

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 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes the following:

1. Preassembled "drop-in" 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.
4. Railing gates at the level of discharge.
5. Industrial-grade alternating tread steel stair.

- B. Related Sections include the following:

1. Division 5 Section "Metal Fabrications" for steel framed wire mesh gate installed at top landing of metal stairs.
2. Division 9 Section "Non-Structural Metal Framing" for metal backing for anchoring railings outside of masonry stairwells.
3. Division 9 Section "Resilient Base and Accessories" for resilient stair tread and landing coverings.
4. Division 9 Section "Interior Painting" for final finish coating of exposed and semi-exposed stair elements and railings.

1.3 PERFORMANCE REQUIREMENTS

- A. Structural Performance of Stairs: Provide metal stairs capable of withstanding 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.

- 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. (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. Top Rails of Guards:
 - a. Uniform load of 50 lbf/ ft. (0.73 kN/m) applied horizontally and concurrently with 100 lbf/H (1.46 KN/m) applied vertically downward.
 - 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.
 3. Infill of Guards:
 - a. Concentrated load of 50 lbf (0.22 kN) 200 lbf (0.89 kN) applied horizontally on an area of 1 sq. ft. (0.093 sq. m).
- C. Seismic Performance: Provide metal stairs capable of withstanding the effects of earthquake motions determined according to ASCE 7, "Minimum Design Loads for Buildings and Other Structures". Refer to structural drawings for project specific seismic criteria.

1.4 SUBMITTALS

- A. Product Data: For metal stairs and the following:
1. Pre-manufactured alternating tread stair.
 2. Paint products.
 3. 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.
 2. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation registered in the State of Maryland.
- C. Welding certificates.
- D. Qualification Data: Submit calculations signed and sealed by a Maryland registered professional engineer for approval.

1.5 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 Alternating Tread Stair: Industrial 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."

1.6 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 PRE-MANUFACTURED ALTERNATING TREAD STAIR

- A. Basis-of-Design: Subject to compliance with Performance Requirements, provide alternating tread staircase indicated on the Drawings, as manufactured by Lapeyre Stair, Inc.

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 A36/A 36M.
- B. Steel Tubing: ASTM A 500 (cold formed) and ASTM A513 (electric-resistance-welded).

- C. 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.
- D. Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, structural steel, Grade 30 (Grade 205), unless another grade is required by design loads.

2.4 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 (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.
- D. Machine Screws: ASME B18.6.3 (ASME B18.6.7M).
- E. Lag Bolts: 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. 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.

2.5 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with MPI#79.
 - 1. Use primer with a VOC content of 420 g/L (3.5 lb/gal.) or less when calculated according to 40 CFR 59, Subpart D (EPA Method 24).
- C. Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.
- D. 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.

- E. Concrete Materials and Properties: Comply with requirements in Division 3 Section "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.
- F. Rubber accessories on Alternating Tread Stair:
 - 1. Rubber Spine: Hollow neoprene.
 - 2. Rubber Foot Dividers: Solid neoprene.

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. 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 true to line and level 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 and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- 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. Acceptable Manufacturers:

1. Alfab, Inc.
2. American Stair, Inc.
3. Sharon Companies, Ltd. (The).

B. Stair Platform 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 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 0.0677 inch (1.7 mm).

1. Steel Sheet: Uncoated cold-rolled steel sheet.
2. 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.
3. Shape metal pans to include nosing integral with riser.
4. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.

2.8 ALTERNATING TREAD STAIR

- A. Landings, Treads, and Mounting Base: Shall be stamped and formed from single piece material. Stock shapes, hand forming, or welded remnants shall not be permitted. All stamped parts shall have integrally formed rigidizing bends and shall be spot welded to stringers of like material.
- B. Welds: Shall be a minimum of 8 welds per tread, and 12 welds each on the landing and mounting base. Each weld shall be quality controlled and be capable of withstanding a minimum of 2800 lbs. in shear.
- C. Pedestrian Surfaces: Shall be punched through with upset non-skid openings.
- D. Riser Spacing: Shall be equally spaced to within 3/16" for adjacent risers and to within 3/8" for any two non-adjacent risers on a stair.
- E. Handrails: Shall be contoured for body guidance and underarm support and shall be attached to the outside stringers and landings by bolting.

- F. Landing Reinforcement: Shall be with ¼" steel angle notched and punched and factory welded to the landing at the points of a handrail attachment.
- G. Rubber Foot Divider: Shall be affixed to the central portion of the landing. A rubber bumper strip shall be attached or will be provided for field attaching to the central stringer.

2.9 STEEL TUBE RAILINGS

- A. General: 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. Configuration: 1-1/2 inch (38 mm) diameter top and bottom rails, 1 ½ inch (38 mm) square posts, and ½ inch (13 mm) square pickets spaced less than 4 inches (100 mm) clear.
 - 2. Handrail: 1 ½ inch (38mm) continuous handrailing, bracketed off square posts, as detailed on drawings.
- B. Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit. Weld all around at connections.
- C. Form changes in direction of railings as follows:
 - 1. By radius bends of radius indicated on drawings.
- D. 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.
- E. Close exposed ends of railing members with prefabricated end fittings.
- F. 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 ¼ inch (6 mm) or less.
- G. Exterior railings shall be hot-dipped galvanized including fittings, brackets, fasteners sleeves and other ferrous metal components.
- 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.
 - 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, except galvanize anchors embedded in exterior masonry and concrete construction.

2.10 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 minimum requirements indicated below for SSPC surface preparation specifications and environmental exposure conditions of installed products:
- 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 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 3 Section "Cast-in-Place Concrete."

3.2 INSTALLATION OF ALTERNATING TREAD STAIR

- A. Position stair with top tread at same elevation as upper finished floor or roof surface.
- B. Secure stair with not less than 2 bolts or studs at top and with not less than 2 at bottom of stair.
- C. If bumper has not been installed at the factory, install the bumper in accordance with the manufacturer's instructions using the glue supplied with the stair.
- D. Touch up with matching paint any chipped or abraded damage to factory finish.

3.3 INSTALLATION OF 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 (38-mm) 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. 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 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 (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 Division 9 painting Sections.

END OF SECTION 05511