

SECTION 05510 - METAL STAIRS

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. This Section includes the following:
 - 1. Preassembled steel stairs with concrete-filled treads.
 - 2. Industrial-type stairs with steel floor plate and/or grating treads.
 - 3. Ornamental steel-framed stairs.
 - 4. Steel tube railings attached to metal stairs.
 - 5. Steel tube handrails attached to walls adjacent to metal stairs.
 - 6. Railing gates at the level of exit discharge.
- B. Related Requirements:
 - 1. Section 01 45 33 – Structural Testing and Special Inspections.
 - 2. Section 03 30 00 – Cast-In-Place Concrete.
 - 3. Section 05 50 00 – Metal Fabrications: For metal treads and nosings not installed in metal stairs and miscellaneous steel fabrications.
 - 4. Section 09 90 00 – Painting.
 - 5. Section 09 96 00 – High Performance Coatings.
 - 6. Division 05 Section "Pipe and Tube Railings" for pipe and tube railings.
 - 7. Division 06 Section Rough Carpentry for wood blocking for anchoring railings.
 - 8. Division 10 Section "Wire Mesh Partitions" for wire mesh security partitions and doors.

1.3 REFERENCES

- A. NAAMM Stair Standards

1.4 PERFORMANCE REQUIREMENTS

- A. Structural Performance of Stairs: Provide metal stairs capable of withstanding the effects of gravity loads and the following non-reducible 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/240 or 1/2 inch, whichever is less.
- B. Structural Performance of Railings: Provide railings capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
 - 1. Handrails:
 - a. Uniform load of 50 lbf/ ft. applied in any direction.
 - b. Concentrated load of 200 lbf applied in any direction.
 - c. Uniform and concentrated loads need not be assumed to act concurrently.
 - 2. Top Rails of Guards:
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- b. Concentrated load of 200 lbf applied in any direction.
- c. Uniform and concentrated loads need not be assumed to act concurrently.
- 3. Infill of Guards:
 - a. Concentrated load of 200 lbf applied horizontally on an area of 1 sq. ft..
 - b. Uniform load of 25 lbf/sq. ft. applied horizontally.
 - c. Infill load and other loads need not be assumed to act concurrently.

1.5 ACTION SUBMITTALS

- A. Product Data: For metal stairs and the following:
 - 1. Prefilled metal-pan stair treads.
 - 2. Precast concrete treads.
 - 3. Epoxy-resin-filled stair treads.
 - 4. Nonslip aggregates and nonslip-aggregate finishes.
 - 5. Abrasive nosings.
 - 6. Metal floor plate treads.
 - 7. Paint products.
 - 8. Grout.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
 - 1. Provide templates for anchors and bolts specified for installation under other Sections.
- C. Samples for Initial Selection: For products involving selection of color, texture, or design.
- D. Samples for Verification: For the following products, in manufacturer's standard sizes:
 - 1. Precast concrete treads.
 - 2. Epoxy-resin-filled stair treads.
 - 3. Stair treads with nonslip-aggregate surface finish.
 - 4. Metal floor plate treads.
 - 5. Grating treads.
 - 6. Abrasive nosings.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for stairs and railings.
 - 1. Test railings according ASTM E 894 and ASTM E 935.

1.6 INFORMATIONAL SUBMITTALS

- A. Submittal Schedule for all action submittal items.
- B. Welding certificates.
- C. Calculations: For installed products indicated to comply with design loads, include structural analysis data signed and sealed by Qualified Professional Engineer responsible for their preparation
- D. Sustainable Design Submittals:
 - 1. LEED Credit: Product Data for Credit MR 4.1 and Credit MR 4.2 if required: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content.
 - a. Include statement indicating costs for each product having recycled content.

1.7 CLOSEOUT SUBMITTALS

- A. Sustainable Design Closeout Documentation.

1.8 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. Preassembled Stairs: Commercial class.
 - 2. Industrial-Type Stairs: Industrial class.
 - 3. Ornamental Stairs: Architectural class.
- C. Welding: 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."

