

**SECTION 055000****MISCELLANEOUS METALS****PART 1 GENERAL****1.1 GENERAL REQUIREMENTS**

- A. Work of this Section, as shown or specified, shall be in accordance with the requirements of the Contract Documents.

**1.2 SECTION INCLUDES**

- A. Work of this Section includes all labor, materials, equipment, and services necessary to complete the miscellaneous metal work as indicated on the drawings and/or specified herein, including, but not limited to, the following:
  - 1. Rough hardware.
  - 2. Repairing existing metal-framed openings at truck door head and jambs.
  - 3. Light steel framing and supports.
  - 4. Steel framing, bracing, supports, anchors, bolts, shims, fastenings, and all other supplementary parts indicated on drawings or as required to complete each item of work of this Section.
  - 5. Prime painting, touch-up painting, galvanizing and separation of dissimilar metals for work of this Section.
  - 6. Cutting, fitting, drilling and tapping work of this Section to accommodate work of other Sections and of concrete, masonry or other materials as required for attaching and installing work of this Section.

**1.3 RELATED SECTIONS**

- A. Steel Pan Stairs - Section 055113.
- B. Painting and Finishing - Section 099100.

**1.4 QUALITY ASSURANCE**

- A. Field Measurements: Take field measurements prior to preparation of shop drawings and fabrication, where possible. Do not delay job progress; allow for trimming and fitting where taking field measurements before fabrication might delay work.
- B. Shop Assembly: Pre-assemble items in shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for re-assembly and coordinated installation.
- C. Reference Standards: The work is subject to requirements of applicable portions of the following standards:
  - 1. "Manual of Steel Construction," American Institute of Steel Construction.

2. AWS D1-1 "Structural Welding Code," American Welding Society.
3. SSPC SP-3 "Surface Preparation Specification No. 3, Power Tool Cleaning," Steel Structures Painting Council.
4. SSPC PA-1 "Painting Application Specification," Steel Structures Painting Council.
5. "Handbook on Bolt, Nut and Rivet Standards," Industrial Fasteners Institute.

## **1.5 SUBMITTALS**

- A. Manufacturer's Literature: Submit manufacturer's specifications, load tables, dimension diagrams, anchor details and installation instructions for products to be used in the fabrication of miscellaneous metal work, including paint products.
- B. Shop Drawings: Shop drawings for the fabrication and erection of all assemblies of miscellaneous iron work which are not completely shown by manufacturer's data sheets. Include plans and elevations at not less than 1" to 1'-0" scale, and include details of sections and connections at not less than 3" to 1'-0" scale. Show anchorage and accessory items.
- C. Welding shall be indicated on shop drawings using AWS symbols and showing length, size and spacing (if not continuous). Auxiliary views shall be shown to clarify all welding. Notes such as 1/4" weld, weld and tack weld are not acceptable.

## **PART 2 PRODUCTS**

### **2.1 MATERIALS**

- A. Metals
  1. Metal Surfaces, General: For fabrication of miscellaneous metal work which will be exposed to view, use only materials which are smooth and free of surface blemishes including pitting, seam marks, roller marks, rolled trade names and roughness.
  2. Steel Plates, Shapes and Bars: ASTM A 36.
  3. Steel Tubing: Cold formed, ASTM A 500; or hot rolled, ASTM A 501.
  4. Structural Steel Sheet: Hot rolled, ASTM A 570; or cold rolled, ASTM A 611, Class 1; of grade required for design loading.
  5. Galvanized Structural Steel Sheet: ASTM A 924, of grade required for design loading. Coating designation G90.
  6. Steel Pipe: ASTM A 53, type and grade as selected by fabricator and as required for design loading; black finish unless galvanizing is indicated; standard weight (Schedule 40), unless otherwise indicated.
  7. Gray Iron Castings: ASTM A 48, Class 30, unless another class is indicated or required by structural loads.
  8. Malleable Iron Castings: ASTM A 47, grade as selected by fabricator.

