# 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. This Section includes the following:
1. Support angles for elevator door sills.
2. Steel framing and supports for operable partitions.
3. Steel framing and supports for overhead doors.
4. Steel framing and supports for countertops.
5. Steel framing and supports for mechanical and electrical equipment.
6. Steel framing and supports for applications where framing and supports are not specified in other Sections.
7. Steel shapes for supporting elevator door sills and guide rails.
8. Shelf angles.
9. Slotted channel framing.
10. Metal ladders.
11. Metal ships' ladders.
12. Metal bollards.
13. Miscellaneous metal trim.
14. Bench supports.
15. Roof tiebacks.

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 Sections:
1. Section 018113 Section “Sustainable Design Requirements.”
2. Section 033000 "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.
3. Section 051200 "Structural Steel Framing."
4. Section 051213 “Architecturally Exposed Structural Steel Framing.”

## 1.3 COORDINATION

A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written 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. LEED Submittals: Credits MRc4, MRc5, and EQc4.2 (inside the weatherproofing system and applied on-site). Refer to Section 018113 "Sustainable Design Requirements" for additional submittal requirements.

C. Delegated Design: For systems listed, comply with the performance and design criteria. Submit shop drawings and calculations signed and sealed by the qualified California professional engineer responsible for their preparation.
   1. Include structural design calculations.

D. Shop Drawings: Show fabrication and installation details. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.

E. Samples for Verification: For each type and finish exposed to view.

1.5 INFORMATIONAL SUBMITTALS

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

B. Research/Evaluation Reports: For post-installed anchors, from ICC-ES.

1.6 QUALITY ASSURANCE

A. Fabricator Qualifications: A firm experienced in producing metal fabrications similar to those indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.

B. Professional Engineer Qualifications: A professional engineer licensed in the State of California and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for installation of systems indicated on Drawings.

C. 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 D1.6/D1.6M, "Structural Welding Code - Stainless Steel."

1.7 FIELD CONDITIONS

A. Field Measurements: Verify actual locations of walls and other construction contiguous with 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 014000 "Quality Requirements," to design ladders.

B. Structural Performance of Ladders: Provide ladders capable of withstanding the effects of loads and stresses within limits and under conditions specified in ANSI A14.3.

A. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.
   1. Temperature Change: 120 deg F, ambient; 180 deg 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. 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. Stainless-Steel Sheet, Strip, and Plate: ASTM A 240/A 240M or ASTM A 666, Type 304.

E. Stainless-Steel Bars and Shapes: ASTM A 276, Type 304.

F. Steel Tubing: ASTM A 500/A 500M, cold-formed steel tubing.

G. Steel Pipe: ASTM A 53/A 53M, Standard Weight (Schedule 40) unless otherwise indicated.

H. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.
   1. Size of Channels: 1-5/8 by 1-5/8 inches, uno.
   2. Material: Galvanized steel, ASTM A 653/A 653M, structural steel, Grade 33, with G90 coating; 0. 108-inch nominal thickness.

I. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

J. Aluminum Plate and Sheet: ASTM B 209, Alloy 6061-T6.

K. Aluminum Extrusions: ASTM B 221, Alloy 6063-T6.

L. Aluminum-Alloy Rolled Tread Plate: ASTM B 632/B 632M, Alloy 6061-T6.

M. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

N. LEED Material Credits MRc4 and MRc5: Refer to Section 018113 “Sustainable Design Requirements” for additional product requirements.

2.3 FASTENERS

A. General: Unless otherwise indicated, provide Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM 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.

B. LEED Material Credits MRc4 and MRc5: Refer to Section 018113 “Sustainable Design Requirements” for additional product requirements.

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

D. Steel Bolts and Nuts, Weathered(where applicable): Regular hexagon-head bolts, ASTM A 325, Type 3; with hex nuts, ASTM A 563, Grade C3; and, where indicated, flat washers.

E. 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 1 (A1).

F. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.
   1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.

G. 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/E 488M, conducted by a qualified independent testing agency.

H. Cast-in-Place Anchors in Concrete: Either threaded type or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A 47/A 47M malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F 2329.

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 Section 099113 "Exterior Painting," Section 099123 Interior Painting" and Section 099605 “Exterior High-Performance Coatings” as applicable.

B. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.

C. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

D. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187/D 1187M.

E. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107/C 1107M. Provide grout specifically recommended by manufacturer for interior and exterior applications.

F. Concrete: Comply with requirements in Section 033000 "Cast-in-Place Concrete" for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 3000 psi.

G. LEED Materials: Credit EQc4.2 (inside the weatherproofing system and applied on-site). Refer to Section 018113 "Sustainable Design Requirements" for additional product requirements.

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 true to line and level 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 where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts, unless otherwise indicated. Locate joints where least conspicuous.

