

## SECTION 055113 - METAL PAN 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 concrete-filled treads.
2. Steel tube railings attached to metal stairs.
3. Steel tube handrails attached to walls adjacent to metal stairs.

## B. Related Requirements:

1. Section 033000 "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
2. Section 055213 "Pipe and Tube Railings" for pipe and tube railings.

## 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. Precast concrete treads.
3. Epoxy-resin-filled stair treads.
4. Nonslip aggregates and nonslip-aggregate finishes.
5. Abrasive nosings.
6. Paint products.

- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
- C. Samples for Verification: For each type and finish of nosing and tread.
- D. Delegated-Design Submittal: For stairs and railings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

## 1.5 INFORMATIONAL SUBMITTALS

- A. Welding certificates.
- B. 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. Welding Qualifications: Qualify procedures and personnel according to the following:
  - 1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
  - 2. AWS D1.3/D1.3M, "Structural Welding Code - Sheet Steel."

## PART 2 - PRODUCTS

### 2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by the following:
  - 1. Alfab, Inc.
  - 2. American Stair, Inc.
  - 3. Pacific Stair Corporation.
  - 4. Worthington Metal Fabricators.

### 2.2 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design stairs and railings.
- 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  $L/360$  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.
- D. Seismic Performance of Stairs: Metal stairs shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.
1. Component Importance Factor: 1.5.

## 2.3 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. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513.
- D. 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.
- E. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, either commercial steel, Type B, or structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.
- F. Woven-Wire Mesh: Intermediate-crimp, square pattern, 2-inch (50-mm) woven-wire mesh, made from 0.135-inch (3.5-mm) nominal diameter wire complying with ASTM A 510 (ASTM A 510M).

## 2.4 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 stairs indicated to be shop primed with zinc-rich primer.
- D. Post-Installed Anchors: Torque-controlled expansion anchors or 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/E 488M, conducted by a qualified independent testing agency.
  - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941 (ASTM F 1941M), Class Fe/Zn 5, unless otherwise indicated.

## 2.5 MISCELLANEOUS MATERIALS

- A. Low-Emitting Materials: Paints and coatings shall comply with the testing and product requirements of the California Department of Public Health's (formerly, the California Department of Health Services') "Standard Method for the Testing and Evaluation of Volatile Organic Chemical Emissions from Indoor Sources Using Environmental Chambers."
- B. Shop Primers: Provide primers that comply with Section 099100 "Painting".
- C. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79 and compatible with topcoat.
  - 1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.
- D. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- E. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.
- F. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187/D 1187M.
- G. Concrete Materials and Properties: Comply with requirements in Section 033000 "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi (20 MPa) unless otherwise indicated.
- H. 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.
- I. Welded Wire Reinforcement: ASTM A 185/A 185M, 6 by 6 inches (152 by 152 mm), 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. Join components by welding unless otherwise indicated.
  - 2. Use connections that maintain structural value of joined pieces.
- 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 4 welds: good quality, uniform undressed weld with minimal splatter.
- 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.

## 2.7 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 channels.
    - a. Provide closures for exposed ends of channel stringers.
  - 2. Construct platforms of steel channel headers and miscellaneous framing members as needed to comply with performance requirements.

3. Weld or bolt stringers to headers; weld or bolt 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 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 (1.7 mm).
1. Steel Sheet: Uncoated cold or hot-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. Attach risers and subtreads to stringers with brackets made of steel angles or bars. Weld brackets to stringers and attach metal pans to brackets by welding, riveting, or bolting.
  4. Shape metal pans to include nosing integral with riser.
  5. Attach abrasive nosings to risers.
  6. At Contractor's option, provide stair assemblies with metal pan subtreads filled with reinforced concrete during fabrication.
  7. Provide epoxy-resin-filled treads, reinforced with glass fibers, with slip-resistant, abrasive surface.
  8. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.
- a. Smooth Soffit Construction: Construct subplatforms with flat metal under surfaces to produce smooth soffits.

## 2.8 STAIR RAILINGS

- A. Comply with applicable requirements in Section 055213 "Pipe and Tube Railings." Section 057300 "Decorative Metal Railings."
1. Rails may be bent at corners, rail returns, and wall returns, instead of using prefabricated fittings.
  2. 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 1-1/2-inch- (38-mm-) square posts.
  2. Mesh Infill: Woven wire mesh crimped into 1-by-1/2-by-1/8-inch (25-by-13-by-3-mm) steel channel frames. Orient wire mesh with wires horizontal and vertical.

- 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 as shown in NAAMM AMP 521.
- D. Form changes in direction of railings as follows:
  - 1. As detailed.
  - 2. By bending or by inserting prefabricated elbow fittings.
  - 3. By flush bends or by inserting prefabricated flush-elbow fittings.
  - 4. By radius bends of radius indicated or by inserting prefabricated elbow fittings of radius indicated.
- E. For changes in direction made by bending, use 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. Connect posts to stair framing by direct welding unless otherwise indicated.
- I. 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. For galvanized railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
  - 2. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
  - 3. Provide type of bracket with flange tapped for concealed anchorage to threaded hanger bolt and that provides 1-1/2-inch (38-mm) clearance from inside face of handrail to finished wall surface.
- J. 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. Finish metal stairs after assembly.
- B. 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.
  2. Fill vent and drain holes that are exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.
- C. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with 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.

### 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. Center nosings on tread width.
- H. Install precast concrete treads with adhesive 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 or bolting 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. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as follows:
  - 1. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
  - 2. For hollow masonry anchorage, use toggle bolts.
  - 3. For steel-framed partitions, use hanger or lag bolts set into fire-retardant-treated wood backing between studs. Coordinate with stud installation to locate backing members.
  - 4. For steel-framed partitions, use self-tapping screws fastened to steel framing or to concealed steel reinforcements.
  - 5. For steel-framed partitions, use toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.

### 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-painted 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 paint are specified in Section 099100 "Painting" .

END OF SECTION 055113

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