9. Brackets, Flanges and Anchors: Cast or formed metal of the same type material and finish as supported rails, unless otherwise indicated.
  10. Concrete Inserts: Threaded or wedge type; galvanized ferrous castings, either malleable iron, ASTM A 47, or cast steel, ASTM A 27. Provide bolts, washers and shims as required, hot-dip galvanized, ASTM A 153.
- B. Grout: Non-shrink, non-metallic grout conforming to the requirements of Section 033000.
- C. Fasteners
1. General: Provide zinc-coated fasteners for exterior use or where built into exterior walls. Select fasteners for the type, grade and class required.
  2. Bolts and Nuts: Regular hexagon head type, ASTM A 307, Grade A.
  3. Anchor Bolts: ASTM F 1554, Grade 36.
  4. Lag Bolts: ASME B18.2.1.
  5. Machine Screws: ASME B18.6.3.
  6. Plain Washers: Round, carbon steel, ASME B18.22.1.
  7. Masonry Anchorage Devices: Expansion shields, FS FF-S-325.
  8. Toggle Bolts: Tumble-wing type, FS FF-B-588, type, class and style as required.
  9. Lock Washers: Helical spring type carbon steel, ASME B18.21.1.
- D. Shop Paint: Shop prime all non-galvanized miscellaneous metal items using Series 88 Azeron Primer made by Tnemec, ICI Devco "Rust Guard" quick dry alkyd shop coat No. 41403, or "Interlac 393" by International Protection Coatings.
- E. Bituminous Paint: Cold applied asphalt emulsion complying with ASTM D 1187.
- F. Galvanizing Repair Coating: For touching up galvanized surfaces after erection, provide repair coating that is V.O.C. compliant, equal to "Silver Galv" made by Z.R.C. Worldwide or approved equal. Apply to a dry film thickness of 1.5 to 3.0 mils.

## 2.2 PRIME PAINTING

- A. Scope: All ferrous metal (except galvanized steel) shall be cleaned and shop painted with one coat of specified ferrous metal primer. No shop prime paint required on galvanized steel or aluminum work.
- B. Cleaning: Conform to Steel Structures Painting Council Surface Preparation Specification SP 3 (latest edition) "Power Tool Cleaning" for cleaning of ferrous metals which are to receive shop prime coat.
- C. Application
1. Apply shop prime coat immediately after cleaning metal. Apply paint in dry weather or under cover. Metal surfaces shall be free from frost or moisture when painted. Paint all metal surfaces including edges, joints, holes, corners, etc.

2. Paint surfaces which will be concealed after shop assembly prior to such assembly. Apply paint in accordance with approved paint manufacturer's printed instructions, and the use of any thinners, adulterants or admixtures shall be only as stated in said instructions.
  3. Paint shall uniformly and completely cover the metal surfaces, 2.0 mils minimum dry film thickness. No work shall be shipped until the shop prime coat thereon has dried.
- D. Touch-Up: In the shop, after assembly and in the field, after installation of work of this Section, touch-up damaged or abraded portions of shop prime paint with specified ferrous metal primer.
  - E. Apply one shop coat to fabricated metal items, except apply two (2) coats of paint to surfaces inaccessible after assembly or erection. Change color of second coat to distinguish it from the first.

### 2.3 GALVANIZING

- A. Scope: All ferrous metal exposed to the weather, and all ferrous metals indicated on drawings or in specifications to be galvanized, shall be cleaned and then hot-dipped galvanized after fabrication as provided by Duncan Galvanizing or approved equal.
- B. Avoid fabrication techniques that could cause distortion or embrittlement of steel items to be hot-dip galvanized. Fabricator shall consult with hot-dip galvanizer regarding potential warpage problems or handling problems during the galvanizing process that may require adjustment of fabrication techniques or design before finalizing shop drawings and beginning of fabrication.
- C. Cleaning: Thoroughly clean metal surfaces of all mill scale, rust, dirt, grease, oil, moisture and other contaminants prior to galvanizing.
- D. Application: Hot-dip galvanizing shall be applied in accordance with:
  1. ASTM A 143: Safeguarding Against Embrittlement of Hot-Dip Galvanized Structural Steel.
  2. ASTM A 123: Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products.
  3. ASTM A 153: Galvanized Coating on Iron and Steel Hardware - Table 1.
  4. ASTM A 385: Practice for Providing High Quality Zinc Coatings.
  5. ASTM A 924: Galvanized Coating on Steel Sheets.
  6. Minimum weight of galvanized coating shall be two (2) oz. per square foot of surface.
- E. Fabricate joints which will be exposed to weather in a manner to exclude water or provide weep holes where water may accumulate.
- F. All galvanized materials must be inspected for compliance with these specifications and marked with a stamp indicating the name of the galvanizer, the weight of the coating, and the appropriate ASTM number.

