

**SECTION 05511**  
**METAL STAIRS**

**PART 1 - GENERAL**

**1.1 RELATED DOCUMENTS**

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions apply to this Section.

**1.2 SUMMARY**

- A. This Section includes the following:
1. Preassembled steel stairs with concrete-filled treads.
  2. Handrails and railings attached to metal stairs.
  3. Handrails attached to walls adjacent to metal stairs.
  4. Railing gates at the level of exit discharge.
- B. Related Sections:
1. Division 3 Section "Cast-in-Place Concrete" for concrete fill for stair treads and platforms.
  2. Division 5 Section "Ornamental Handrails and Railings" for ornamental metal handrails and railings.
  3. Division 5 Section "Pipe and Tube Railings" for pipe and tube handrails and railings not attached to metal stairs or to walls adjacent to metal stairs.

**1.3 PERFORMANCE REQUIREMENTS**

- A. Structural Performance: Provide metal stairs capable of withstanding the following structural loads without exceeding the allowable design working stress of the materials involved, including anchors and connections. Apply each load to produce the maximum stress in each component of metal stairs.
1. Treads and Platforms of Metal Stairs: Capable of withstanding a uniform load of 100 lbf/sq. ft. or a concentrated load of 300 lbf on an area of 4 sq. in., whichever produces the greater stress.
  2. Stair Framing: Capable of withstanding stresses resulting from loads specified above in addition to stresses resulting from railing system loads.
  3. Limit deflection of treads, platforms, and framing members to L/360 or 1/4 inch, whichever is less.
- B. Structural Performance of Handrails and Railings: Provide handrails and railings capable of withstanding the following structural loads without exceeding the allowable design working stress of materials for handrails, railings, anchors, and connections:
1. Top Rail of Guards: Capable of withstanding the following loads applied as indicated:
    - a. Concentrated load of 200 lbf applied at any point and in any direction.
    - b. Uniform load of 50 lbf/ft. applied horizontally and concurrently with uniform load of 100 lbf/ft. applied vertically downward.
    - c. Concentrated and uniform loads above need not be assumed to act concurrently.
  2. Handrails Not Serving as Top Rails: Capable of withstanding the following loads applied as indicated:
    - a. Concentrated load of 200 lbf applied at any point and in any direction.
    - b. Uniform load of 50 lbf/ft. applied in any direction.
    - c. Concentrated and uniform loads above need not be assumed to act concurrently.
  3. Infill Area of Guards: Capable of withstanding a horizontal concentrated load of 200 lbf applied to 1 sq. ft. at any point in system, including panels, intermediate rails, balusters, or other elements composing infill area.
    - a. Load above need not be assumed to act concurrently with loads on top rails in determining stress on guards.

#### 1.4 SUBMITTALS

- A. Product Data: For metal stairs and the following:
  - 1. Paint products.
  - 2. Grout.
- B. Shop Drawings: Show fabrication and installation details for metal stairs. Include plans, elevations, sections, and details of metal stairs and their connections. Show anchorage and accessory items. Provide templates for anchors and bolts specified for installation under other Sections.
  - 1. Indicate head room clearances.
  - 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.
- C. Samples for Verification: For the following products. Prepare Samples from the same material to be used for the Work.
- D. Welding Certificates: Copies of certificates for welding procedures and personnel.
- E. Structural calculations.

#### 1.5 QUALITY ASSURANCE

- A. Installer Qualifications: Arrange for metal stairs specified in this Section to be fabricated and installed by the same firm.
- B. Professional Engineer Qualifications: A professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for installations of metal stairs (including handrails and railing systems) that are similar to those indicated for this Project in material, design, and extent.
- C. Fabricator Qualifications: A firm experienced in producing metal stairs similar to those indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.
- D. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel," and 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.

### PART 2 - PRODUCTS

#### 2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
  - 1. American Stair Corp., Inc.
  - 2. Sharon Companies, Ltd. (The).

#### 2.2 FERROUS METALS

- A. Metal Surfaces, General: Provide metal free from pitting, seam marks, roller marks, and other imperfections where exposed to view on finished units. Do not use steel sheet with variations in flatness exceeding those permitted by referenced standards for stretcher-leveled sheet.

- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Steel Tubing: Cold-formed steel tubing complying with ASTM A 500.
- D. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- E. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.

### 2.3 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; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Machine Screws: ASME B18.6.3.
- D. Lag Bolts: ASME B18.2.1.
- E. Plain Washers: Round, carbon steel, ASME B18.22.1.
- F. Lock Washers: Helical, spring type, carbon steel, ASME B18.21.1.
- G. Expansion Anchors: Anchor bolt and sleeve assembly of material indicated below with capability to sustain, without failure, a load equal to six times the load imposed when installed in unit masonry and equal to four times the load imposed when installed in concrete, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.
  - 1. Material: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.

