

SECTION 055213 – PIPE AND TUBE RAILINGS

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:

1. Steel railings.
2. Aluminum railings.

B. Related Sections:

1. Section 099113 – Exterior Painting.
2. Section 099123 – Interior Painting.

C. Reference and Industry Standards

1. The following reference standards shall be applicable to this Section:
 - a. The current Enterprise Green Communities (EGC) Criteria, and the current New York City Overlay.
2. Industry Standards
 - AAMA (American Architectural Manufacturers Association)
 - ASTM (American Society for Testing and Materials)
 - AWS (American Welding Society)
 - NACE (National Association of Corrosion Engineers)
 - NOMMA (National Ornamental and Miscellaneous Metals Association)
 - SSPC (Society for Protective Coatings)

D. The current NYC Overlay of the current Enterprise Green Communities Criteria:

1. Mandatory Requirements: See the NYC Overlay of the EGC reference standard for full specifications.
 - a. All projects must achieve compliance with the mandatory criteria measures that are applicable:
 - Criterion 6.10: Construction Waste Management
2. Optional Project Requirements for Certification Points
 - a. Additionally, rehab projects are required to achieve **55** optional points. Criteria with optional points related to this Specification Section include, but may not be limited to:
 - Criterion 6.1: Ingredient Transparency for Material Health
 - Criterion 6.2: Recycled Content and Ingredient Transparency

- Criterion 6.5: Environmentally Responsible Material Selection
- Criterion 6.7: Regional Materials
- Criterion 6.10: Construction Waste Management

1.2 ACTION SUBMITTALS

A. Product Data:

1. Manufacturer's product lines of mechanically connected railings.
2. Handrail brackets.
3. Shop primer.
4. Intermediate coats and topcoats.
5. Bituminous paint.
6. Non-shrink, nonmetallic grout.
7. Anchoring cement.
8. Metal finishes.
9. Paint products.

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

1.3 INFORMATIONAL SUBMITTALS

A. Welding certificates.

B. Product Test Reports: For tests on railings performed by a qualified testing agency, in accordance with ASTM E894 and ASTM E935.

C. Documentation for compliance with Enterprise Green Communities criteria.

1.4 QUALITY ASSURANCE

A. Welding Qualifications: Qualify procedures and personnel in accordance with the following:

1. AWS D1.1, Structural Welding Code - Steel.
2. AWS D1.2, Structural Welding Code - Aluminum.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

A. Structural Performance: Railings, including attachment to building construction, 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. applied in any direction.
 - b. Concentrated load of 200 lbf 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 applied horizontally on an area of 1 sq. ft..
- b. Infill load and other loads need not be assumed to act concurrently.

2.2 METALS, GENERAL

- A. Metal Surfaces, General: Provide materials with smooth surfaces, without seam marks, roller marks, rolled trade names, stains, discolorations, or blemishes.
- B. Brackets, Flanges, and Anchors: Cast or formed metal of same type of material and finish as supported rails unless otherwise indicated.
 - 1. Provide type of bracket with **[flange tapped for concealed anchorage to threaded hanger bolt] [predrilled hole for exposed bolt anchorage]** and that provides 1-1/2-inch clearance from inside face of handrail to finished wall surface.

2.3 STEEL RAILINGS

- A. Tubing: **[ASTM A500 (cold formed)] [or] [ASTM A513, Type 5 (round steel tube)]**.
- B. Pipe: ASTM A53, Type F or Type S, Grade A, Standard Weight (Schedule 40), unless another grade and weight are required by structural loads.
 - 1. Provide galvanized finish for exterior installations and where indicated.
- C. Plates, Shapes, and Bars: ASTM A36.
- D. Cast Iron Fittings: Either gray iron, ASTM A48, or malleable iron, ASTM A47, unless otherwise indicated.
- E. Expanded Metal Infill Panels: ASTM F1267, **[Type I (expanded)] [Type II (expanded and flattened)]**, Class 1 (uncoated).
 - 1. Style Designation: **[3/4 number 13] [1-1/2 number 10] <Insert designation>**.
- F. Perforated-Metal Infill Panels:
 - 1. Cold-Rolled Steel Sheet: ASTM A1008, or hot-rolled steel sheet, ASTM A1011, commercial steel, Type B, **[0.060 inch] <Insert dimension> thick, [with 1/4-inch holes 3/8 inch o.c. in staggered rows] <Insert description>**.
- G. Woven-Wire Mesh Infill Panels: Intermediate-crimp, **[diamond] [square]** pattern, 2-inch woven-wire mesh, made from 0.134-inch-diameter steel wire complying with ASTM A510.

2.4 ALUMINUM RAILINGS

- A. Aluminum, General: Provide alloy and temper recommended by aluminum producer and finisher for type of use and finish indicated, and with not less than the strength and durability properties of alloy and temper designated below for each aluminum form required.

- B. Extruded Bars and Tubing: ASTM B221, Alloy 6063-T5/T52.
- C. Extruded Structural Pipe and Round Tubing: ASTM B429, Alloy 6063-T6.
 - 1. Provide Standard Weight (Schedule 40) pipe unless otherwise indicated.
- D. Drawn Seamless Tubing: ASTM B210, Alloy 6063-T832.
- E. Plate and Sheet: ASTM B209, Alloy 6061-T6.
- F. Die and Hand Forgings: ASTM B247, Alloy 6061-T6.
- G. Castings: ASTM B26, Alloy A356.0-T6.
- H. Perforated Metal Infill Panels: Aluminum sheet, ASTM B209, Alloy 6061-T6, [**0.063 inch**] **<Insert dimension>** thick, [**with 1/4-inch holes 3/8 inch o.c. in staggered rows**] **<Insert description>**.
- I. Woven-Wire Mesh Infill Panels: Intermediate-crimp, [**diamond**] [**square**] pattern, 2-inch woven-wire mesh, made from 0.162-inch-diameter aluminum wire complying with ASTM B211, Alloy 6061-T94.

2.5 FASTENERS

- A. Fastener Materials:
 - 1. Ungalvanized-Steel Railing Components: Plated steel fasteners complying with ASTM F1941, Class Fe/Zn 5 for zinc coating.
 - 2. Hot-Dip Galvanized Railing Components: Type 304 stainless steel or hot-dip zinc-coated steel fasteners complying with ASTM A153 or ASTM F2329 for zinc coating.
 - 3. Aluminum Railing Components: Type 304 stainless steel fasteners.
- B. Post-Installed Anchors: Fastener systems with working capacity greater than or equal to the design load, according to an evaluation report acceptable to authorities having jurisdiction, based on ICC-ES AC193 (Mechanical Anchors in Concrete Elements) [**or ICC-ES AC308 (Post-Installed Adhesive Anchors in Concrete Elements.)**]
 - 1. Material for Interior Locations: Carbon-steel components zinc-plated to comply with ASTM B633 or ASTM F1941, Class Fe/Zn 5, unless otherwise indicated.

2.6 MISCELLANEOUS MATERIALS

- A. Handrail Brackets: [**Cast iron**] [**Cast aluminum,**] center of handrail [**2-1/2 inches**] [**3-1/8 inches**] **<Insert dimension>** from [**face of railing**] [**wall**].
- B. Welding Rods and Bare Electrodes: Select in accordance with AWS specifications for metal alloy welded.

1. For **[aluminum]** **[and]** **[stainless steel]** railings, provide type and alloy as recommended by producer of metal to be welded and as required for color match, strength, and compatibility in fabricated items.
- 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. Shop Primers: Provide primers that comply with *Section 099113 – Exterior Painting* and *Section 099123 – Interior Painting*.
- E. Universal Shop Primer: Fast-curing, lead- and chromate-free, universal modified-alkyd primer compatible with topcoat.
 1. Use primer containing pigments that make it easily distinguishable from zinc-rich primer.
- F. Epoxy Zinc-Rich Primer: Compatible with topcoat.
- G. Shop Primer for Galvanized Steel: Primer formulated for exterior use over zinc-coated metal and compatible with finish paint systems indicated.
- H. Intermediate Coats and Topcoats: Provide products that comply with *Section 099113 – Exterior Painting* or *Section 099123 – Interior Painting*.
- I. Epoxy Intermediate Coat: Compatible with primer and topcoat.
- J. Polyurethane Topcoat: Compatible with undercoat.
- K. Bituminous Paint: Cold-applied asphalt emulsion, complying with ASTM D1187.
- L. Non-shrink, Non-metallic Grout: Factory-packaged, non-staining, noncorrosive, nongaseous grout, complying with ASTM C1107. Provide grout specifically recommended by manufacturer for interior and exterior applications.
- M. Anchoring Cement: Factory-packaged, non-shrink, non-staining, hydraulic-controlled expansion cement formulation for mixing with water at Project site to create pourable anchoring, patching, and grouting compound.
 1. Water-Resistant Product: At exterior locations, provide formulation that is resistant to erosion from water exposure without needing protection by a sealer or waterproof coating and that is recommended by manufacturer for exterior use.

2.7 FABRICATION

- A. Cut, drill, and punch metals cleanly and accurately.
 1. Remove burrs and ease edges to a radius of approximately 1/32 inch unless otherwise indicated.
 2. Remove sharp or rough areas on exposed surfaces.
- B. Form work true to line and level with accurate angles and surfaces.

- C. 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. 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 flux immediately.
 - 4. At exposed connections, finish exposed welds to comply with NOMMA's Voluntary Joint Finish Standards for [**Finish #1 welds; ornamental quality with no evidence of a welded joint**] [**Finish #2 welds; good appearance, completely sanded joint, some undercutting and pinholes okay**] [**Finish #3 welds; utilitarian appearance not subject to view, partially dressed weld with spatter removed**]
- D. Welded Connections for Aluminum Pipe: Fabricate railings to interconnect members with concealed internal welds that eliminate surface grinding, using manufacturer's standard system of sleeve and socket fittings.
- E. Nonwelded Connections: Connect members with concealed mechanical fasteners and fittings. Fabricate members and fittings to produce flush, smooth, rigid, hairline joints.
- F. Form changes in direction as follows:
 - 1. As detailed.
 - 2. [**By bending**] [**or**] [**by inserting prefabricated elbow fittings**].
- G. Bend members in jigs to produce uniform curvature for each configuration required. Maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- H. Close exposed ends of hollow railing members with prefabricated cap and end fittings of same metal and finish as railings.
- I. 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.
- J. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, flanges, miscellaneous fittings, and anchors to interconnect railing members to other work unless otherwise indicated.
 - 1. At brackets and fittings fastened to plaster or gypsum board partitions, provide crush-resistant fillers or other means to transfer loads through wall finishes to structural supports and prevent bracket or fitting rotation and crushing of substrate.
- K. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work.
 - 1. Fabricate anchorage devices capable of withstanding loads imposed by railings.
 - 2. Coordinate anchorage devices with supporting structure.
- L. For railing posts set in concrete, provide stainless steel sleeves not less than 6 inches long with inside dimensions not less than 1/2 inch greater than outside dimensions of post, with metal plate forming bottom closure.

- M. For removable railing posts, fabricate slip-fit sockets from stainless steel tube or pipe whose ID is sized for a close fit with posts; limit movement of post without lateral load, measured at top, to not more than one-fortieth of post height.
 - 1. Provide socket covers designed and fabricated to resist being dislodged.
 - 2. Provide chain with eye, snap hook, and staple across gaps formed by removable railing sections at locations indicated. Fabricate from same metal as railings.
- N. Expanded-Metal Infill Panels: Fabricate infill panels from expanded-metal sheet of same metal as railings.
 - 1. Orient expanded metal with long dimension of diamonds **[parallel to top rail]** **[perpendicular to top rail]** **[horizontal]** **[vertical]**.
- O. Perforated-Metal Infill Panels: Fabricate infill panels from perforated metal made from **[steel]** **[galvanized steel]** **[aluminum]** **[stainless steel]** **[same metal as railings in which they are installed]**.
 - 1. Edge panels with U-shaped channels made from metal sheet, of same metal as perforated metal and not less than 0.043 inch thick.
 - 2. Orient perforated metal with pattern **[parallel to top rail]** **[perpendicular to top rail]** **[horizontal]** **[vertical]** **[as indicated on Drawings]**.
- P. Woven-Wire Mesh Infill Panels: Fabricate infill panels from woven-wire mesh crimped into 1-by-1/2-by-1/8-inch metal channel frames.
 - 1. Fabricate wire mesh and frames from same metal as railings in which they are installed.
 - 2. Orient wire mesh with **[diamonds vertical]** **[diamonds perpendicular to top rail]** **[wires perpendicular and parallel to top rail]** **[wires horizontal and vertical]** **[as indicated on Drawings]**.
- Q. Toe Boards: Where indicated, provide toe boards at railings around openings and at edge of open-sided floors and platforms. Fabricate to dimensions and details indicated.

2.8 STEEL AND IRON FINISHES

- A. Galvanized Railings:
 - 1. Hot-dip galvanize exterior steel railings, including hardware, after fabrication.
 - 2. Comply with ASTM A123 for hot-dip galvanized railings.
 - 3. Comply with ASTM A153 for hot-dip galvanized hardware.
- B. For galvanized railings, provide hot-dip galvanized fittings, brackets, fasteners, sleeves, and other ferrous components.
- C. Preparing Galvanized Railings for Shop Priming: After galvanizing, thoroughly clean railings of grease, dirt, oil, flux, and other foreign matter, and treat with etching cleaner **[and as follows]**.
 - 1. Comply with SSPC-SP 16.