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

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

I. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.

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 recommended by partition manufacturer with attached bearing plates, anchors, and braces as recommended by partition manufacturer. Drill or punch bottom flanges of beams to receive partition track hanger rods; locate holes where indicated on operable partition Shop Drawings.

D. Galvanize miscellaneous framing and supports where indicated and at all exterior locations.

E. Prime miscellaneous framing and supports with zinc-rich primer where indicated.

## 2.7 METAL LADDERS

A. General:
   1. Comply with ANSI A14.3 unless otherwise indicated.
   2. For elevator pit ladders, comply with ASME A17.1.

B. Steel Ladders:
   1. Space siderails 16 inches apart unless otherwise indicated.
   2. Space siderails of elevator pit ladders 12 inches apart.

3. Siderails: Continuous, 3/8-by-2-1/2-inch steel flat bars, with eased edges.
4. Rungs: 3/4-inch diameter steel bars.
5. Fit rungs in centerline of siderails; plug-weld and grind smooth on outer rail faces.
6. 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.
7. 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 1/2 inch in least dimension.
8. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted steel brackets.
9. Galvanize ladders, including brackets and fasteners.

C. Aluminum Ships' Ladders: Provide where indicated.
1. Space siderails 18 inches apart unless otherwise indicated.
2. Siderails: Continuous extruded-aluminum channels or tubes, not less than 2-1/2 inches deep, 3/4 inch wide, and 1/8 inch thick.
3. Rungs: Extruded-aluminum tubes, not less than 3/4 inch deep and not less than 1/8 inch thick, with ribbed tread surfaces.
4. Fit rungs in centerline of siderails; fasten by welding or with stainless-steel fasteners or brackets and aluminum rivets.
5. 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 1/2 inch in least dimension.
6. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted aluminum brackets.
7. Provide minimum 72-inch- high, hinged security door with padlock hasp at foot of ladder to prevent unauthorized ladder use.

## 2.8 METAL SHIPS' LADDERS

A. Provide metal ships' ladders 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, including railings from aluminum.
3. Fabricate treads and platforms from pressure-locked aluminum bar grating or extruded-aluminum plank grating. Limit openings in gratings to no more than 1/2 inch in least dimension.
4. Fabricate treads and platforms from rolled-aluminum-alloy tread plate.
5. Comply with applicable railing requirements in Section 055213 "Pipe and Tube Railings."

## 2.9 MISCELLANEOUS STEEL TRIM

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

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

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

C. Galvanize and prime exterior miscellaneous steel trim.

D. Prime exterior miscellaneous steel trim with zinc-rich primer.

2.10 METAL BOLLARDS

A. Fabricate metal bollards from Schedule 40 steel pipe or steel shapes, as indicated.
1. Cap bollards with 1/4-inch-thick steel plate.

B. 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.

C. Prime bollards with zinc-rich primer.

2.11 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.

2.12 LOOSE STEEL LINTELS

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

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

C. Galvanize and prime loose steel lintels located in exterior walls.

D. Prime loose steel lintels located in exterior walls with zinc-rich primer.

2.13 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.

2.14 FINISHES, GENERAL

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

B. Finish metal fabrications after assembly.

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

2.15 STEEL AND IRON FINISHES

A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M 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 3, "Power Tool Cleaning."

E. Shop Priming: Apply shop primer to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.
   1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

F. Powder-Coat Finish: Immediately after cleaning and pretreating, apply manufacturer's standard thermosetting polyester or acrylic urethane powder coating with cured-film thickness not less than 1.5 mils. Prepare, treat, and coat metal to comply with resin manufacturer's written instructions.
   1. Color and Gloss: Match Architect's sample.

G. High-Performance Coating Finish: Comply with Section 099605 "Exterior High-Performance Coatings."

2.16 ALUMINUM FINISHES

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

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

C. High-Performance Organic Storefront Finish: 3-coat fluoropolymer finish complying with AAMA 2605 and containing not less than 70 percent PVDF resin by weight in both color coat and clear topcoat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.
   1. Color and Gloss: Custom colors shall be selected by Architect.

2.17 STAINLESS-STEEL FINISHES

A. Surface Preparation: Remove tool and die marks and stretch lines, or blend into finish.

B. Polished Finishes: Grind and polish surfaces to produce uniform finish, free of cross scratches.
   1. Run grain of directional finishes with long dimension of each piece.

C. Directional Satin Finish: No. 4, unless noted otherwise.

D. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

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 operable partitions and overhead grilles 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 in concrete with pipe sleeves preset and anchored into concrete. 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.

C. Anchor internal sleeves for removable bollards in concrete by inserting in pipe sleeves preset into concrete. 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.

D. 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.

3.4 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.

3.5 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