steel baseplates for bolting to concrete slab. Drill baseplates at all four corners for 3/4-inch anchor bolts.
 - 1. Where bollards are to be anchored to sloping concrete slabs, angle baseplates for plumb alignment of bollards.
- C. Fabricate sleeves for bollard anchorage from steel pipe or tubing with 1/4-inch-thick steel plate welded to bottom of sleeve. Make sleeves not less than 8 inches deep and 3/4 inch larger than OD of bollard.
- D. Fabricate internal sleeves for removable bollards from Schedule 40 steel pipe or 1/4-inch wall-thickness steel tubing with an OD approximately 1/16 inch less than ID of bollards. Match drill sleeve and bollard for 3/4-inch steel machine bolt.
- E. Prime bollards with zinc-rich primer.

2.14 ABRASIVE METAL NOSINGS TREADS AND THRESHOLDS

- A. Provide abrasive metal nosing treads on all interior stair construction and thresholds for all interior/exterior doors.
- B. Cast-Metal Units: Cast aluminum, with an integral-abrasive, as-cast finish consisting of aluminum oxide, silicon carbide, or a combination of both. Fabricate units in lengths necessary to accurately fit openings or conditions.
 - 1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to the following:
 - a. Victory Treads
 - b. American Safety Tread Co., Inc.
 - c. Balco, Inc.
 - d. Safe-T-Metal Company, Inc.
 - e. Or approved equal.
 - 2. Nosings: Cross-hatched units, 1-1/2 by 1-1/2 inches, for casting into concrete.
 - 3. Treads: Cross-hatched units, full depth of tread with 3/4-by-3/4-inch nosing, for application over bent plate treads or existing stairs.
 - 4. Thresholds: Fluted-saddle-type units, 5 inches wide by 1/2 inch high, with tapered edges.

- C. Extruded Units: Aluminum, with abrasive filler consisting of aluminum oxide, silicon carbide, or a combination of both, in an epoxy-resin binder. Fabricate units in lengths necessary to accurately fit openings or conditions.
 - 1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to the following:
 - a. ACL Industries, Inc.
 - b. American Safety Tread Co., Inc.
 - c. Balco, Inc.
 - d. Or approved equal.
 - 2. Provide ribbed units, with abrasive filler strips projecting 1/16 inch above aluminum extrusion.
 - 3. Nosings: Square-back units, 3 inches wide, for casting into concrete steps.
 - 4. Treads: Square-back units, full depth of tread with 1-3/8-inch lip, for application over existing stairs.
- D. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- E. Apply bituminous paint to concealed surfaces of cast-metal units.
- F. Apply clear lacquer to concealed surfaces of extruded units.

2.15 METAL DOWNSPOUT BOOTS

- A. Provide downspout boots made from aluminum in heights indicated with inlets of size and shape to suit downspouts. Provide units with flanges and holes for countersunk anchor bolts.
 - 1. Outlet: Vertical, to discharge into pipe OR at 35 degrees from horizontal, to discharge onto splash block or pavement.

2.16 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 plates.
- C. Prime plates with zinc-rich primer.

2.17 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. Galvanize and prime loose steel lintels located in exterior walls.
- C. Prime loose steel lintels located in exterior walls with zinc-rich primer.

2.18 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.

2.19 FINISHES, GENERAL

- 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.

2.20 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153 for steel and iron hardware and with ASTM A 123 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 railings 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, sprayed-on fireproofing, or masonry, or unless otherwise indicated.
- D. Preparation for Shop Priming: Prepare surfaces to comply with SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."

2.21 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 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.
- B. Anchor supports for overhead doors securely to, and rigidly brace from, building structure.
- C. Support steel girders on solid grouted masonry, concrete, or steel pipe columns. Secure girders with anchor bolts embedded in grouted masonry or concrete or with bolts through top plates of pipe columns.

1. Where grout space under bearing plates is indicated for girders supported on concrete or masonry, install as specified in "Installing Bearing and Leveling Plates" Article.
- D. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified in "Installing Bearing and Leveling Plates" Article.
 1. Grout baseplates of columns supporting steel girders after girders are installed and leveled.

