

SECTION 05 50 00 - METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.
- B. The Contractor's attention is specifically directed, but not limited, to the following documents for additional requirements:
 - 1. *Uniform General Conditions for Construction Contracts, State of Texas, 2010 (UGC).*
 - 2. *The University of Houston's Supplemental General Conditions and Special Conditions for Construction.*

1.2 SUMMARY

- A. Section Includes:
 - 1. Steel framing and supports for ceiling-hung toilet compartments.
 - 2. Steel framing and supports for overhead doors .
 - 3. Steel framing and supports for countertops.
 - 4. Steel framing and supports for mechanical and electrical equipment.
 - 5. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 - 6. Mounting brackets and anchorages for window-washing equipment.
 - 7. Elevator machine beams, hoist beams, and divider beams.
 - 8. Steel shapes for supporting elevator door sills.
 - 9. Shelf angles.
 - 10. Metal ladders.
 - 11. Ladder safety cages.
 - 12. Metal ships' ladders and pipe crossovers.
 - 13. Metal floor plate and supports.
 - 14. Structural-steel door frames.
 - 15. Miscellaneous steel trim including steel angle corner guards steel edgings and loading-dock edge angles.
 - 16. Metal bollards.
 - 17. Pipe guards.
- B. Products furnished, but not installed, under this Section:
 - 1. Loose steel lintels.
 - 2. Anchor bolts, steel pipe sleeves, slotted-channel inserts, and wedge-type inserts indicated to be cast into concrete or built into unit masonry.

- C. Related Sections:

1. Section 03 30 00 "Cast-in-Place Concrete" for installing anchor bolts, steel pipe sleeves, slotted-channel inserts, wedge-type inserts, and other items cast into concrete.
2. Section 04 20 00 "Unit Masonry" for installing loose lintels, anchor bolts, and other items built into unit masonry.
3. Section 05 12 00 "Structural Steel Framing."
4. Section 12 93 00 "Site Furnishings" for bicycle racks.

1.3 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Design ladders and alternating tread devices, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.
- B. Structural Performance of Alternating Tread Devices: Alternating tread devices shall withstand the effects of loads and stresses within limits and under conditions specified in ICC's International Building Code.
- C. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes acting on exterior metal fabrications by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects.
 1. Temperature Change: 120 deg F, ambient; 180 deg F, material surfaces.

1.4 ACTION SUBMITTALS

- A. Product Data: For the following:
 1. Nonslip aggregates and nonslip-aggregate surface finishes.
 2. Paint products.
 3. Grout.
- B. LEED Submittals (Projects authorized for LEED certification only):
 1. Product Data for Credit MR 4: For products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.
 2. Laboratory Test Reports for Credit IEQ 4: For primers, documentation indicating that products comply with the testing and product requirements of the California Department of Health Services' "Standard Practice for the Testing of Volatile Organic Emissions from Various Sources Using Small-Scale Environmental Chambers."
- C. Shop Drawings: Show fabrication and installation details for metal fabrications.
 1. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
- D. Samples for Verification: For each type and finish of extruded nosing and tread.

- E. Delegated-Design Submittal: For installed products indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For qualified professional engineer.
- B. Mill Certificates: Signed by manufacturers of stainless-steel certifying that products furnished comply with requirements.
- C. Welding certificates.
- D. Paint Compatibility Certificates: From manufacturers of topcoats applied over shop primers certifying that shop primers are compatible with topcoats.

1.6 QUALITY ASSURANCE

- A. Welding Qualifications: Qualify procedures and personnel according to AWS D1.1/D1.1M, "Structural Welding Code - Steel."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with metal fabrications by field measurements before fabrication.

1.8 COORDINATION

- A. Coordinate selection of shop primers with topcoats to be applied over them. Comply with paint and coating manufacturers' written recommendations to ensure that shop primers and topcoats are compatible with one another.
- B. Coordinate installation of anchorages and steel weld plates and angles for casting into concrete. 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 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth, flat surfaces unless otherwise indicated. For metal fabrications exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.

