

## SECTION 055113 - METAL PAN STAIRS

### PART 1 - GENERAL

#### 1.1 SUMMARY

A. Section Includes:

1. Preassembled steel stairs with concrete-filled treads.
2. Steel tube and picket railings attached to metal stairs for Stair No. 2.
3. Steel tube handrails attached to walls adjacent to metal stairs at Stair No. 2.

B. Related Requirements:

1. Section 057300 "Decorative Metal Railings" for railings at for Stair No. 1.

#### 1.2 ACTION SUBMITTALS

A. Product Data: For metal pan stairs.

B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.

C. Delegated-Design Submittal: For stairs and railings, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

### PART 2 - PRODUCTS

#### 2.1 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.

## 2.2 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.

## 2.3 FASTENERS

- A. 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.

## 2.4 MISCELLANEOUS MATERIALS

- A. Shop Primers: Provide primers that comply with Division 09 painting and coating Sections.

## 2.5 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. 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 2 welds: completely sanded joint, some undercutting and pinholes are okay.
- F. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible.
- 2.6 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 plates or channels.
      - a. Provide closures for exposed ends of channel stringers.
    2. Construct platforms of steel plate or channel headers and miscellaneous framing members as needed to comply with performance requirements.
    3. Weld stringers to headers; weld framing members to stringers and headers.
    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. Smooth Soffit Construction: Construct stairs to allow for attachment of metal furring and gypsum board to form gypsum board soffits on underside of treads and platforms, flush with bottom of stringers unless otherwise indicated.
- 2.7 STAIR RAILINGS
- A. Steel Railings for Stair No. 2: 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: 1-1/2-inch- (38-mm-) square top and bottom rails and 1-1/2-inch- (38-mm-) square posts.
    2. Picket Infill: 1/2-inch- (13-mm-) square pickets spaced less than 4 inches (100 mm) clear.
  - B. 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.
  - C. Form changes in direction of railings by bending or by inserting prefabricated elbow fittings.

- D. 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.
- E. Close exposed ends of railing members with prefabricated end fittings.
- F. Provide wall returns at ends of wall-mounted handrails unless otherwise indicated.
- G. Connect posts to stair framing by direct welding unless otherwise indicated.
- 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.
- 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.

## 2.8 FINISHES

- A. Finish metal stairs after assembly.
- B. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with SSPC-SP 3, "Power Tool Cleaning."
- C. 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. 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.
- B. Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete unless otherwise indicated.
- C. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints.
- D. Field Welding: Comply with requirements for welding in "Fabrication, General" Article.
- E. Place and finish concrete fill for treads and platforms to comply with Section 033000 "Cast-in-Place Concrete."

### 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 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 required to comply with performance requirements.

### 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.

END OF SECTION