3.3 INSTALLING METAL BOLLARDS

- A. Fill metal-capped bollards solidly with concrete and allow concrete to cure seven days before installing.
 1. Do not fill removable bollards with concrete.
- B. Anchor bollards to existing construction with anchor bolts. Provide four 3/4-inch bolts at each bollard unless otherwise indicated.
 1. Embed anchor bolts at least 4 inches in concrete.
- C. Anchor bollards in concrete in formed or core-drilled holes not less than 8 inches deep and 3/4 inch larger than OD of bollard. Fill annular space around bollard solidly with nonshrink grout; mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward bollard.
- D. Anchor internal sleeves for removable bollards in formed or core-drilled holes not less than 8 inches deep and 3/4 inch larger than OD of sleeve. Fill annular space around internal sleeves solidly with nonshrink grout; mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward internal sleeve.
- E. Place removable bollards over internal sleeves and secure with 3/4-inch machine bolts and nuts. After tightening nuts, drill holes in bolts for inserting padlocks. Owner furnishes padlocks.
- F. Fill bollards solidly with concrete, mounding top surface to shed water.
 1. Do not fill removable bollards with concrete.

3.4 INSTALLING NOSINGS, TREADS, AND THRESHOLDS

- A. Center nosings on tread widths unless otherwise indicated.
- B. For nosings embedded in concrete steps or curbs, align nosings flush with riser faces and level with tread surfaces.
- C. Seal thresholds exposed to exterior with elastomeric sealant complying with Section 07 92 00 - Joint Sealants to provide a watertight installation.

3.5 INSTALLING 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 nonshrink grout. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.6 ADJUSTING AND CLEANING

- A. Touchup 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 dry film thickness.
- B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified.
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 05 50 00

SECTION 05 51 19 - METAL GRATING STAIRS

PART 1 - GENERAL

1.1 SUMMARY

- A. Section includes industrial-type, straight-run stairs with aluminum-grating treads and railings attached to aluminum grating stairs.
- B. Related Requirements
 - 1. Section 05 52 13 – Pipe and Tube Railings

1.2 COORDINATION

- A. Coordinate installation of anchorages for metal stairs. 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.
- B. Coordinate pipes and other various mechanical devices that may conflict with the structural stairway. Modify stair structure to accommodate and approve modifications with the Engineer.

1.3 ACTION SUBMITTALS

- A. Product Data: For metal grating stairs
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments.
- C. Delegated-Design Submittal: For stairs, including analysis data signed and sealed by the qualified professional Engineer responsible for their preparation.

1.4 QUALITY ASSURANCE

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

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional Engineer, as defined in Section 01 40 00 - Quality Requirements, to design stairs and railings.

- B. Structural Performance of Stairs: Metal stairs shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Uniform Load: 100 lbf/sq. ft.
 - 2. Concentrated Load: 300 lbf applied on an area of 4 sq. in.
 - 3. Uniform and concentrated loads need not be assumed to act concurrently.
 - 4. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
 - 5. Limit deflection of treads, platforms, and framing members to L/360.

2.2 METALS

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces unless otherwise indicated. For components exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.
- B. Aluminum Plates, Shapes, and Bars: ASTM A 429, Alloy 6063-T5.
- C. Corrugated Nosings: Extruded aluminum, with an integral corrugated non-slip finish.

2.3 FASTENERS

- A. General: Provide type 316 stainless steel fasteners with coating complying with ASTM F 593. Select fasteners for type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon-head bolts, ASTM F 593; with hex nuts, ASTM F 594; and, where indicated, flat washers.
- C. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors 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 according to ASTM E 488, conducted by a qualified independent testing agency.
 - 1. Alloy Group 1 (A1) stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.4 MISCELLANEOUS MATERIALS

- A. Bituminous Paint: Cold applied asphalt emulsion complying with ASTM D1187.
- B. 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.

2.5 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.