2.2 FERROUS METALS

- A. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 23 percent.
- B. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- C. Stainless-Steel Sheet, Strip, and Plate: ASTM A 240/A 240M or ASTM A 666, Type 304.
- D. Stainless-Steel Bars and Shapes: ASTM A 276, Type 304.
- 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.
- F. Rolled-Stainless-Steel Floor Plate: ASTM A 793.
- G. Steel Tubing: ASTM A 500, cold-formed steel tubing.
- H. Steel Pipe: ASTM A 53/A 53M, standard weight (Schedule 40) unless otherwise indicated.
- I. Slotted Channel Framing: Cold-formed metal box channels (struts) complying with MFMA-4.
 - 1. Size of Channels: As indicated.
 - 2. Material: Galvanized steel, ASTM A 653/A 653M, structural steel, Grade 33, with G90 coating; 0.079-inch nominal thickness.

2.3 NONFERROUS METALS

- A. Aluminum Plate and Sheet: ASTM B 209, Alloy 6061-T6.
- B. Aluminum Extrusions: ASTM B 221, Alloy 6063-T6.
- C. Aluminum-Alloy Rolled Tread Plate: ASTM B 632/B 632M, Alloy 6061-T6.
- D. Aluminum Castings: ASTM B 26/B 26M, Alloy 443.0-F.

2.4 FASTENERS

- A. General: Unless otherwise indicated, provide Type 304 stainless-steel fasteners for exterior use and zinc-plated fasteners with coating complying with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, at exterior walls. Select fasteners for type, grade, and class required.
 - 1. Provide stainless-steel fasteners for fastening aluminum.
 - 2. Provide stainless-steel fasteners for fastening stainless steel.
- B. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Steel Bolts and Nuts: Regular hexagon-head bolts, ASTM A 325, Type 3; with hex nuts, ASTM A 563, Grade C3; and, where indicated, flat washers.

- D. Stainless-Steel Bolts and Nuts: Regular hexagon-head annealed stainless-steel bolts, ASTM F 593; with hex nuts, ASTM F 594; and, where indicated, flat washers; Alloy Group 1.
- E. Anchor Bolts: ASTM F 1554, Grade 36, of dimensions indicated; with nuts, ASTM A 563; and, where indicated, flat washers.
 - 1. Hot-dip galvanize or provide mechanically deposited, zinc coating where item being fastened is indicated to be galvanized.
- F. Eyebolts: ASTM A 489.
- G. Machine Screws: ASME B18.6.3.
- H. Lag Screws: ASME B18.2.1.
- I. Wood Screws: Flat head, ASME B18.6.1.
- J. Plain Washers: Round, ASME B18.22.1.
- K. Lock Washers: Helical, spring type, ASME B18.21.1.
- L. Anchors, General: Anchors capable of sustaining, 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.
- M. Cast-in-Place Anchors in Concrete: Either threaded type or wedge type unless otherwise indicated; galvanized ferrous castings, either ASTM A 47/A 47M malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, all hot-dip galvanized per ASTM F 2329.
- N. Post-Installed Anchors: Torque-controlled expansion anchors or chemical anchors.
 - 1. Material for Interior Locations: Carbon-steel components zinc plated to comply with ASTM B 633 or ASTM F 1941, Class Fe/Zn 5, unless otherwise indicated.
 - 2. Material for Exterior Locations and Where Stainless Steel is Indicated: Alloy Group 2 stainless-steel bolts, ASTM F 593, and nuts, ASTM F 594.

2.5 MISCELLANEOUS MATERIALS

- A. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B. Shop Primers: Provide primers that comply with Section 09 91 13 "Exterior Painting," Section 09 91 23 "Interior Painting," and Section 09 96 00 "High-Performance Coatings."
- C. Galvanizing Repair Paint: High-zinc-dust-content paint complying with SSPC-Paint 20 and compatible with paints specified to be used over it.

