

**SECTION 055113 STEEL PAN STAIRS**

**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 steel pan stairs as indicated on the drawings and specified herein, including but not limited to, the following:
  - 1. Steel pan stairs, including all clips, hangers, inserts, braces and other supports.
  - 2. Steel pipe handrails, guardrails and intermediate rails for steel stairs, including supports, brackets, and anchors.

**1.3 RELATED SECTIONS**

- A. Structural Steel - Section 051200.
- B. Miscellaneous Metals - Section 055000.
- C. Installation of inserts in drywall furnished by this Section - Section 092900.
- D. Finish painting - Section 099000.

**1.4 QUALITY ASSURANCE**

- A. Qualification of Welders: Use only certified welders and the shielded arc process for all welding performed in connection with the work of this Section. Protect adjacent surfaces when field welding to prevent damage or stain. Welders and welding operators must be qualified by tests as provided by AWS.
- B. Codes and Standards: In addition to complying with all pertinent codes and regulations, comply with:
  - 1. "Specifications for Design, Fabrication and Erection of Structural Steel for Buildings" of the American Institute of Steel Construction.
  - 2. "Code for Welding in Building Construction" of the American Welding Society.
  - 3. "Metal Stairs Manual" of the National Association of Architectural Metal Manufacturers
- C. Conflicting Requirements: In the event of conflict between pertinent codes and regulations and the requirements of the referenced standards of these specifications, the provisions of the more stringent shall govern.
- D. Field Measurements: If construction process permits, take field measurements prior to preparation of shop drawings and fabrication, where possible. Do not delay job progress. Allow for trimming and fitting wherever taking field measurements before fabrication might delay work.

- E. Tolerances: Allow for construction tolerances as required.
- F. Coordination: Coordinate this work with the work of all other trades interfacing with metal pan stairs, such as structural openings, sprinklers and standpipes, and other trades as required.

#### 1.5 DRAWING SUBMISSION

- A. General: It is the intent of the Working Drawings to display the layouts and general design parameters upon which the Shop Drawings shall be developed. Detail development and all connections shall be part of Shop Drawing Development.
- B. Shop Drawings
  - 1. Before any steel stairs are fabricated, submit shop drawings to the Architect for approval.
  - 2. Show all locations, markings, quantities, materials, sizes and shapes, and indicate all methods of connecting, anchoring, fastening, bracing, for the stair construction, support and attachment to the work of other trades.
- C. Engineering Data
  - 1. Before any metal pan stairs are fabricated, submit engineering data drawings to the Architect for review. The Contractor is responsible for the structural design and supports for the stair system and must show his proposed system on these drawings.
  - 2. These drawings must show all load conditions and design calculations relative to connections, fastening devices and anchorage, as well as size and gauge of stair members. Calculations and drawings must be prepared by a Structural Engineer licensed in the State of New Jersey and shall be signed and sealed by this Engineer.

#### 1.6 SAMPLES SUBMISSION

- A. Submit the following listed samples and other samples as may be requested by the Architect, to show the quality standards:
  - 1. Railing bracket.
  - 2. Exposed weld.
  - 3. Exposed bolted connection.
  - 4. Bent pipe railing.
- B. Samples shall be submitted cleaned and shop primed and shall represent standards to which all respective materials used in the Project shall meet.

#### 1.7 PERFORMANCE STANDARDS

- A. Stairs and railings shall be constructed to conform to the following performance standards, unless greater required by 2021 International Building Code; New Jersey edition:
  - 1. Stairs and platforms shall support a live load of one hundred (100) psf and a concentrated live load of three hundred (300) lbs. and shall have a live load deflection limited to 1/360 of the span. Loads shall not apply simultaneously.
  - 2. Loads of Handrails and Guards

- a. Handrails and guards shall be designed to resist a load of 50 pounds per lineal foot applied in any direction at the top and to transfer this load through the supports to the structure supporting the rail or guard.
- b. Handrail assemblies shall also be able to resist a single concentrated load of 200 pounds applied in any direction at any point along the top. This load can be considered independently of the uniform load noted previously.
- c. Intermediate rails, that is, those not the handrail, shall be able to resist a load of 50 pounds on an area not to exceed 1 sf including the openings and spaces between rails. These are not required to be superimposed with the other railing loads noted above.