- D. For nongalvanized-steel railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves; however, hot-dip galvanize anchors to be embedded in exterior concrete or masonry.
- E. Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with [SSPC-SP 6/NACE No. 3.] [SSPC-SP 3.] [**requirements indicated below:**]
 - 1. Exterior Railings: SSPC-SP 6/NACE No. 3.
 - 2. Railings Indicated To Receive Zinc-Rich Primer: SSPC-SP 6/NACE No. 3.
 - 3. Other Railings: SSPC-SP 3.
- F. Primer Application: Apply shop primer to prepared surfaces of railings unless otherwise indicated. Comply with requirements in SSPC-PA 1 for shop painting. Primer need not be applied to surfaces to be embedded in concrete or masonry.
 - 1. Shop prime uncoated railings with universal shop primer.
 - 2. Do not apply primer to galvanized surfaces.
- G. Shop-Painted Finish: Comply with *Section 099113 – Exterior Painting*.
 - 1. Color: As indicated by manufacturer's designations.
- H. High-Performance Coating: Apply epoxy intermediate and polyurethane topcoats to prime-coated surfaces. Comply with coating manufacturer's written instructions and with requirements in SSPC-PA 1 for shop painting. Apply at spreading rates recommended by coating manufacturer.
 - 1. Color: As indicated by manufacturer's designations.

2.9 ALUMINUM FINISHES

- A. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are unacceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.
- B. Mill Finish: AA-M12, non-specular as fabricated.
- C. Clear Anodic Finish: AAMA 611, [AA-M12C22A41] [AA-M12C22A31].
- D. Color Anodic Finish: AAMA 611, [AA-M12C22A42/A44] [AA-M12C22A32/A34].
 - 1. Color: [**Light bronze**] [**Medium bronze**] [**Dark bronze**] [**Black**] [**As selected by Owner from full range of industry colors and color densities**].
- E. Baked-Enamel or Powder-Coat Finish: AAMA 2603 except with a minimum dry film thickness of 1.5 mils. Comply with coating manufacturer's written instructions for cleaning, conversion coating, and applying and baking finish.
 - 1. Color and Gloss: As selected by Owner from manufacturer's full range.

PART 3 - EXECUTION

3.1 INSTALLATION, GENERAL

- A. Perform cutting, drilling, and fitting required for installing railings.
 - 1. Fit exposed connections together to form tight, hairline joints.
 - 2. Install railings level, plumb, square, true to line; without distortion, warp, or rack.
 - 3. Set railings accurately in location, alignment, and elevation; measured from established lines and levels.
 - 4. Do not weld, cut, or abrade surfaces of railing components that are coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
 - 5. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
 - 6. Align rails so variations from level for horizontal members and variations from parallel with rake of steps and ramps for sloping members do not exceed 1/4 inch in 12 feet.
- B. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.
 - 1. Coat concealed surfaces of aluminum that will be in contact with grout, concrete, masonry, wood, or dissimilar metals, with a heavy coat of bituminous paint.

3.2 ANCHORING POSTS

- A. Use stainless steel pipe sleeves preset and anchored into concrete for installing posts. After posts are inserted into sleeves, fill annular space between post and sleeve with [**non-shrink, non-metallic grout**] [or] [**anchoring cement**], mixed and placed to comply with anchoring material manufacturer's written instructions.
- B. Form or core-drill holes not less than 5 inches deep and 3/4 inch larger than OD of post for installing posts in concrete. Clean holes of loose material, insert posts, and fill annular space between post and concrete with [**non-shrink, non-metallic grout**] [or] [**anchoring cement**], mixed and placed to comply with anchoring material manufacturer's written instructions.
- C. Anchor posts to metal surfaces with flanges, angle type, or floor type, as required by conditions, connected to posts and to metal supporting members as follows:
- D. Install removable railing sections, where indicated on Drawing, in slip-fit stainless steel sockets cast in concrete.

3.3 ATTACHING RAILINGS

- A. Attach handrails to walls with wall brackets[, **except where end flanges are used**]. Provide brackets with [**1-1/2-inch**] <Insert dimension> clearance from inside face of handrail and finished wall surface.
- B. Secure wall brackets [**and railing end flanges**] 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 wood stud partitions, use hanger or lag bolts set into studs or wood backing between studs. Coordinate with carpentry work to locate backing members.
4. For steel-framed partitions, use hanger or lag bolts set into **[fire-retardant-treated]** wood backing between studs. Coordinate with stud installation to locate backing members.
5. For steel-framed partitions, fasten brackets directly to steel framing or concealed steel reinforcements, using self-tapping screws of size and type required to support structural loads.
6. For steel-framed partitions, use toggle bolts installed through flanges of steel framing or through concealed steel reinforcements.

C. Touchup Painting:

1. Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

3.4 CLEANING

- A. Clean aluminum by washing thoroughly with clean water and soap and rinsing with clean water.
- B. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas, and repair galvanizing to comply with ASTM A780.

END OF SECTION 055213