1. Join components by welding unless otherwise indicated.
 2. Use connections that maintain structural value of joined pieces.
- B. Form exposed work with accurate angles and surfaces and straight edges.
- C. Weld connections 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. Weld exposed corners and seams continuously unless otherwise indicated.
 5. At exposed connections, finish exposed welds to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 4 welds: good quality, uniform undressed weld with minimal splatter.
- D. Fabricate joints that are exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

2.6 ALUMINUM-FRAMED STAIRS

- A. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," Industrial Class, unless more stringent requirements are indicated.
- B. Stair Framing:
1. Fabricate stringers of structural aluminum channels.
 - a. Provide closures for exposed ends of channel stringers.
 2. Construct platforms of aluminum channel headers and miscellaneous framing members as needed to comply with performance requirements.
 3. Weld or bolt stringers to headers; weld or bolt framing members to stringers and headers.
- C. Metal Bar-Grating Stairs: Form treads and platforms to configurations shown from metal bar grating; fabricate to comply with NAAMM MBG 531, "Metal Bar Grating Manual."
1. Fabricate treads and platforms from pressure-locked aluminum grating with 1-1/4-by-3/16-inch bearing bars at 15/16 inch o.c. and crossbars at 4 inches o.c.
 2. Fabricate treads and platforms from pressure-locked steel grating with openings in gratings no more than 1/2 inch in least dimension.
 3. Surface: Serrated.
 4. Finish: Mill finish.
 5. Fabricate grating treads with non-slip nosing and with aluminum angle or aluminum plate carrier at each end for stringer connections. Secure treads to stringers with bolts.
 6. Fabricate grating platforms with nosing matching that on grating treads. Provide toeplates at open-sided edges of grating platforms. Mechanically attach grating to platform framing.

2.7 STAIR RAILINGS

- A. Comply with applicable requirements in Section 05 52 13 - Pipe and Tube Railings.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.

3.2 INSTALLING METAL STAIRS WITH GROUTED BASEPLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of baseplates.
- B. Set steel-stair baseplates on wedges, shims, or leveling nuts. After stairs have been positioned and aligned, 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 nonmetallic, nonshrink grout unless otherwise indicated.
 - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

END OF SECTION 05 51 19

SECTION 05 52 13 - PIPE AND TUBE RAILINGS

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:

1. Aluminum pipe and tube railings.

- B.** This section shall be used for areas where stairs and handrail are congruent. For all other handrail, refer to Section 05 40 00 - Aluminum Handrail.

1.2 RELATED DOCUMENTS

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

B. Related Requirements:

1. Section 05 50 00 - Metal Fabrications
2. Section 05 51 19 - Metal Grating Stairs

1.3 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 for railings. 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.
- C.** Schedule installation so wall attachments are made only to completed walls. Do not support railings temporarily by any means that do not satisfy structural performance requirements.
- D.** Coordinate railings with gate and valve operators, as well as electrical components.

1.4 ACTION SUBMITTALS

A. Product Data: For the following:

1. Manufacturer's product lines of mechanically connected railings.
2. Railing brackets.
3. Grout, anchoring cement, and paint products.

- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
- C. Samples: For each type of exposed finish required.
 - 1. Sections of each distinctly different linear railing member, including handrails, top rails, and posts.
 - 2. Fittings and brackets.
- D. Delegated-Design Submittal: For railings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For testing agency.
- B. Welding certificates.
- C. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.
- D. Evaluation Reports: For post-installed anchors, from ICC-ES.

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1, "Structural Welding Code - Steel."
 - 2. AWS D1.2, "Structural Welding Code - Aluminum."
 - 3. AWS D1.6, "Structural Welding Code - Stainless Steel."

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.

1.8 FIELD CONDITIONS

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

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Aluminum Pipe and Tube Railings:

1. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to the following:
 - a. ATR Technologies, Inc.
 - b. Thompson Fabricating, LLC.
 - c. Tubular Specialties Manufacturing, Inc.
 - d. Or Equal
- B. Source Limitations: Obtain each type of railing from single source from single manufacturer.