- 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: Comply with requirements in Section 03 30 00 "Cast-in-Place Concrete" for normal-weight, air-entrained, concrete with a minimum 28-day compressive strength of 3000 psi.

2.6 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in the shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
- B. Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- C. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- D. Form exposed work with accurate angles and surfaces and straight edges.
- E. Weld corners and seams continuously 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. 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 or welds where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) fasteners unless otherwise indicated. Locate joints where least conspicuous.
- G. Fabricate seams and other connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- H. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- I. Provide for anchorage of type indicated; coordinate with supporting structure. Space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
 - 1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors, 1/8 by 1-1/2 inches, with a minimum 6-inch

embedment and 2-inch hook, not less than 8 inches from ends and corners of units and 24 inches o.c., unless otherwise indicated.

2.7 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports not specified in other Sections as needed to complete the Work.
- B. Fabricate units from steel shapes, plates, and bars of welded construction unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction.
 - 1. Fabricate units from slotted channel framing where indicated.
 - 2. Furnish inserts for units installed after concrete is placed.
- C. Galvanize miscellaneous framing and supports where indicated.
- D. Prime miscellaneous framing and supports with primer specified in Section 09 91 13 "Exterior Painting", Section 09 91 23 "Interior Painting", or Section 09 96 00 "High-Performance Coatings".

2.8 METAL LADDERS

- A. General:
 - 1. Comply with ANSI A14.3 unless otherwise indicated.
 - 2. For elevator pit ladders, comply with ASME A17.1.
- B. Steel Ladders:
 - 1. Space siderails 18 inches apart unless otherwise indicated.
 - 2. Siderails: Continuous, 3/8-by-2-1/2-inch steel flat bars, with eased edges.
 - 3. Rungs: 3/4-inch- diameter steel bars.
 - 4. Fit rungs in centerline of siderails; plug-weld and grind smooth on outer rail faces.
 - 5. Provide nonslip surfaces on top of each rung, either by coating rung with aluminum-oxide granules set in epoxy-resin adhesive or by using a type of manufactured rung filled with aluminum-oxide grout.
 - 6. Provide platforms as indicated fabricated from welded or pressure-locked steel bar grating, supported by steel angles. Limit openings in gratings to no more than 1/2 inch in least dimension.
 - 7. Support each ladder at top and bottom and not more than 60 inches o.c. with welded or bolted steel brackets.
 - 8. Galvanize ladders, including brackets and fasteners.

2.9 LADDER SAFETY CAGES

- A. General:

1. Fabricate ladder safety cages to comply with ANSI A14.3. Assemble by welding or with stainless-steel fasteners.
2. Provide primary hoops at tops and bottoms of cages and spaced not more than 20 feet o.c. Provide secondary intermediate hoops spaced not more than 48 inches o.c. between primary hoops.
3. Fasten assembled safety cage to ladder rails and adjacent construction by welding or with stainless-steel fasteners unless otherwise indicated.

B. Steel Ladder Safety Cages:

1. Primary Hoops: 1/4-by-4-inch flat bar hoops.
2. Secondary Intermediate Hoops: 1/4-by-2-inch flat bar hoops.
3. Vertical Bars: 3/16-by-1-1/2-inch flat bars secured to each hoop.
4. Galvanize ladder safety cages, including brackets and fasteners.

2.10 METAL [SHIPS' LADDERS] [AND] [PIPE CROSSOVERS]

- A. Provide metal ships' ladders and pipe crossovers where indicated. Fabricate of open-type construction with channel or plate stringers and pipe and tube railings unless otherwise indicated. Provide brackets and fittings for installation.

1. Fabricate ships' ladders and pipe crossovers, including railings from steel .
2. Fabricate treads and platforms from welded or pressure-locked steel bar grating . Limit openings in gratings to no more than 1/2 inch in least dimension.
3. Fabricate treads from rolled-steel floor plate .
4. Comply with applicable railing requirements in Section 05 52 13 "Pipe and Tube Railings."

