

## SECTION 055100 - 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. Section Includes:

- 1. Preassembled steel stairs with precast concrete treads and steel risers.
  - 2. Steel tube railings attached to metal stairs.
  - 3. Steel tube handrails attached to walls adjacent to metal stairs.

- B. Related Sections:

- 1. Division 05 Section "Pipe and Tube Railings" for pipe and tube railings not attached to metal stairs or to walls adjacent to metal stairs.
  - 2. Division 06 Section "Rough Carpentry" for wood blocking for anchoring railings.
  - 3. Division 09 Section "Exterior Painting" for painting steel stairs.
  - 4. Division 09 Section "Joint Sealants" for sealants.

#### 1.3 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Design metal stairs, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.
- 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. (4.79 kN/sq. m).
  - 2. Concentrated Load: 300 lbf (1.33 kN) applied on an area of 4 sq. in. (2580 sq. mm).
  - 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 1/4 inch (6.4 mm), whichever is less.
- C. Structural Performance of Railings: Railings shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated.

1. Handrails and Top Rails of Guards:
  - a. Uniform load of 50 lbf/ ft. (0.73 kN/m) applied in any direction.
  - b. Concentrated load of 200 lbf (0.89 kN) applied in any direction.
  - c. Uniform and concentrated loads need not be assumed to act concurrently.
2. Infill of Guards:
  - a. Concentrated load of 50 lbf (0.22 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
  - b. Infill load and other loads need not be assumed to act concurrently.

#### 1.4 ACTION SUBMITTALS

- A. Product Data: For metal stair materials and the following:
  1. Precast concrete treads with non-slip surface finish texture.
  2. Paint products.
  3. Grout.
- B. Shop Drawings: Include plans, elevations, sections, details for stairs, guardrails and rails, and attachments to other work.
- C. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

#### 1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For qualified professional engineer.
- B. Welding certificates.
- C. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.
- D. 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 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. Prefabricated Stairs: Architectural class.
- C. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."
- D. Welding Qualifications: Qualify procedures and personnel according to the following:
  - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
  - 2. AWS D1.3, "Structural Welding Code - Sheet Steel."

## 1.7 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 will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.

## PART 2 - PRODUCTS

### 2.1 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.

### 2.2 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513.
- C. 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.
- D. Cast Iron: Either gray iron, ASTM A 48/A 48M, or malleable iron, ASTM A 47/A 47M, unless otherwise indicated.

- E. Uncoated, Cold-Rolled Steel Sheet: ASTM A 1008/A 1008M, structural steel, Grade 25 (Grade 170), unless another grade is required by design loads; exposed.
- F. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.

## 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 (ASTM F 568M, Property Class 4.6); with hex nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.
- C. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563 (ASTM A 563M); and, where indicated, flat washers.
  - 1. Provide mechanically deposited or hot-dip, zinc-coated anchor bolts for exterior stairs.
- D. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).
- E. Lag Screws: ASME B18.2.1 (ASME B18.2.3.8M).
- F. Plain Washers: Round, ASME B18.22.1 (ASME B18.22M).
- G. Lock Washers: Helical, spring type, ASME B18.21.1 (ASME B18.21.2M).
- H. Post-Installed Anchors: 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. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 2 (A4) stainless-steel bolts, ASTM F 593 (ASTM F 738M), and nuts, ASTM F 594 (ASTM F 836M).

## 2.4 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."

- C. Shop Primers: Provide primers that comply with Division 09 painting Sections.
- D. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.
- 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.

## 2.5 PRECAST CONCRETE TREADS

- A. Concrete Materials and Properties: Comply with requirements in Division 03 Section "Cast-in-Place Concrete" for normal-weight, ready-mixed concrete with a minimum 28-day compressive strength of 5000 psi (35 MPa) and a total air content of not less than 4 percent or more than 6 percent.
- B. Reinforcing Wire Fabric: Galvanized, welded wire fabric, 2 by 2 inches (50 by 50 mm) by 0.062-inch- (1.6-mm-) diameter wire; comply with ASTM A 185/A 185M and ASTM A 82/A 82M, except for minimum wire size.

## 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. 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 (1 mm) 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.

## 2.7 STEEL-FRAMED STAIRS

- A. Stair Framing:
1. Fabricate stringers of steel tubes or channels.
    - a. Provide closures for exposed ends of channel and tube stringers.
    - b. Provide cross brace strapping field welded to underside of stringers to minimize lateral movement of installed assembly.
  2. Weld stringers to steel headers; weld or bolt framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.

## 2.8 STAIR RAILINGS

- A. Comply with applicable requirements in Division 05 Section "Pipe and Tube Railings"
1. Connect posts to stair framing by direct welding unless otherwise indicated.
- B. Steel Tube Railings: Fabricate railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.
1. Rails and Posts: 1-5/8-inch- (41-mm-) diameter top and bottom rails and 1-5/8-inch- (41-mm-) diameter posts.
  2. Picket Infill: 1/2-inch- (13-mm-) square pickets spaced less than 4 inches (100 mm) o.c..
  3. Intermediate Rails Infill: 1-5/8-inch- (41-mm-) diameter.
- C. Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.

1. Finish welds to comply with NOMMA's "Voluntary Joint Finish Standards" for Type 1 welds: no evidence of a welded joint.
- D. Form changes in direction of railings as follows:
  1. By inserting prefabricated flush-elbow fittings.
- E. Form simple and compound curves by bending members in jigs to produce uniform curvature for each repetitive configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- F. Close exposed ends of railing members with prefabricated end fittings.
- G. 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 (6 mm) or less.
- H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
  1. Connect posts to stair framing by direct welding unless otherwise indicated.
  2. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves.
- I. Fillers: Provide fillers made from steel plate, or other suitably crush-resistant material, where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses and to produce adequate bearing area to prevent bracket rotation and overstressing of substrate.

## 2.9 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 [SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
- D. Apply shop primer to uncoated surfaces of metal stair components.. 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 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include stainless steel threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors and fasteners..
- 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. 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.
- D. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.
- E. Install precast concrete treads with adhesive and fasteners supplied by manufacturer.

### 3.2 INSTALLING 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 substrates with steel round flanges welded to rail ends and anchored with postinstalled stainless steel anchors and bolts.
- B. Attach handrails to wall with wall brackets. Use type of bracket with flange tapped for concealed anchorage to threaded hanger bolt or as indicated on accepted shop drawings. Provide bracket with 1-1/2-inch (38-mm) minimum clearance from inside face of handrail and finished wall surface. Locate brackets as indicated on accepted shop drawings or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as required to comply with performance requirements and as follows:
  - 1. For wood stud partitions, use stainless steel hanger or lag bolts set into studs or wood backing between studs. Coordinate with carpentry work to locate blocking and backing members. Set fasteners and brackets in full bed of sealant

### 3.3 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 same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-primed surfaces.



1. Apply by brush or spray to provide a minimum 2.0-mil (0.05-mm) dry film thickness.
- B. Touchup Painting: Cleaning and touchup painting of field welds, bolted connections, and abraded areas of shop prime paint are specified in Division 09 painting Sections.

END OF SECTION 055100