## 1.8 PRODUCT HANDLING

- A. Protection: Use all means necessary to protect steel pan stair before, during and after installation and to protect the installed work and materials of all other trades.
- B. Replacements: In the event of damage, immediately make all repairs and replacements necessary to the approval of the Architect and at no additional cost to the Owner.

## PART 2 - PRODUCTS

### 2.1 MATERIALS

- A. Structural Steel: ASTM A 36.
- B. Steel Sheets: ASTM A 245, Grade C, minimum ten (10) gauge for platforms, twelve (12) gauge minimum for treads and risers.
- C. Steel Pipe: ASTM A 53, Type E., Grade A, and ASTM A 501. Use standard malleable iron fittings for steel pipe.
- D. Malleable Iron Castings: ASTM A 47, Grade 35018.
- E. Bolts and Nuts: ASTM A 307, Grade A bolts.
- F. Machine Screws: ASME B 18.6.3.
- G. Expansion Bolts: "Cinch" type, galvanized, of approved manufacture.
- H. Threaded End Hanger Rods: Minimum 3/4" diameter, ASTM A 36.
- I. Shop Paint: Shop prime all stairs and railings using Series 88 Azeron Primer made by Tnemec, ICI Devoe "Rust Guard" quick dry alkyd shop coat No. 41403, or "Interlac 393" by International Protection Coatings.
- J. Bituminous Paint: Cold applied asphalt emulsion complying with ASTM D1187.
- K. Concrete Fill and Reinforcing Materials
  1. Concrete Materials and Properties: Comply with requirements in Division 3 Section "Cast-in-Place Concrete" for normal-weight, ready-mixed concrete with a minimum 28-day compressive strength of 3000 psi.

2. Nonslip-Aggregate Finish: Factory-packaged abrasive aggregate made from fused, aluminum-oxide grits or crushed emery; rustproof and nonglazing; unaffected by freezing, moisture, or cleaning materials.
3. Welded Wire Fabric: ASTM A 185, 6 by 6 inches – W1.4 by W1.4, unless otherwise indicated.

## 2.2 FABRICATION

### A. General

1. Steel pan stair work shall be fabricated by an experienced manufacturer in accordance with 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 strains and stresses to which material will be subjected.
2. Fabricate shop assemblies in largest practical sizes to minimize field work. All exposed surfaces shall be clean and free from all dirt, stains, grease marks, scratches, waves, dents, buckles, tool marks, rattles, and other objectionable defects which mar appearance or use of finished work.
3. Cutting: Cut materials by sawing, shearing, or blanking. Flame cutting will be permitted when ground back to clean edges. Cuts shall be made accurately, clean, sharp and free of burrs, without deforming adjacent metals.
4. Connections: Make connections with tight joints, capable of developing full strength of the members, flush. Locate joints where least conspicuous. Use concealed fasteners where possible. Weld or rivet shop connections; bolt, screw or weld field connections.
  - a. Welding: Welds shall be continuous, except where spot welding is specifically permitted. Welding shall conform to the Standard Code of the American Welding Society. Exposed welds are required to be ground flush.
  - b. Bolts and Screws: Make threaded connections tight with threads entirely concealed. Use lock nuts, or upset thread ends. Exposed bolts and screw head shall be flat and countersunk, unless otherwise indicated on drawings. Remove projecting ends of bolts and screws. Punch or drill holes; do not burn.

### B. Stairs and Platforms

1. Provide stringers, risers, sub-treads and platforms matching profiles as shown. Form tread pan and riser in a continuous piece to receive the finished tread; tread shall be a minimum of twelve (12) gauge. Weld risers and treads to carrier angles which shall be welded to the structural steel stringers. Fasten countersunk bolts or stud welded clips through mesh for cement fill. Provide welded-on clips for the support of gypsum drywall soffits.
2. On intermediate platforms, provide metal bases formed of stringers. Miter and weld and grind smooth internal and external corners of metal bases. Form platform runs of minimum ten (10) gauge steel.
3. Countersink bolt heads and screws on finished surfaces or cut off flush with such surfaces.
4. Properly fit and securely fasten together all parts making exposed joints close fitting. Cut, drill, punch and tap as required for installation.
5. Make joints as strong and rigid as adjoining sections. Weld continuously along entire line of contact except where spot welding is indicated.

