

SECTION 05500 - METAL FABRICATIONS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to work of this Section.

1.2 SUMMARY

- A. This section includes the following metal fabrications:
 - 1. Rough hardware.
 - 2. Loose bearing and leveling plates.
 - 3. Loose steel lintels.
 - 4. Miscellaneous framing and supports for the following:
 - a. Applications where framing and supports are not specified in other sections.
 - 5. Miscellaneous steel trim.
 - 6. Shelf and relieving angles.
 - 7. Steel pipe railings.
 - 8. Pipe bollards.
- B. Related Sections: The following sections contain requirements that relate to this section:
 - 1. Division 5 Section "Structural Steel" for structural steel framing system components.

1.3 DEFINITIONS

- A. Definitions in ASTM E 985 for railing-related terms apply to this section.

1.4 SYSTEM PERFORMANCE REQUIREMENTS

- A. Structural Performance of Handrails and Railing Systems: Design, engineer, fabricate, and install handrails and railing systems to comply with requirements of ASTM E 985 for structural performance based on testing performed in accordance with ASTM E 894 and E 935.

1.5 SUBMITTALS

- A. General: Submit the following in accordance with Conditions of Contract and Division 1 Specification Sections.
- B. Shop drawings detailing fabrication and erection of each metal fabrication indicated. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items. Provide templates for anchors and bolts specified for installation under other sections.

1.6 QUALITY ASSURANCE

- A. Fabricator Qualifications: Firm experienced in successfully producing metal fabrications similar to that indicated for this Project, with sufficient production capacity to produce required units without causing delay in the Work.
- B. Qualify welding processes and welding operators in accordance with AWS D1.1 "Structural Welding Code - Steel," D1.3 "Structural Welding Code - Sheet Steel", and D1.2 "Structural Welding Code - Aluminum."
 - 1. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone recertification.

1.7 PROJECT CONDITIONS

- A. Field Measurements: Check actual locations of walls and other construction to which metal fabrications must fit, by accurate field measurements before fabrication; show recorded measurements on final shop drawings. Coordinate fabrication schedule with construction progress to avoid delay of Work.
 - 1. Where field measurements cannot be made without delaying the Work, guarantee dimensions and proceed with fabrication of products without field measurements. Coordinate construction to ensure that actual opening dimensions correspond to guaranteed dimensions. Allow for trimming and fitting.

1.8 SEQUENCING AND SCHEDULING

- A. Sequence and coordinate installation of wall handrails as follows:
 - 1. Mount handrails only on completed walls. Do not support handrails temporarily by any means not satisfying structural performance requirements.

PART 2 - PRODUCTS

2.1 FERROUS METALS

- A. Metal Surfaces, General: For metal fabrications exposed to view upon completion of the Work, provide materials selected for their surface flatness, smoothness, and freedom from surface blemishes. Do not use materials whose exposed surfaces exhibit pitting, seam marks, roller marks, rolled trade names, roughness, and, for steel sheet, variations in flatness exceeding those permitted by reference standards for stretcher-leveled sheet.
- B. Steel Plates, Shapes, and Bars: ASTM A 36.
- C. Steel Tubing: Product type (manufacturing method) and as follows:
 - 1. Cold-Formed Steel Tubing: ASTM A 500, grade as indicated below:
 - a. Grade A, unless otherwise indicated or required for design loading.
 - 2. Hot-Formed Steel Tubing: ASTM A 501.

- a. For exterior installations and where indicated, provide tubing with hot-dip galvanized coating per ASTM A 53.
 - D. Uncoated Structural Steel Sheet: Product type (manufacturing method), quality, and grade, as follows:
 - 1. Cold-Rolled Structural Steel Sheet: ASTM A 611, grade as follows:
 - a. Grade A, unless otherwise indicated or required by design loading.
 - 2. Hot-Rolled Structural Steel Sheet: ASTM A 570, grade as follows:
 - a. Grade 30, unless otherwise indicated or required by design loading.
 - E. Uncoated Steel Sheet: Commercial quality, product type (method of manufacture) as follows:
 - 1. Cold-Rolled Steel Sheet: ASTM A 366.
 - 2. Hot-Rolled Steel Sheet: ASTM A 569
 - F. Galvanized Steel Sheet: Quality as follows:
 - 1. Structural Quality: ASTM A 446; Grade A, unless another grade required for design loading, and G90 coating designation unless otherwise indicated.
 - G. Steel Pipe: ASTM A 53; finish, type, and weight class as follows:
 - 1. Black finish, unless otherwise indicated.
 - 2. Galvanized finish for exterior installations and where indicated.
 - 3. Type S, Grade A, standard weight (schedule 40), unless otherwise indicated, or another grade or weight or both required by structural loads.
 - H. Gray Iron Castings: ASTM A 48, Class 30.
 - I. Malleable Iron Castings: ASTM A 47, grade 32510.
 - J. Brackets, Flanges and Anchors: Cast or formed metal of the same type material and finish as supported rails, unless otherwise indicated.
 - K. Concrete Inserts: Threaded or wedge type; galvanized ferrous castings, either malleable iron, ASTM A 47, or cast steel, ASTM A 27. Provide bolts, washers, and shims as required, hot-dip galvanized per ASTM A 153.
 - L. Welding Rods and Bare Electrodes: Select in accordance with AWS specifications for the metal alloy to be welded.
- 2.2 STAINLESS STEEL
- A. Bar Stock: ASTM A 276, Type 302 or 304.
 - B. Plate: ASTM A 167, Type 302 or 304.

