# PART 1 - GENERAL

## 1.1 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 and 01 Specification Sections, apply to this Section.

## 1.2 SUMMARY

A. Section Includes:
   1. Preassembled steel stairs with concrete-filled treads.

B. Related Sections:
   1. Section 018113 Section “Sustainable Design Requirements.”
   2. Section 033000 "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
   3. Section 051200 "Structural Steel Framing" for additional requirements applicable to the stair framing.
   4. Section 055213 "Pipe and Tube Railings" for pipe and tube railings.
   5. Section 093000 “Tiling” for stair tread and landing finishes.

## 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 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.

C. Coordinate locations of hanger rods and struts with other work so that they do not encroach on required stair width and are within the fire-resistance-rated stair enclosure.

## 1.4 ACTION SUBMITTALS

A. Product Data: For metal pan stairs and the following:
   1. Prefilled metal-pan-stair treads.
   2. Paint products.

B. LEED Submittals: Credits MRc4, MRc5 and EQc4.2. Refer to Section 018113 "Sustainable Design Requirements" for additional submittal requirements.

C. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

D. Samples for Verification: For each type and finish of slip-resistant nosing and tread.

E. Delegated-Design Submittal: For stairs, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

A. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.6 QUALITY ASSURANCE

A. Installer Qualifications: Fabricator of products.

B. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," for class of stair designated, unless more stringent requirements are indicated.
   1. Ornamental Stairs: Architectural class.

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

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design stairs. Design metal stairs, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated on Structural Drawings. The design shall comply with the 2013 California Building Code.

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 live load deflection of treads, platforms, and framing members to L/360 or 3/4 inch, whichever is less. Limit deflection of treads, platforms and framing members to L/720 when scheduled to receive tile flooring.

C. Seismic Performance: Metal stairs shall withstand the effects of earthquake motions determined according to the 2013 California Building Code.
   1. Component Importance Factor is 1.0.
   2. Stairs design shall allow for the inelastic deformation between floors due to seismic forces. See general notes on structural drawings for the inelastic deformation values.

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. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 25 percent.

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

D. Steel Channels: ASTM A 36/A 36M.

E. Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513.

F. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.

G. Uncoated, Cold-Rolled Steel Sheet: ASTM A 1008/A 1008M, either commercial steel, Type B, or structural steel, Grade 25 (Grade 170), unless another grade is required by design loads; exposed.

H. LEED Material Credits MRc4, MRc5 and EQc4.2. Refer to Section 018113 “Sustainable Design Requirements” for additional product requirements.

## 2.3 FASTENERS

A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 12 for exterior use, and Class Fe/Zn 5 where built into exterior walls. Select fasteners for type, grade, and class required.

B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A; with hex nuts, ASTM A 563; and, where indicated, flat washers.

C. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; and, where indicated, flat washers.
   1. Provide mechanically deposited or hot-dip, zinc-coated anchor bolts for stairs indicated to be galvanized and stairs indicated to be shop primed with zinc-rich primer.

D. LEED Material Credits MRc4, MRc5 and EQc4.2. Refer to Section 018113 “Sustainable Design Requirements” for additional product requirements.

## 2.4 FABRICATION, GENERAL

A. Provide complete stair assemblies, including metal framing, hangers, struts, 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.
   3. Fabricate treads and platforms of exterior stairs so finished walking surfaces slope to drain.

B. Preassembled Stairs: Assemble stairs in shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.

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 bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.

E. Form exposed work with accurate angles and surfaces and straight edges.

F. 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 1 welds: no evidence of a welded joint.

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

H. Fabricate joints that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

## 2.5 STEEL-FRAMED STAIRS

A. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual," Commercial Class, unless more stringent requirements are indicated.

B. Stair Framing:
   1. Fabricate stringers of steel as indicated on Drawings.
      a. Provide closures for exposed ends of channel stringers.
   2. Construct platforms of steel headers and miscellaneous framing members as needed to comply with performance requirements and as indicated.
   3. Weld stringers to headers; weld framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.
   4. Where stairs are enclosed by gypsum board assemblies, provide hanger rods or struts to support landings from floor construction above or below. Locate hanger rods and struts where they do not encroach on required stair width and are within the fire-resistance-rated stair enclosure.
   5. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.

C. Metal Pan Concrete Filled Stairs: Form risers, subtread pans, and subplatforms to configurations shown from steel sheet of thickness needed to comply with performance requirements, but not less than 0.067 inch.
   1. Steel Sheet: Uncoated cold-rolled steel sheet unless otherwise indicated.
   2. Directly weld metal pans to stringers; locate welds on top of subtreads where they are concealed by concrete fill. Do not weld risers to stringers.

3. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.

2.6 STAIR RAILINGS

A. Comply with applicable requirements in Section 055213 "Pipe and Tube Railings."
   1. Connect posts to stair framing by direct welding unless otherwise indicated.

2.7 FINISHES

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

B. Finish metal stairs after assembly.

C. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with minimum requirements indicated below for SSPC surface preparation specifications and environmental exposure conditions of installed products:
   1. Exterior Stairs: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
   2. Interior Stairs: SSPC-SP 3, "Power Tool Cleaning."

D. Apply shop primer to uncoated surfaces of metal stair components, except those with galvanized finishes and those to be embedded in concrete or masonry unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.
   1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 INSTALLING METAL PAN STAIRS

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.

C. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete unless otherwise indicated.

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

E. 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.

F. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.

G. Place and finish concrete fill for treads and platforms to comply with Section 033000 "Cast-in-Place Concrete."
   1. Install abrasive nosings with anchors fully embedded in concrete, where indicated. Center nosings on tread width.

3.2 ADJUSTING AND CLEANING

A. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop paint are specified in Section 099113 "Exterior Painting" and Section 099123 "Interior Painting."

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

END OF SECTION