### 2.4 PAINT

- A. Shop Primer for Ferrous Metal: Fast-curing, lead- and chromate-free, universal modified-alkyd primer complying with performance requirements in FS TT-P-664, selected for good resistance to normal atmospheric corrosion, compatibility with finish paint systems indicated, and capability to provide a sound foundation for field-applied topcoats despite prolonged exposure.

### 2.5 GROUT

- A. 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.

### 2.6 CONCRETE FILL AND REINFORCING MATERIALS

- A. 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, unless higher strengths are indicated.
- B. 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.
- C. Welded Wire Fabric: ASTM A 185, 6 by 6 inches--W1.4 by W1.4, unless otherwise indicated.

## 2.7 FABRICATION, GENERAL

- A. Provide complete stair assemblies, including metal framing, hangers, struts, handrails, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
  - 1. Join components by welding.
  - 2. Use connections that maintain structural value of joined pieces.
- 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. Commercial class.
- C. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges. Shear and punch metals cleanly and accurately. Remove sharp or rough areas on exposed surfaces.
- D. Ease exposed edges to a radius of approximately 1/32 inch. 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 and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- F. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.
- G. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.

## 2.8 STEEL-FRAMED STAIRS

- A. Stair Framing: Fabricate stringers of structural-steel channels, plates, or a combination of both, as indicated. Provide closures for exposed ends of stringers. Construct platforms of structural-steel channel headers and miscellaneous framing members as indicated. Bolt or weld headers to stringers; bolt or weld framing members to stringers and headers. If using bolts, fabricate and join so bolts are not exposed on finished surfaces.
  - 1. Where stairs are enclosed by gypsum board shaft-wall assemblies, provide hanger rods to support landings from floor construction above. Locate hanger rods within stud space of shaft-wall construction.
  - 2. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.
- B. Metal Risers, Subtread Pans, and Subplatforms: Form to configurations shown from steel sheet of thickness necessary to support indicated loads, but not less than 0.0677 inch.
  - 1. Steel Sheet: Uncoated cold-rolled steel sheet, unless otherwise indicated.
  - 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. At Contractor's option, provide stair assemblies with metal-pan subtreads filled with reinforced concrete during fabrication.
  - 5. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.

- C. Rolled Steel Floor Plate Landing: Provide rolled steel floor plate landing where indicated on Drawings.

## 2.9 STEEL TUBE HANDRAILS AND RAILINGS

- A. General: Fabricate handrails and 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. Standard Configuration: Nominal 1-1/4-inch- rails and posts, 1-1/4-inch- handrails.
  - 2. Configuration at Building 8600 (CLO): Refer to Drawings.
- B. Gates: Form gates from steel tube of same size and shape as top rails. Provide with hinges for fastening to wall and overlapping stop with rubber bumper to restrict gate to opening in the direction of egress.
- C. Interconnect members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
  - 1. At tee and cross intersections, cope ends of intersecting members to fit contour of tube to which end is joined, and weld all around.
- D. Form changes in direction of handrails and rails as follows: By flush-radius bends.
- E. 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.
- F. Close exposed ends of handrail and 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 or less.
- H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting railings and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
  - 1. Connect railing posts to stair framing by direct welding, unless otherwise indicated.
- 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 and to produce adequate bearing area to prevent bracket rotation and overstressing of substrate.
- J. For nongalvanized handrails and 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:
  - 1. Interiors: SSPC SP 3, "Power Tool Cleaning."
- D. Apply shop primer to prepared surfaces of metal stair components, unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1," for shop painting. Primer need not be applied to surfaces to be embedded in concrete or masonry.
  - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

### 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 from 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.

#### 3.2 INSTALLING METAL STAIRS WITH GROUTED BASEPLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of baseplates.
- B. Set steel stair baseplates on wedges, shims, or leveling nuts. After stairs have been positioned and aligned, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.
  - 1. Use nonmetallic, nonshrink grout, unless otherwise indicated.
  - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

#### 3.3 INSTALLING STEEL TUBE RAILINGS AND HANDRAILS

- A. Adjust handrails and 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 railing 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 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. Use type of bracket with flange tapped for concealed anchorage to threaded hanger bolt.

2. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
3. For hollow masonry anchorage, use toggle bolts.
4. For steel-framed gypsum board assemblies, fasten brackets directly to steel framing or concealed 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 dry film thickness.

**END OF SECTION 05511**