6. Separate dissimilar metals in or adjacent to work of this Section with a coat of bituminous paint on each surface prior to installation.
7. Closure and Filler Plates: Where indicated on drawings or as required, at least twelve (12) gauge sheet steel, securely fastened to top and bottom of stringer and adjacent wall, by welding or screws.
8. Struts, Hangers, Platform Headers and Subframing
  - a. Provide supports as detailed and required, including all struts, clip angles, angles or hangers which are required and necessary for support of stair construction.
  - b. Supports shall be of size suitable for the support load, as required. Struts, angles and hangers shall be supported by and directly connected to the structural framing. Struts and hangers, with their connections, shall be concealed.
  - c. Provide other inserts, anchors and/or other subframing as may be required to complete the stair construction and properly support it on the structural framing.

C. Handrails, Railings, Posts and Brackets

1. Provide steel pipe of size shown on drawings, Schedule 40. Use heavier weight pipes and/or reinforce pipes internally as required to meet performance standards given in paragraph 1.7 herein. Fittings shall be flush type, malleable or cast iron. Wall brackets shall be steel design as detailed.
2. Handrail, post and railing spacing shall meet Code requirements.
3. Construction: Form direction changes in rails using solid bar stock or elbows. Connections shall be shop welded, except where expansion joints are required. Field connections shall be welded for continuity. All exposed welds shall be ground smooth and flush.
  - a. If elbows are not available for angles shown, bends shall maintain full diameter of pipe, use mandrel, no kinks, ripples, flats are acceptable.
4. Fabricate newel or steel tubing with wall thickness of 0.120" and provide gray iron casting newel caps.
5. Anchor posts to steel with steel flanges, angle type or floor type as required by conditions, welded to posts and bolted to the steel supporting members.
6. Secure handrails to walls with wall brackets. Provide brackets as shown on drawings. For installation in drywall, furnish Drywall Section steel plate to receive wall plate portion of bracket and anchor or bolt wall plate through drywall to supporting steel plate. Locate brackets at not more than 5'-0" o.c. unless otherwise shown.
7. Anchor rail ends into adjacent walls with steel flanges welded to rail ends and anchored into the wall construction as described above.

2.3 SHOP PAINTING

- A. Scope: All ferrous metal shall be cleaned and shop painted with one coat of specified ferrous metal primer.
- 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.

### PART 3 - EXECUTION

#### 3.1 INSPECTION

- A. Examine the areas and conditions where steel pan stairs are 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 INSTALLATION

- A. Work in the field shall comply with the same requirements as specified for shop work above.
- B. Except where otherwise shown or specified for a particular item of work or for built-in work, fasten metal work to solid masonry with expansion bolts. Fastenings to wood plugs in masonry will not be accepted. Drill holes to the exact diameter of the bolts using a rotary drill for concrete and a percussion drill for other masonry. Thread screws full length to the head of the screw.
- C. Provide connecting members needed for properly securing the work to masonry, drywall and structural framing, including bolts, machine screws, rods, hangers, inserts, sleeves, plates, anchors, expansion bolts, washers and other items as required. Furnish built-in items to drywall trades as required for proper anchorage.
- D. Leave work exposed to view, including stair soffits, clean, smooth and neatly finished. All exposed welds shall be dressed smooth.
- E. Include supplementary parts necessary to complete each item even though such work is not definitively shown or specified.
- F. Coordinate and schedule the work of this Section with the work of other trades. Furnish anchors, sockets, fastenings and other miscellaneous items to be embedded in concrete or masonry, or required for securing metal work to other construction so as not to delay job progress.
- G. Attach wall railings to the wall construction, using appropriate bolts and anchors to meet performance standards
- H. Install work plumb and true to the exact lines and levels, in the correct location and in proper relation to adjoining work.

- I. Touch up marred and abraded shop paint of exposed surfaces after erection in the field.
- J. Posts shall be set plumb within 1/8" vertical tolerance. Longitudinal members shall be parallel with each other and with floor surface or slope of stair to a tolerance of 1/8" in ten (10) linear feet. Center lines of members within each run of railing shall lie in the same vertical plane. Field joints of connecting sections shall be hairline.

3.3 TOUCH-UP PAINTING

- A. Immediately after erection, clean field welds, bolted connections, and abraded areas of shop coat, and paint exposed areas with same material used for shop painting. Apply by brush or spray to provide a minimum dry film thickness of 2.0 mils.

END OF SECTION 055113