

**SECTION 05 50 00**  
**METAL FABRICATIONS**

**PART 1 GENERAL**

**1.01 SECTION INCLUDES**

- A. Shop fabricated steel items.

**1.02 RELATED REQUIREMENTS**

- A. Section 01 45 33 - Special Inspections - Code required special tests and inspections.
- B. Section 03 30 00 - Cast-in-Place Concrete: Placement of metal fabrications in concrete.

**1.03 REFERENCE STANDARDS**

- A. ASTM A36/A36M - Standard Specification for Carbon Structural Steel; 2019.
- B. ASTM A53/A53M - Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless; 2020.
- C. ASTM A123/A123M - Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products; 2017.
- D. ASTM F3125/F3125M - Standard Specification for High Strength Structural Bolts and Assemblies, Steel and Alloy Steel, Heat Treated, Inch Dimensions 120 ksi and 150 ksi Minimum Tensile Strength, and Metric Dimensions 830 MPa and 1040 MPa Minimum Tensile Strength; 2019, with Editorial Revision (2020).
- E. AWS B2.1/B2.1M - Specification for Welding Procedure and Performance Qualification; 2014 (Amended 2015).
- F. AWS D1.1/D1.1M - Structural Welding Code - Steel; 2020.
- G. IAS AC172 - Accreditation Criteria for Fabricator Inspection Programs for Structural Steel; 2018.
- H. SSPC-Paint 15 - Steel Joist Shop Primer/Metal Building Primer; 1999 (Ed. 2004).
- I. SSPC-Paint 20 - Zinc-Rich Primers (Type I, "Inorganic," and Type II, "Organic"); 2002 (Ed. 2004).
- J. SSPC-SP 2 - Hand Tool Cleaning; 2018.

**1.04 SUBMITTALS**

- A. See Section 01 30 00 - Administrative Requirements, for submittal procedures.
- B. Shop Drawings: Indicate profiles, sizes, connection attachments, reinforcing, anchorage, size and type of fasteners, and accessories. Include erection drawings, elevations, and details where applicable.
- C. Welders' Qualification Statement: Welders' certificates in accordance with AWS B2.1/B2.1M and dated no more than 12 months before start of scheduled welding work.
- D. Fabricator's Qualification Statement: Provide documentation showing steel fabricator is accredited under IAS AC172.

**PART 2 PRODUCTS**

**2.01 MATERIALS - STEEL**

- A. Steel Sections: ASTM A992 Grade 50 or ASTM A572 Grade 50.
- B. Hollow Steel Sections: ASTM A500 Grade C or ASTM A1085.
- C. Plates: ASTM A570 Grade 50.
- D. Pipe: ASTM A53/A53M, Grade B Schedule 40, black finish.
- E. Bolts, Nuts, and Washers: ASTM F3125/F3125M, Type 1, plain.
- F. Welding Materials: AWS D1.1/D1.1M; type required for materials being welded.

- G. Shop and Touch-Up Primer: SSPC-Paint 15, complying with VOC limitations of authorities having jurisdiction.
- H. Touch-Up Primer for Galvanized Surfaces: SSPC-Paint 20, Type I - Inorganic, complying with VOC limitations of authorities having jurisdiction.

## **2.02 FABRICATION**

- A. Fit and shop assemble items in largest practical sections, for delivery to site.
- B. Fabricate items with joints tightly fitted and secured.
- C. Grind exposed joints flush and smooth with adjacent finish surface. Make exposed joints butt tight, flush, and hairline. Ease exposed edges to small uniform radius.
- D. Exposed Mechanical Fastenings: Flush countersunk screws or bolts; unobtrusively located; consistent with design of component, except where specifically noted otherwise.
- E. Furnish components required for anchorage of fabrications. Fabricate anchors and related components of same material and finish as fabrication, except where specifically noted otherwise.

## **2.03 FABRICATED ITEMS**

- A. Bollards: Steel pipe, concrete filled, crowned cap, as detailed; prime paint finish.
- B. Door Frames for Overhead Door Openings: Channel sections; prime paint finish.

## **2.04 FINISHES - STEEL**

- A. Prime paint steel items.
  - 1. Exceptions: Galvanize items to be embedded in concrete, items to be embedded in masonry, and items specified for galvanized finish.
  - 2. Exceptions: Do not prime surfaces in direct contact with concrete, where field welding is required, and items to be covered with sprayed fireproofing.
- B. Prepare surfaces to be primed in accordance with SSPC-SP2.
- C. Clean surfaces of rust, scale, grease, and foreign matter prior to finishing.
- D. Prime Painting: One coat.
- E. Galvanizing of Structural Steel Members: Galvanize after fabrication to ASTM A123/A123M requirements. Provide minimum 1.7 oz/sq ft galvanized coating.
- F. Galvanizing of Non-structural Items: Galvanize after fabrication to ASTM A123/A123M requirements.

## **PART 3 EXECUTION**

### **3.01 EXAMINATION**

- A. Verify that field conditions are acceptable and are ready to receive work.

### **3.02 PREPARATION**

- A. Clean and strip primed steel items to bare metal where site welding is required.
- B. Supply setting templates to the appropriate entities for steel items required to be cast into concrete or embedded in masonry.

### **3.03 INSTALLATION**

- A. Install items plumb and level, accurately fitted, free from distortion or defects.
- B. Provide for erection loads, and for sufficient temporary bracing to maintain true alignment until completion of erection and installation of permanent attachments.
- C. Field weld components as indicated on drawings.
- D. Perform field welding in accordance with AWS D1.1/D1.1M.
- E. Obtain approval prior to site cutting or making adjustments not scheduled.

- F. After erection, prime welds, abrasions, and surfaces not shop primed, except surfaces to be in contact with concrete.

#### **3.04 TOLERANCES**

- A. Maximum Variation From Plumb: 1/4 inch per story, non-cumulative.
- B. Maximum Offset From True Alignment: 1/4 inch.
- C. Maximum Out-of-Position: 1/4 inch.

**END OF SECTION**

**This page was intentionally left blank for duplex printing.**