2.3 GROUT AND ANCHORING CEMENT

- A. Nonshrink Metallic Grout: Premixed, factory-packaged, ferrous aggregate grout complying with CE CRD-C 621, specifically recommended by manufacturer for heavy duty loading applications of type specified in this section.
- B. Nonshrink Nonmetallic Grout: Premixed, factory-packaged, nonstaining, noncorrosive, nongaseous grout complying with CE CRD- C 621. Provide grout specifically recommended by manufacturer for interior and exterior applications of type specified in this section.
- C. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include but are not limited to the following:
 - 1. Nonshrink Nonmetallic Grouts:
 - a. "Masterflow 713"; Master Builders.
 - b. "Sealtight 588 Grout"; W. R. Meadows, Inc.
 - c. "SonogROUT"; Sonneborn Building Products Div., Rexnord Chemical Products, Inc.
 - 2. Erosion-Resistant Anchoring Cement:
 - a. "Super Por-Rok"; Minwax Construction Products Division.

2.4 FASTENERS

- A. General: Provide zinc-coated fasteners for exterior use or where built into exterior walls. Select fasteners for the type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon head type, ASTM A 307, Grade A.
- C. Lag Bolts: Square head type, FS FF-B-561.
- D. Machine Screws: Cadmium plated steel, FS FF-S-92.
- E. Wood Screws: Flat head carbon steel, FS FF-S-111.
- F. Plain Washers: Round, carbon steel, FS FF-W-92.
- G. Drilled-In Expansion Anchors: Expansion anchors complying with FS FF-S-325, Group VIII (anchors, expansion, [nondrilling]), Type I (internally threaded tubular expansion anchor); and machine bolts complying with FS FF-B-575, Grade 5.
- H. Toggle Bolts: Tumble-wing type, FS FF-B-588, type, class, and style as required.
- I. Lock Washers: Helical spring type carbon steel, FS FF-W-84.

2.5 TRENCH FRAMES WITH GRATED COVERS

- A. Trench Frames With Grated Covers: Shall be constructed of Class 35, Gray Iron for heavy duty use equal to R-4990 series Type P as fabricated by Neenah Foundry Company.

2.6 PAINT

- A. Shop Primer for Ferrous Metal: Manufacturer's or fabricator's standard, fast-curing, lead-free, universal modified alkyd primer selected for good resistance to normal atmospheric corrosion, for compatibility with finish paint systems indicated, and for capability to provide a sound foundation for field-applied topcoats despite prolonged exposure complying with performance requirements of FS TT-P-645.
- B. Galvanizing Repair Paint: High zinc dust content paint for regalvanizing welds in galvanized steel, with dry film containing not less than 94 percent zinc dust by weight, and complying with DOD-P-21035 or SSPC-Paint-20.
- C. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12 except containing no asbestos fibers.
- D. Zinc Chromate Primer: FS TT-P-645.

2.7 CONCRETE FILL AND REINFORCING MATERIALS

- A. Concrete Materials and Properties: Comply with requirements of Division 3 section "Concrete Work" for normal weight, ready-mix concrete with minimum 28-day compressive strength of 3,500 psi.
- B. Reinforcing Bars: ASTM A 615, Grade 60, unless otherwise indicated.

2.8 FABRICATION, GENERAL

- A. Form metal fabrications from materials of size, thickness, and shapes indicated but not less than that needed to comply with performance requirements indicated. Work to dimensions indicated or accepted on shop drawings, using proven details of fabrication and support. Use type of materials indicated or specified for various components of each metal fabrication.
- B. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
- C. Allow for thermal movement resulting from the following maximum change (range) in ambient temperature in the design, fabrication, and installation of installed metal assemblies to prevent buckling, opening up of joints, and overstressing of welds and fasteners. Base design calculations on actual surface temperatures of metals due to both solar heat gain and nighttime sky heat loss.
 - 1. Temperature Change (Range): 100 deg F (55.5 deg C).
- D. Shear and punch metals cleanly and accurately. Remove burrs.
- E. Ease exposed edges to a radius of approximately 1/32 inch, unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- F. Remove sharp or rough areas on exposed traffic surfaces.

- G. Weld corners and seams continuously to comply with AWS recommendations and 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 that no roughness shows after finishing and contour of welded surface matches those adjacent.
- H. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners wherever possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.
- I. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to provide adequate support for intended use.
- J. Shop Assembly: Preassemble items in shop to greatest extent possible to minimize field splicing and assembly. 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.
- K. Cut, reinforce, drill and tap miscellaneous metal work as indicated to receive finish hardware, screws, and similar items.
- L. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.

2.9 ROUGH HARDWARE

- A. Furnish bent or otherwise custom fabricated bolts, plates, anchors, hangers, dowels, and other miscellaneous steel and iron shapes as required for framing and supporting woodwork, and for anchoring or securing woodwork to concrete or other structures. Straight bolts and other stock rough hardware items are specified in Division 6 sections.
- B. Fabricate items to sizes, shapes, and dimensions required. Furnish malleable-iron washers for heads and nuts which bear on wood structural connections; elsewhere, furnish steel washers.

2.10 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction, made flat, free from warps or twists, and of required thickness and bearing area. Drill plates to receive anchor bolts and for grouting as required. Galvanize after fabrication.

2.11 LOOSE STEEL LINTELS

- A. Fabricate loose structural steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.
- B. