

## SECTION 055213 - PIPE AND TUBE RAILINGS

### PART 1 - GENERAL

#### 1.1 M.S.U. ISSUES

- A. Stainless steel or aluminum is the preferred handrail material for all public exterior and interior spaces, and for exterior roof access steps, handrails and ladders. Hot-dipped galvanized may be used in mechanical rooms, for incidental handrails and guards around mechanical equipment when the mechanical equipment support is hot-dipped galvanized, and other non-public spaces. Painted steel balusters and top railing may be used in interior low traffic areas. They will be properly prepared and finished with a high performance coating.
- B. Other finishes may be considered for historic buildings. Review such proposals with the M.S.U. Project Designer.
- C. The latest publication of "Pipe Railing Systems Manual" by the National Association of Architectural Metal Manufacturers (NAAMM) shall establish the minimum requirements when not otherwise specified in this section.
- D. LEED

Comply with LEED NC 2.2 Credit Requirements EQ Credit 4.1: Low-Emitting Materials: Adhesives and Sealants for the following:  
Interior Sealants and Adhesives: Maximum VOC content in accordance with South Coast Air Quality Management District (SCAQMD) Rule #1168, effective July 1, 2005 and amended January 7, 2005.

- 1) Interior Sealants: Maximum VOC 250 g/L
- 2) Contact Adhesive: Maximum VOC 80 g/L
- 3) Metal to Metal Adhesive: Maximum VOC 30 g/L
- 4) Multipurpose Construction Adhesive: Maximum VOC 70 g/L

#### 1.2 Related Sections include the following:

- 1. Division 3 Section CONCRETE FOR BUILDING CONSTRUCTION for installing anchor bolts, steel pipe sleeves, wedge-type inserts and other items indicated to be cast into concrete.
- 2. Division 4 Section UNIT MASONRY ASSEMBLIES for installing loose lintels, anchor bolts, and other items indicated to be built into unit masonry.
- 3. Division 5 Section METAL FABRICATIONS.
- 4. Division 5 Section METAL FINISHES.
- 5. Division 9 Sections GYPSUM VENEER PLASTER and PORTLAND CEMENT PLASTER for metal stud systems.

#### 1.3 SUMMARY

- A. This Section includes the following:

1. Aluminum pipe and tube railings.
2. Stainless-steel pipe and tube railings.
3. Steel pipe and tube railings.

#### 1.4 PERFORMANCE REQUIREMENTS

- A. General: In engineering railings to withstand structural loads indicated, determine allowable design working stresses of railing materials based on the following:
1. Aluminum: The lesser of minimum yield strength divided by 1.65 or minimum ultimate tensile strength divided by 1.95.
  2. Stainless Steel: 60 percent of minimum yield strength.
  3. Steel: 72 percent of minimum yield strength.
- B. Structural Performance: 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. applied simultaneously both vertically and horizontally.
    - b. Concentrated load of 300 lbf applied at any point.
    - c. Uniform and concentrated loads need not be assumed to act concurrently.
  2. Top Rails of Guards:
    - a. Uniform load of 50 lbf/ ft. applied simultaneously both vertically and horizontally.
    - b. Concentrated load of 300 lbf applied at any point.
    - c. Uniform and concentrated loads need not be assumed to act concurrently.
- C. Thermal Movements: Provide exterior railings that allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
1. Temperature Change (Range): 120 deg F, ambient; 180 deg F, material surfaces.
- D. Control of Corrosion: Prevent galvanic action and other forms of corrosion by insulating metals and other materials from direct contact with incompatible materials.

#### 1.5 SUBMITTALS

- A. Product Data: For the following:
1. Manufacturer's product lines of mechanically connected railings.
  2. Grout, anchoring cement, and paint products.
- B. Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
- C. Samples for Verification: For each type of exposed finish required.

D. Welding: Qualify procedures and personnel according to the following:

1. AWS D1.1, "Structural Welding Code--Steel."
2. AWS D1.2, "Structural Welding Code--Aluminum."
3. AWS D1.6, "Structural Welding Code--Stainless Steel."

1.6 PROJECT CONDITIONS

- A. Field Measurements: Verify actual locations of walls and other construction contiguous with railings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.7 COORDINATION AND SCHEDULING

- A. Coordinate installation of anchorages for railings. 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. Schedule installation so wall attachments are made only to completed walls. Do not support railings temporarily by any means that do not satisfy structural performance requirements.

PART 2 - PRODUCTS

2.1 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.

2.2 ALUMINUM

- 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 B 221, Alloy 6063-T5/T52.
- C. Extruded Structural Pipe and Round Tubing: ASTM B 429, Alloy 6063-T6.
1. Provide Standard Weight (Schedule 40) pipe, unless otherwise indicated.
- D. Drawn Seamless Tubing: ASTM B 210, Alloy 6063-T832.
- E. Plate and Sheet: ASTM B 209, Alloy 6061-T6.

- F. Die and Hand Forgings: ASTM B 247, Alloy 6061-T6.
- G. Castings: ASTM B 26/B 26M, Alloy A356.0-T6.

## 2.3 STAINLESS STEEL

- A. Tubing: ASTM A 554, Grade MT 316.
- B. Castings: ASTM A 743/A 743M, Grade CF 8 or CF 20.
- C. Plate and Sheet: ASTM A 666, Type 316.

## 2.4 STEEL AND IRON

- A. Tubing: ASTM A 500 (cold formed) or ASTM A 513, Type 5 (mandrel drawn).
- B. Pipe: ASTM A 53/A 53M, Type F or Type S, Grade A, Standard Weight (Schedule 40), unless another grade and weight are required by structural loads.
- C. Plates, Shapes, and Bars: ASTM A 36/A 36M.
- D. Castings: Either gray or malleable iron, unless otherwise indicated.
  - 1. Gray Iron: ASTM A 48/A 48M, Class 30, unless another class is indicated or required by structural loads.
  - 2. Malleable Iron: ASTM A 47/A 47M.

## 2.5 FASTENERS

- A. General: Provide the following:
  - 1. Aluminum Railings: Type 316 stainless-steel fasteners.
  - 2. Stainless-Steel Railings: Type 316 stainless-steel fasteners.
  - 3. Steel Railings: Plated steel fasteners complying with ASTM B 633, Class Fe/Zn 25 for electrodeposited zinc coating.
- B. Fasteners for Anchoring Railings to Other Construction: Select fasteners of type, grade, and class required to produce connections suitable for anchoring railings to other types of construction indicated.
- C. Fasteners for Interconnecting Railing Components:
  - 1. Provide concealed fasteners for interconnecting railing components and for attaching them to other work, unless otherwise indicated.
- D. Anchors: Provide anchors, fabricated from corrosion-resistant materials 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.

## 2.6 MISCELLANEOUS MATERIALS

- A. Shop Primers: Provide primers that comply with Division 9 painting Sections.
- B. Nonshrink, Nonmetallic Grout: Factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with ASTM C 1107. Provide grout specifically recommended by manufacturer for interior applications. For exterior applications use Sikadur® 31, Hi-Mod Gel epoxy and Pecora Dynatrol II caulk.
- C. Anchoring Cement: Factory-packaged, nonshrink, nonstaining, hydraulic-controlled expansion cement formulation for mixing with water at Project site to create pourable anchoring, patching, and grouting compound.

## 2.7 FABRICATION

- A. Except for expansion and contraction joints, handrails will be fabricated in the largest pieces practical and consistent with shipping and handling.
- B. Assemble railings in the shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation. Use connections that maintain structural value of joined pieces.
- C. 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.
- D. Form work true to line and level with accurate angles and surfaces.
- E. Fabricate connections that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.
- F. Cut, reinforce, drill, and tap as indicated to receive finish hardware, screws, and similar items.
- G. Connections: Fabricate railings with welded connections.
- H. 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 surfaces smooth and blended so no roughness shows after finishing and welded surface matches contours of adjoining surfaces.
- I. 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.

- J. 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.
- K. Close exposed ends of railing members with prefabricated end fittings.
- L. Provide wall returns at ends of wall-mounted handrails, with the end turned into the wall and cut parallel to the wall leaving ¼" clearance. A plate equal to the pipe gauge will be welded over the open end and ground smooth.
- M. 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 fillers made from crush-resistant material, or other means to transfer wall loads through wall finishes to structural supports and prevent bracket or fitting rotation and crushing of substrate.
- N. Provide inserts and other anchorage devices for connecting railings to concrete or masonry work. Fabricate anchorage devices capable of withstanding loads imposed by railings. Coordinate anchorage devices with supporting structure.

## 2.8 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Protect mechanical finishes on exposed surfaces from damage by applying a strippable, temporary protective covering before shipping.
- C. 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 not acceptable. 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.
- D. Provide exposed fasteners with finish matching appearance, including color and texture, of railings.

## 2.9 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Mechanical Finish: AA-M12 (Mechanical Finish: nonspecular as fabricated). Use only in non-public spaces.

- C. Class II, Clear Anodic Finish: AA-M12C22A31 (Mechanical Finish: nonspecular as fabricated; Chemical Finish: etched, medium matte; Anodic Coating: Architectural Class II, clear coating 0.010 mm or thicker) complying with AAMA 611.

## 2.10 STAINLESS-STEEL FINISHES

- A. Remove tool and die marks and stretch lines or blend into finish.
- B. Grind and polish surfaces to produce uniform, directionally textured, polished finish indicated, free of cross scratches. Run grain with long dimension of each piece.
- C. Directional Satin Finish: No. 4.
- D. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

## 2.11 STEEL AND IRON FINISHES

- A. Galvanized Railings:
  - 1. Hot-dip galvanize steel and iron railings, including hardware, after fabrication.
  - 2. Comply with ASTM A 123/A 123M for hot-dip galvanized railings.
  - 3. Comply with ASTM A 153/A 153M for hot-dip galvanized hardware.
- B. Fill vent and drain holes that will be exposed in the finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.
- C. For galvanized railings, provide hot-dip galvanized fittings, brackets, fasteners, sleeves, and other ferrous components.

## PART 3 - EXECUTION

### 3.1 EXAMINATION

- A. Examine plaster and gypsum board assemblies, where reinforced to receive anchors, to verify that locations of concealed reinforcements have been clearly marked for Installer. Locate reinforcements and mark locations if not already done.

### 3.2 INSTALLATION, GENERAL

- A. Fit exposed connections together to form tight, hairline joints.
- B. Perform cutting, drilling, and fitting required for installing railings. Set railings accurately in location, alignment, and elevation; measured from established lines and levels and free of rack.

1. Do not weld, cut, or abrade surfaces of railing components that have been coated or finished after fabrication and that are intended for field connection by mechanical or other means without further cutting or fitting.
  2. Set posts plumb within a tolerance of 1/16 inch in 3 feet.
  3. 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.
- C. Corrosion Protection: 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.
- D. Adjust railings before anchoring to ensure matching alignment at abutting joints.
- E. Fastening to In-Place Construction: Use anchorage devices and fasteners where necessary for securing railings and for properly transferring loads to in-place construction.

### 3.3 RAILING CONNECTIONS

- A. Welded Connections: Use fully welded joints for permanently connecting railing components. Comply with requirements for welded connections in Part 2 "Fabrication" Article whether welding is performed in the shop or in the field.
- B. Expansion Joints: Install expansion joints at locations indicated but not farther apart than required to accommodate thermal movement. Provide slip-joint internal sleeve extending 2 inches beyond joint on either side, fasten internal sleeve securely to 1 side, and locate joint within 6 inches of post.

### 3.4 ANCHORING POSTS

- A. 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 nonshrink, nonmetallic grout or anchoring cement, mixed and placed to comply with anchoring material manufacturer's written instructions. Holes for handrails set with expanding grout will have 1/2" radial clearance, and with epoxy will have 1/4" radial clearance. Bolted flange floor mounting is not acceptable.
- B. Leave anchorage joint exposed; wipe off surplus anchoring material; and leave 1/8-inch buildup, sloped away from post.

### 3.5 ATTACHING HANDRAILS TO WALLS

- A. Attach handrails to wall with wall brackets. Provide brackets with 1-1/2-inch clearance from inside face of handrail and finished wall surface.
- B. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads.
- C. 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 wood stud partitions, use hanger or lag bolts set into wood backing between studs. Coordinate with carpentry work to locate backing members.
4. For steel-framed gypsum board or plaster partitions, use hanger or lag bolts set into wood backing between studs. Coordinate with stud installation to locate backing members.

### 3.6 ADJUSTING AND CLEANING

- A. Clean aluminum and stainless steel 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 A 780, using zinc-based alloys or sprayed zinc.

### 3.7 PROTECTION

- A. Protect finishes of railings from damage during construction period with temporary protective coverings approved by railing manufacturer. Remove protective coverings at time of Substantial Completion.
- B. Restore finishes damaged during installation and construction period so no evidence remains of correction work. Return items that cannot be refinished in the field to the shop; make required alterations and refinish entire unit, or provide new units.

END OF SECTION 055213