2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 01 40 00 - Quality Requirements, to design railings, including attachment to building or structural construction.
- B. Structural Performance: Railings, including attachment to building construction, shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 1. Uniform horizontal load of 50 lbf/ft applied in any direction to the top rail
 2. Concentrated load of 200 lbf applied in any direction
- C. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes.
 1. Temperature Change: 120 °F, ambient; 180 °F.

2.3 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth surfaces, without seam marks, roller marks, rolled trade names, stains, discolorations, or blemishes.
- B. Brackets, Flanges, and Anchors: Cast or formed metal of same type of material and finish as supported rails unless otherwise indicated.
 1. Provide type of bracket with flange tapped for concealed anchorage to threaded hanger bolt and that provides 1-1/2-inch clearance from inside face of handrail to finished wall surface.

2.4 ALUMINUM

- A. Aluminum, General: Provide alloy and temper recommended by aluminum producer and finisher for type of use and finish indicated, and with not less than the strength and durability properties of alloy and temper designated below for each aluminum form required.
- B. Extruded Bars and Tubing: ASTM B 221, Alloy 6063-T5/T52.
- C. Extruded Structural Pipe and Round Tubing: ASTM B 429, Alloy 6063-T6.

1. Provide Standard Weight (Schedule 40) pipe unless otherwise indicated.
- D. Drawn Seamless Tubing: ASTM B 210, Alloy 6063-T832.
- E. Plate and Sheet: ASTM B 209, Alloy 6061-T6.
- F. Die and Hand Forgings: ASTM B 247, Alloy 6061-T6.
- G. Castings: ASTM B 26, Alloy A356.0-T6.

2.5 FASTENERS

- A. General: Provide the following:
 1. Aluminum Railings: Type 316 stainless-steel fasteners.
 2. Provide exposed fasteners with finish matching appearance, including color and texture, of railings.
- B. Fasteners for Anchoring Railings to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated and capable of withstanding design loads.
- C. Fasteners for Interconnecting Railing Components:
 1. Provide concealed fasteners for interconnecting railing components and for attaching them to other work, unless exposed fasteners are unavoidable or are the standard fastening method for railings indicated.
 2. Provide Phillips OR square or hex socket flat-head machine screws for exposed fasteners unless otherwise indicated.
- D. Post-Installed Anchors: Torque-controlled expansion anchors capable of sustaining, without failure, a load equal to 6 times the load imposed when installed in unit masonry and 4 times the load imposed when installed in concrete, as determined by testing according to ASTM E 488, conducted by a qualified independent testing agency.
 1. Material for Interior Locations: Carbon-steel components zinc-plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 2. Material for Exterior Locations and Where Stainless Steel Is Indicated: Alloy Group 2 stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.6 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
 1. For aluminum railings, provide type and alloy as recommended by producer of metal to be welded and as required for color match, strength, and compatibility in fabricated items.

- B. 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.
- C. Anchoring Cement: Factory-packaged, nonshrink, nonstaining, hydraulic-controlled expansion cement formulation for mixing with water at Project site to create pourable anchoring, patching, and grouting compound.
 - 1. Water-Resistant Product: At exterior locations provide formulation that is resistant to erosion from water exposure without needing protection by a sealer or waterproof coating and that is recommended by manufacturer for exterior use.

2.7 FABRICATION

- A. General: Fabricate railings to comply with requirements indicated for design, dimensions, member sizes and spacing, details, finish, and anchorage, but not less than that required to support structural loads.
- B. Shop assemble railings to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation. Use connections that maintain structural value of joined pieces.
- C. 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.
- D. Form work true to line and level with accurate angles and surfaces.
- E. Fabricate connections that are exposed to weather in a manner that excludes water. Provide weep holes where water may accumulate.
- F. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.
- G. Connections: Fabricate railings with either welded or nonwelded connections unless otherwise indicated.
- H. Welded Connections for Aluminum Pipe: Fabricate railings to interconnect members with concealed internal welds that eliminate surface grinding, using manufacturer's standard system of sleeve and socket fittings.
- I. Nonwelded Connections: Connect members with concealed mechanical fasteners and fittings. Fabricate members and fittings to produce flush, smooth, rigid, hairline joints.
- J. Form Changes in Direction as Follows:
 - 1. As detailed.
 - 2. By flush bends or by inserting prefabricated flush-elbow fittings.