1.9 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 locations of hanger rods and struts with other work so that they will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. In other Part 2 articles where titles below introduce lists, the following requirements apply to product selection:
 - 1. Available Products: Subject to compliance with requirements, products that may be incorporated into the Work include, but are not limited to, products specified.
 - 2. Products: Subject to compliance with requirements, provide one of the products specified.
 - 3. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, manufacturers specified.
 - 4. Manufacturers: Subject to compliance with requirements, provide products by one of the manufacturers specified.

2.2 METALS, GENERAL

- 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.

2.3 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36
- B. Steel Tubing: ASTM A500
- C. Steel Bars for Grating Treads: ASTM A 36

- D. Wire Rod for Grating Crossbars: ASTM A 510.

2.4 FASTENERS

- A. General: Provide zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 25 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.
 - 1. Provide hot-dip or mechanically deposited, zinc-coated anchor bolts for exterior stairs and stairs indicated to be galvanized.
- D. Machine Screws: ASME B18.6.3.
- E. Lag Bolts: ASME B18.2.1.
- F. Plain Washers: Round, ASME B18.22.1.
- G. Lock Washers: Helical, spring type, ASME B18.21.1.
- H. Expansion Anchors: Anchor bolt and sleeve assembly with capability to sustain, 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. Material for Anchors in Interior Locations: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.
 - 2. Material for Anchors in Exterior Locations: Alloy Group 1 stainless-steel bolts complying with ASTM F 593 and nuts complying with ASTM F 594.

2.5 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Shop Primers: Provide primers that comply with Division 09 painting Sections.
- C. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- D. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.
- E. 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.
- F. Concrete Materials and Properties: Comply with requirements in Division 03 Section "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi, unless otherwise indicated.
- G. Nonslip-Aggregate Concrete Finish: Factory-packaged abrasive aggregate made from fused, aluminum-oxide grits or crushed emery; rustproof and nonglazing; unaffected by freezing, moisture, or cleaning materials.

- H. Welded Wire Fabric: ASTM A 185, 6 by 6 inches--W1.4 by W1.4, unless otherwise indicated.

2.6 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, struts, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
 - 1. Fabricate treads and platforms of exterior stairs so finished walking surfaces slope to drain.
- 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 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. 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 joints that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

2.7 STAIR RAILINGS

- A. Comply with applicable requirements in Division 05 Section Pipe and Tube Railings for railings

2.8 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. Galvanizing: Hot-dip galvanize items as indicated to comply with applicable standard listed below:
 - 1. ASTM A 123/A 123M, for galvanizing steel and iron products.
 - 2. ASTM A 153/A 153M, for galvanizing steel and iron hardware.
 - 3. Fill vent and drain holes that will be exposed in finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.

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.
- 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 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.
- G. Place and finish concrete fill for treads and platforms to comply with Division 03 Section "Cast-in-Place Concrete."
 - 1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.
- H. Install precast concrete treads with adhesive supplied by manufacturer.

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.

3.3 INSTALLING STEEL TUBE RAILINGS

- A. Adjust railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and rail ends to building construction as follows:

1. Anchor posts to steel by welding directly to steel supporting members.
 2. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.
- B. Attach handrails to wall with wall brackets. Provide bracket with 1-1/2-inch clearance from inside face of handrail and finished wall surface. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as follows:
1. Use type of bracket with flange tapped for concealed anchorage to threaded hanger bolt.
 2. Use type of bracket with predrilled hole for exposed bolt anchorage.
 3. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
 4. For steel-framed gypsum board assemblies, use hanger or lag bolts set into wood backing between studs. Coordinate with stud installation to locate backing members.
 5. For steel-framed gypsum board assemblies, fasten brackets directly to steel framing or concealed steel reinforcements using self-tapping screws of size and type required to support structural loads.

3.4 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with 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 in Division 09 painting Sections.
- C. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 05510