- B. Galvanize steel ships' ladders and pipe crossovers, including treads, railings, brackets, and fasteners.

2.11 METAL FLOOR PLATE

- A. Fabricate from rolled-steel floor plate of thickness indicated below:

1. Thickness: As indicated.

- B. Provide grating sections where indicated fabricated from welded or pressure-locked steel bar grating . Limit openings in gratings to no more than 1/2 inch [**1 inch**] in least dimension.

- C. Provide steel angle supports as indicated.

- D. Include steel angle stiffeners, and fixed and removable sections as indicated.

- E. Provide flush steel bar drop handles for lifting removable sections, one at each end of each section.

2.12 STRUCTURAL-STEEL DOOR FRAMES

- A. Fabricate structural-steel door frames from steel shapes, plates, and bars of size and to dimensions indicated, fully welded together, with 5/8-by-1-1/2-inch steel channel stops, unless otherwise indicated. Plug-weld built-up members and continuously weld exposed joints. Secure removable stops to frame with countersunk machine screws, uniformly spaced at not more than 10 inches o.c. Reinforce frames and drill and tap as necessary to accept finish hardware.
 - 1. Provide with integrally welded steel strap anchors for securing door frames into adjoining concrete or masonry.
- B. Extend bottom of frames to floor elevation indicated with steel angle clips welded to frames for anchoring frame to floor with expansion shields and bolts.

C. Galvanize exterior steel frames.

2.13 MISCELLANEOUS STEEL TRIM

- A. Unless otherwise indicated, fabricate units from steel shapes, plates, and bars of profiles shown with continuously welded joints and smooth exposed edges. Miter corners and use concealed field splices where possible.
- B. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work.
 - 1. Provide with integrally welded steel strap anchors for embedding in concrete or masonry construction.

C. Galvanize exterior miscellaneous steel trim.

2.14 METAL BOLLARDS

- A. Fabricate metal bollards from Schedule 80 steel pipe .
 - 1. Where bollards are indicated to receive controls for door operators, provide necessary cutouts for controls and holes for wire.
 - 2. Where bollards are indicated to receive light fixtures, provide necessary cutouts for fixtures and holes for wire.
- B. Fabricate bollards with 3/8-inch- thick steel baseplates for bolting to concrete slab. Drill baseplates at all four corners for 3/4-inch anchor bolts.
 - 1. Where bollards are to be anchored to sloping concrete slabs, angle baseplates for plumb alignment of bollards.
- C. Fabricate sleeves for bollard anchorage from steel pipe with 1/4-inch- thick steel plate welded to bottom of sleeve. Make sleeves not less than 8 inches deep and 3/4 inch larger than OD of bollard.

- D. Fabricate internal sleeves for removable bollards from Schedule 80 steel pipe or 1/4-inch wall-thickness steel tubing with an OD approximately 1/16 inch less than ID of bollards. Match drill sleeve and bollard for 3/4 inch steel machine bolt.
- E. Prime bollards with primer specified in Section 09 96 00 "High-Performance Coatings."

2.15 PIPE GUARDS

- A. Fabricate pipe guards from 3/8-inch-thick by 12-inch-wide steel plate, bent to fit flat against the wall or column at both ends and to fit around pipe with 2-inch clearance between pipe and pipe guard. Drill each end for two 3/4-inch anchor bolts.
- B. Galvanize pipe guards.

2.16 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts and for grouting.
- B. Galvanize plates.

2.17 LOOSE STEEL LINTELS

- A. Fabricate loose steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated. Fabricate in single lengths for each opening unless otherwise indicated. Weld adjoining members together to form a single unit where indicated.
- B. Size loose lintels to provide bearing length at each side of openings equal to 1/12 of clear span but not less than 8 inches unless otherwise indicated.
- C. Galvanize loose steel lintels located in exterior walls.

2.18 STEEL WELD PLATES AND ANGLES

- A. Provide steel weld plates and angles not specified in other Sections, for items supported from concrete construction as needed to complete the Work. Provide each unit with no fewer than two integrally welded steel strap anchors for embedding in concrete.

2.19 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish metal fabrications after assembly.
- C. Finish exposed surfaces to remove tool and die marks and stretch lines, and to blend into surrounding surface.

2.20 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with ASTM A 153/A 153M for steel and iron hardware and with ASTM A 123/A 123M for other steel and iron products.
- B. Shop prime iron and steel items not indicated to be galvanized unless they are to be embedded in concrete, sprayed-on fireproofing, or masonry, or unless otherwise indicated.
- C. Preparation for Shop Priming: Prepare surfaces to comply with requirements indicated below:
 - 1. Exterior Items: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 2. Items Indicated to Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 3. Items Indicated to Receive Primers Specified in Section 09 96 00 "High-Performance Coatings": SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
 - 4. Other Items: SSPC-SP 3, "Power Tool Cleaning."
- D. Shop Priming: Apply shop primer to comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel," for shop painting.
 - 1. Stripe paint corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- B. 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.
- C. 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.

- D. Fastening to In-Place Construction: Provide anchorage devices and fasteners where metal fabrications are required to be fastened to in-place construction. Provide threaded fasteners for use with concrete and masonry inserts, toggle bolts, through bolts, lag screws, wood screws, and other connectors.
- E. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with the following:
 - 1. Cast Aluminum: Heavy coat of bituminous paint.
 - 2. Extruded Aluminum: Two coats of clear lacquer.

3.2 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings.

3.3 INSTALLING METAL BOLLARDS

- A. Fill metal-capped bollards solidly with concrete and allow concrete to cure seven days before installing.
 - 1. Do not fill removable bollards with concrete.
- B. Anchor bollards to existing construction with **[expansion anchors] [anchor bolts] [through bolts]**. Provide four 3/4-inch bolts at each bollard unless otherwise indicated.
 - 1. Embed anchor bolts at least 4 inches in concrete.
- C. Anchor bollards in concrete **[with pipe sleeves preset and anchored into concrete] [in formed or core-drilled holes not less than 8 inches deep and 3/4 inch larger than OD of bollard]**. Fill annular space around bollard solidly with nonshrink, nonmetallic grout; mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward bollard.
- D. Anchor bollards in place with concrete footings. Center and align bollards in holes 3 inches above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace bollards in position until concrete has cured.
- E. Anchor internal sleeves for removable bollards in **[concrete by inserting into pipe sleeves preset into concrete] [formed or core-drilled holes not less than 8 inches deep and 3/4 inch larger than OD of sleeve]**. Fill annular space around internal sleeves solidly with nonshrink, nonmetallic grout; mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward internal sleeve.

- F. Anchor internal sleeves for removable bollards in place with concrete footings. Center and align sleeves in holes 3 inches above bottom of excavation. Place concrete and vibrate or tamp for consolidation. Support and brace sleeves in position until concrete has cured.
- G. Place removable bollards over internal sleeves and secure with 3/4-inch machine bolts and nuts. After tightening nuts, drill holes in bolts for inserting padlocks. Owner will furnish padlocks.
- H. Fill bollards solidly with concrete, mounding top surface to shed water.
 - 1. Do not fill removable bollards with concrete.

3.4 INSTALLING PIPE GUARDS

- A. Provide pipe guards at exposed vertical pipes in parking garage where not protected by curbs or other barriers. Install by bolting to wall or column with expansion anchors. Provide four 3/4-inch bolts at each pipe guard. Mount pipe guards with top edge 26 inches above driving surface.

3.5 INSTALLING BEARING AND LEVELING PLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of plates.
- B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, 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 nonshrink grout, either metallic or nonmetallic, in concealed locations where not exposed to moisture; use nonshrink, nonmetallic grout in exposed locations unless otherwise indicated.
 - 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.6 ADJUSTING AND CLEANING

- A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas. Paint uncoated and abraded 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 dry film thickness.
- B. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 05 50 00