- K. Close exposed ends of railing members with prefabricated end fittings.
- L. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated. Close ends of returns unless clearance between end of rail and wall is 1/4 inch or less.
- M. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work unless otherwise indicated.
- N. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work. Fabricate anchorage devices capable of withstanding loads imposed by railings. Coordinate anchorage devices with supporting structure.
- O. For railing posts set in concrete, provide stainless-steel sleeves not less than 6 inches long with inside dimensions not less than 1/2 inch greater than outside dimensions of post, with metal plate forming bottom closure.
- P. For removable railing posts, fabricate slip-fit sockets from stainless-steel tube or pipe whose ID is sized for a close fit with posts; limit movement of post without lateral load, measured at top, to not more than 1/40th of post height. Provide socket covers designed and fabricated to resist being dislodged.
 - 1. Provide chain with eye, snap hook, and staple across gaps formed by removable railing sections at locations indicated. Fabricate from same metal as railings.
- Q. Toe Boards: Where indicated or required by OSHA, provide toe boards at railings around openings and at edge of open-sided floors and platforms. Fabricate to dimensions and details indicated.

2.8 ALUMINUM FINISHES

- A. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are unacceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.
- B. Clear Anodic Finish: AAMA 611, AA-M12C22A31.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine plaster and gypsum board assemblies, where reinforced to receive anchors, to verify that locations of concealed reinforcements are clearly marked for Installer. Locate reinforcements and mark locations if not already done.

3.2 INSTALLATION, GENERAL

- A. Fit exposed connections together to form tight, hairline joints.
- B. Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.
 - 1. Do not weld, cut, or abrade surfaces of railing components that are coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
 - 2. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
 - 3. Align rails so variations from level for horizontal members and variations from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.
- C. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.
 - 1. Coat, with a heavy coat of bituminous paint, concealed surfaces of aluminum that are in contact with grout, concrete, masonry, wood, or dissimilar metals.
- D. Adjust railings before anchoring to ensure matching alignment at abutting joints.
- E. Fastening to In-Place Construction: Use anchorage devices and fasteners where necessary for securing railings and for properly transferring loads to in-place construction.

3.3 RAILING CONNECTIONS

- A. Nonwelded Connections: Use mechanical or adhesive joints for permanently connecting railing components. Seal recessed holes of exposed locking screws using plastic cement filler colored to match finish of railings.
- B. Expansion Joints: Install expansion joints at locations indicated but not farther apart than required to accommodate thermal movement. Provide slip-joint internal sleeve extending 2 inches beyond joint on either side, fasten internal sleeve securely to one side, and locate joint within 6 inches of post.

3.4 ANCHORING POSTS

- A. Use metal sleeves preset and anchored into concrete for installing posts. After posts are inserted into sleeves, fill annular space between post and sleeve with nonshrink, nonmetallic grout or anchoring cement, mixed and placed to comply with anchoring material manufacturer's written instructions.
- B. Cover anchorage joint with flange of same metal as post, attached to post with set screws.
- C. Leave anchorage joint exposed with anchoring material flush with adjacent surface.
- D. Anchor posts to metal surfaces with oval flanges, angle type, or floor type as required by conditions, connected to posts and to metal supporting members as follows:

1. For aluminum pipe railings, attach posts using fittings designed and engineered for this purpose.
- E. Install removable railing sections, where indicated, in slip-fit metal sockets cast in concrete.

3.5 ATTACHING RAILINGS

- A. Secure wall brackets and railing end flanges to building construction as follows:
 1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 2. For hollow masonry anchorage, use toggle bolts.
 3. For wood stud partitions, use hanger or lag bolts set into studs or wood backing between studs. Coordinate with carpentry work to locate backing members.
 4. For steel-framed partitions, use toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.