- G. To minimize surface imperfection (eg: flux inclusions), material to be galvanized shall be dipped into a solution of Zinc Ammonium Chloride (pre-flux) immediately prior to galvanizing. The type of galvanizing process utilizing a flux blanket overlaying the molten zinc will not be permitted.
- H. After galvanizing all materials not exposed to view must be chromated by dipping material in a 0.2% chromic acid solution.
- I. Galvanized surfaces, where exposed to view, must have a smooth, level surface finish. Where this does not occur, piece shall be rejected and replaced to the acceptance of the Commissioner.

## **2.4 PROTECTIVE COATINGS**

- A. Whenever dissimilar metals will be in contact, separate contact surfaces by coating each contact surface prior to assembly or installation with one coat of specified bituminous paint, which shall be in addition to the specified shop prime paint. Mask off those surfaces not required to receive protective coating.

## **2.5 WORKMANSHIP**

- A. General
  - 1. Miscellaneous metal work shall be fabricated by an experienced fabricator or manufacturer and installed by an experienced tradesman.
  - 2. Materials, methods of fabrication, fitting, assembly, bracing, supporting, fastening, operating devices, and erection shall be in accordance with drawings and specifications, approved shop drawings, and best practices of the industry, using new and clean materials as specified, having structural properties sufficient to safely sustain or withstand stresses and strains to which materials and assembled work will be subjected.
  - 3. All work shall be accurately and neatly fabricated, assembled and erected.
- B. Shop Assembly: Insofar as practicable, fitting and assembly of work shall be done in shop. Shop assemble work in largest practical sizes to minimize field work. It is the responsibility of the miscellaneous metal subcontractor to assure himself that the shop-fabricated miscellaneous metal items will properly fit the field condition. In the event that shop-fabricated miscellaneous metal items do not fit the field condition, the item shall be returned to the shop for correction.
- C. Cutting: Cut metal by sawing, shearing, or blanking. Flame cutting will be permitted only if cut edges are ground back to clean, smooth edges. Make cuts accurate, clean, sharp and free of burrs, without deforming adjacent surfaces or metals.
- D. Holes: Drill or cleanly punch holes; do not burn.
- E. Connections: Make connections with tight joints, capable of developing full strength of member, flush unless indicated otherwise, formed to exclude water where exposed to weather. Locate joints where least conspicuous. Unless indicated otherwise, weld or bolt shop connections; bolt or screw field connections. Provide expansion and contraction joints to allow for thermal movement of metal at locations and by methods approved by Commissioner.

1. Welding
  - a. Shall be in accordance with "Standard Code for Welding in Building Construction" of the American Welding Society, and shall be done with electrodes and/or methods recommended by the manufacturer of the metals being welded.
  - b. Welds shall be continuous, except where spot welding is specifically permitted. Welds exposed to view shall be ground flush and dressed smooth with and to match finish of adjoining surfaces; undercut metal edges where welds are required to be flush.
  - c. All welds on or behind surfaces which will be exposed to view shall be done so as to prevent distortion of finished surface. Remove weld spatter and welding oxides from all welded surfaces.
2. Bolts and Screws: Make threaded connections tight with threads entirely concealed. Use lock nuts. Bolts and screw heads exposed to view shall be flat and countersunk. Cut off projecting ends of exposed bolts and screws flush with nuts or adjacent metal.
- F. Operating Mechanism: Operating devices (i.e. pivots, hinges, etc.) mechanism and hardware used in connection with this work shall be fabricated, assembled, installed and adjusted after installation so that they will operate smoothly, freely, noiselessly and without excessive friction.
- G. Built-In Work: Furnish anchor bolts, inserts, plates and any other anchorage devices, and all other items specified under this Section of the Specifications to be built into concrete, masonry or work of other trades, with necessary templates and instructions, and in ample time to facilitate proper placing and installation.
- H. Supplementary Parts: Provide as necessary to complete each item of work, even though such supplementary parts are not shown or specified.
- I. Coordination: Accurately cut, fit, drill and tap work of this Section to accommodate and fit work of other trades. Furnish or obtain, as applicable, templates and drawings to or from applicable trades for proper coordination of this work.
- J. Exposed Work
  1. In addition to requirements specified herein and shown on drawings, all surfaces exposed to view shall be clean and free from dirt, stains, grease, scratches, distortions, waves, dents, buckles, tool marks, burrs, and other defects which mar appearance of finished work.
  2. Metal work exposed to view shall be straight and true to line or curve, smooth arrises and angles as sharp as practicable, miters formed in true alignment, profiles accurately intersecting, and with joints carefully matched to produce continuity of line and design.
  3. Exposed fastenings, where permitted, shall be of the same material, color and finish as the metal to which applied, unless otherwise indicated, and shall be of the smallest practicable size.
- K. Preparation for Hot-Dip Galvanizing: Fabricator shall correctly prepare assemblies for galvanizing in consultation with galvanizer and in accordance with applicable Reference Standards and applicable AGA publications for the "Design of Products to be Hot-Dip

galvanized After Fabrication." Preparation shall include but not be limited to the following:

1. Remove welding flux.
2. Drill appropriate vent holes and provide for drainage in inconspicuous locations of hollow sections and semi-enclosed elements. After galvanizing, plug vent holes with shaped lead and grind smooth.

## **2.6 MISCELLANEOUS METALS ITEMS**

### **A. Rough Hardware**

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

### **B. Miscellaneous Steel Framing**

1. Steel framing, bracing, supports, framing, clip angles, shelf angles, plates, etc., shall be of such shapes and sizes as indicated on the drawings and details or as required to suit the condition and shall be provided with all necessary supports and reinforcing such as hangers, braces, struts, clip angles, anchors, bolts, nuts, welds, etc., as required to properly support and rigidly fasten and anchor same in place and to steel, concrete, masonry and all other connecting and adjoining work.
2. All light steel framing steel shall be furnished and erected in accordance with the applicable requirements of the "Specifications for the Design, Fabrication and Erection of Structural Steel for Buildings" by the American Institute of Steel Construction and as specified herein.

## **PART 3 EXECUTION**

### **3.1 INSPECTION**

- A. Examine the areas and conditions where miscellaneous metal is to be installed and correct any conditions detrimental to the proper and timely completion of the work. Do not proceed with the work until unsatisfactory conditions are corrected to permit proper installation of the work.

### **3.2 ERECTION**

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing miscellaneous metal fabrications to in-place construction; including threaded fasteners for concrete and masonry inserts, toggle bolts, through-bolts, lag bolts, wood screws, and other connectors as required.
- B. Cutting, Fitting and Placement: Perform cutting, drilling and fitting required for installation of miscellaneous metal fabrications. Set work accurately in location, alignment and elevation, plumb, level, true and free of rack, measured from established

lines and levels. Provide temporary bracing or anchors in formwork for items which are to be built into concrete, masonry, or similar construction.

- C. Fitting Connections: Fit exposed connections accurately together to form tight hairline joints. Weld connections which are not to be left as exposed joints, but cannot be shop welded because of shipping size limitations. Grind exposed joints smooth and touch up shop paint coat. Do not weld, cut or abrade the surfaces of exterior units which have been hot dip galvanized after fabrication, and are intended for bolted or screwed field connections.
- D. Field Welding: Comply with AWS Code for procedures of manual shielded metal-arc welding, appearance, and quality of welds made, and methods used in correcting welding work.
- E. Touch-Up Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting. Apply by brush or spray to provide a minimum dry film thickness of 2.0 mils.
- F. Field Touch-Up of Galvanized Surfaces: Touch-up shop applied galvanized coatings damaged during handling and installation. Use galvanizing repair coating specified herein for galvanized surfaces.

**END OF SECTION**