3.6 ADJUSTING AND CLEANING

- A. Clean aluminum by washing thoroughly with clean water and soap and rinsing with clean water.

3.7 PROTECTION

- A. Protect finishes of railings from damage during construction period with temporary protective coverings approved by railing manufacturer. Remove protective coverings at time of Substantial Completion.

END OF SECTION 05 52 13

SECTION 05 53 13 - BAR GRATINGS

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 metal bar gratings and metal frames and supports for gratings.
- B. Related Requirements:
 - 1. Section 05 52 13 - Pipe and Tube Railings for metal pipe and tube handrails and railings.
 - 2. Section 05 51 19 - Metal Grating Stairs

1.3 COORDINATION

- A. Coordinate installation of anchorages for gratings, grating frames, and supports. 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. Clips and anchorage devices for gratings.
 - 2. Paint products.
- B. Shop Drawings: Include plans, sections, details, and attachments to other work.
- C. Delegated-Design Submittal: For gratings, including manufacturers' published load tables.

1.5 INFORMATIONAL SUBMITTALS

- A. Mill Certificates: Signed by manufacturers of stainless steel certifying that products furnished comply with requirements.
- B. Welding certificates.

1.6 QUALITY ASSURANCE

A. 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."
3. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."
4. AWS D1.6/D1.6M, "Structural Welding Code - Stainless Steel."

1.7 FIELD CONDITIONS

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

PART 2 - PRODUCTS

2.1 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to the following:

1. Alabama Metal Industries Company; a Gibraltar Industries company.
2. All American Grating.
3. Harsco Industrial IKG, a division of Harsco Corporation.
4. Ohio Gratings, Inc.
5. Or Approved Equivalent

2.2 PERFORMANCE REQUIREMENTS

A. Structural Performance: Gratings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:

1. Floors: Uniform load of 150 lbf/sq. ft. or concentrated load of 2000 lbf, whichever produces the greater stress.
2. Walkways and Elevated Platforms Used as Exits: Uniform load of 125 lbf/sq. ft.
3. Heavy Equipment Room Floors: 300 lbf/sq. ft. or concentrated load of 3000 lbf, whichever produces the greater stress.
4. Electrical Room Floors: 250 lbf/sq. ft. or concentrated load of 2500 lbf, whichever produces the greater stress.
5. Limit deflection to L/360 or 1/4 inch, whichever is less.

B. Seismic Performance: Gratings shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.

1. Component Importance Factor: 1.5.

2.3 METAL BAR GRATINGS

- A. Metal Bar Grating Standards: Comply with NAAMM MBG 531, "Metal Bar Grating Manual."
- B. Pressure-Locked, Rectangular-Bar Aluminum Grating: Fabricated by pressing rectangular flush-top crossbars into slotted bearing bars or swaging crossbars between bearing bars.
 - 1. Bearing Bar Spacing: 1-3/16 inch o.c. (max)
 - 2. Bearing Bar Depth: As required to comply with structural performance requirements.
 - 3. Bearing Bar Thickness: As required to comply with structural performance requirements.
 - 4. Crossbar Spacing: 4 inches o.c.
 - 5. Traffic Surface: Plain.
 - 6. Aluminum Finish: Mill Finish.

2.4 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Steel Bars for Bar Gratings: ASTM A 36/A 36M or steel strip, ASTM A 1011/A 1011M or ASTM A 1018/A 1018M.
- C. Wire Rod for Bar Grating Crossbars: ASTM A 510.
- D. Uncoated Steel Sheet: ASTM A 1011/A 1011M, structural steel, Grade 30.
- E. Galvanized-Steel Sheet: ASTM A 653/A 653M, structural quality, Grade 33, with G90 coating.
- F. Stainless-Steel Sheet, Strip, Plate, and Flat Bars: ASTM A 240/A 240M, Type 316L.
- G. Stainless-Steel Bars and Shapes: ASTM A 276, Type 316L.

2.5 ALUMINUM

- A. General: Provide alloy and temper recommended by aluminum producer for type of use indicated, with not less than the strength and durability properties of alloy, and temper designated below for each aluminum form required.
- B. Extruded Bars and Shapes: ASTM B 221, alloys as follows:
 - 1. 6061-T6 or 6063-T6, for bearing bars of gratings and shapes.
 - 2. 6061-T1, for grating crossbars.
- C. Aluminum Sheet: ASTM B 209, Alloy 5052-H32.

2.6 FASTENERS

- A. General: Unless otherwise indicated, provide Type 316 stainless-steel fasteners for exterior use. Select fasteners for type, grade, and class required.

1. Provide stainless-steel fasteners for fastening aluminum.
 2. Provide stainless-steel fasteners for fastening stainless steel.
- B. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, nuts, and, where indicated, flat washers; ASTM F 593 for bolts and ASTM F 594 for nuts, Alloy Group 2.
- C. Post-Installed Anchors: Torque-controlled expansion anchors 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 according to ASTM E 488/E 488M, conducted by a qualified independent testing agency.
1. Material for All Locations and Where Stainless Steel Is Indicated: Alloy Group 2 stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.7 FABRICATION

- A. Shop Assembly: Fabricate grating sections 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.
- B. Cut, drill, and punch material 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 from materials of size, thickness, and shapes indicated, but not less than that needed to support indicated loads.
- D. Fit exposed connections accurately together to form hairline joints.
- E. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space the anchoring devices to secure gratings, frames, and supports rigidly in place and to support indicated loads.
1. Fabricate toeplates for attaching in the field.
 2. Toeplate Height: 4 inches unless otherwise indicated.
- F. Removable Grating Sections: Fabricate with banding bars attached by welding to entire perimeter of each section. Include anchors and fasteners of type indicated or, if not indicated, as recommended by manufacturer for attaching to supports.
1. Provide no fewer than four weld lugs for each heavy-duty grating section, with each lug shop welded to two bearing bars.
 2. Provide no fewer than four saddle clips for each grating section containing rectangular bearing bars 3/16 inch or less in thickness and spaced 15/16 inch or more o.c., with each clip designed and fabricated to fit over two bearing bars.
 3. Provide no fewer than four weld lugs for each grating section containing rectangular bearing bars 3/16 inch or less in thickness and spaced less than 15/16 inch o.c., with each lug shop welded to three or more bearing bars. Interrupt intermediate bearing bars as necessary for fasteners securing grating to supports.

4. Provide no fewer than four flange blocks for each section of aluminum I-bar grating, with block designed to fit over lower flange of I-shaped bearing bars.
 5. Furnish stainless steel flange clamp with galvanized bolt for securing grating to supports. Furnish as a system designed to be installed from above grating by one person.
- G. Fabricate cutouts in grating sections for penetrations indicated. Arrange cutouts to permit grating removal without disturbing items penetrating gratings.
1. Edge-band openings in grating that interrupt four or more bearing bars with bars of same size and material as bearing bars.
- H. Do not notch bearing bars at supports to maintain elevation.

2.8 GRATING FRAMES AND SUPPORTS

- A. Aluminum or stainless-steel frames and supports in the following locations:
1. Exterior.
 2. Interior.

2.9 ALUMINUM FINISHES

- A. Clear Anodic Finish: AAMA 611, AA-M12C22A41, Class I.
- B. The portion of aluminum frames in contact with concrete shall have a bitumastic coating for protection.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing gratings to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing gratings. Set units accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.
- C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete or masonry.
- D. Fit exposed connections accurately together to form hairline joints.
- E. Attach toeplates to gratings by welding at locations indicated.
- F. Field Welding: Comply with AWS recommendations and 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.

- G. 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.

3.2 INSTALLING METAL BAR GRATINGS

- A. General: Install gratings to comply with recommendations of referenced metal bar grating standards that apply to grating types and bar sizes indicated, including installation clearances and standard anchoring details.
- B. Attach removable units to supporting members with type and size of clips and fasteners indicated or, if not indicated, as recommended by grating manufacturer for type of installation conditions shown.
- C. Attach nonremovable units to supporting members by welding where both materials are same; otherwise, fasten by bolting as indicated above.

3.3 ADJUSTING AND CLEANING

- A. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780/A 780M.

END OF SECTION 05 53 13

SECTION 05 60 00 – ALUMINUM HATCHES

PART 1 - GENERAL

1.1 SUMMARY

- A. This Section includes:
 - 1. Aluminum hatches

1.2 RELATED DOCUMENTS

- A. Related work specified elsewhere includes:
 - 1. Section 05 50 00 – Metal Fabrications

1.3 SUBMITTALS

- A. Contractor shall submit to the Engineer for approval:
 - 1. Shop drawings.
 - 2. Product data including load information.
 - 3. Warranties

PART 2 - PRODUCTS

2.1 DRIP PROOF HATCH

- A. Manufacturers
 - 1. Thompson Fabricating Company; Birmingham, AL
 - 2. Or Approved Equal
- B. Floor access doors shall be drip-proof type. Door leaf shall be ¼” aluminum checkered plate reinforced with structural aluminum channels and shall be capable of withstanding a 300 pound/s.f. uniform load with minimal deflection. (Calculations shall be provided to the Engineer upon request.) The following items shall be type 316 stainless steel: slam locks, brackets, hinges and hardware. The door shall have a 316 stainless steel gas spring with integral hold open device which will assist in opening the door and shall lock automatically in the open position. The door shall open a minimum of 90 degrees. The aluminum gutter frame shall be provided with a 1 ½” threaded drain fitting and shall have a thickness not less than ¼” and shall incorporate a neoprene gasket that will reduce air leakage to less than 1 CFM per linear foot of frame when the interior of the hatch is subjected to a 2 inch water column vacuum. All fasteners which penetrate into the “Dry” area of the hatch shall be sealed with “O” Ring Seals to prevent incidental water and gas

leakage. The portion of the frame which is in contact with the concrete shall receive a protective bituminous coating.

- C. All double leaf access doors shall have two interconnected slam locks which latch at both ends of the plate and can be un-latched from a single point. "Watertight" for standard single leaf doors shall be for a 1" to 2" head of water.
- D. Hatches shall be provided with a fall protection system.

2.2 TRAFFIC LOAD HATCH

A. Manufacturers

- 1. Thompson Fabricating Company; Birmingham, AL
- 2. Or Approved Equal

- B. Floor access doors shall be type "TH-H20" (gutterless) or "THG-H20" (gutter type) (WATERTIGHT, ODORTIGHT and GASTIGHT) as manufactured by Thompson Fabricating Company, Birmingham, AL. Door leaf shall be 1/4" aluminum checkered plate reinforced with structural aluminum channels and shall be capable of withstanding wheel loads up to AASHTO-H20 at OFF-STREET locations only. (Calculations will be provided to the engineer upon request.) The following items shall be type 316 stainless steel: slam locks, brackets, hinges and hardware. The door shall have a 316 stainless steel gas spring with integral hold open device which will assist in opening the door and shall lock automatically in the open position. The door shall open a minimum of 90 degrees. The aluminum extruded frame shall have a thickness not less than 1/4" and shall incorporate a neoprene gasket that will reduce air leakage to less than 1 CFM per lineal foot of frame when the interior of the hatch is subjected to a 2 inch water column vacuum. For type "THG" doors the gutter frames shall be provided with a 1 1/2" threaded drain coupling. All fasteners which penetrate into the "Dry" area of the hatch shall be sealed with "O" Ring Seals to prevent incidental water and gas leakage. The portion of the frame which is in contact with the concrete shall receive a protective bituminous coating.
- C. All double leaf access doors shall have two interconnected slam locks with latch at both ends of the plate and can be un-latched from a single point. "Watertight" for single leaf H20 doors shall be for a 1" to 2" head of water.

PART 3 - EXECUTION

3.1 INSTALLATION

- A. Install where shown on the drawings according to manufactures recommendations.

END OF SECTION 05 60 00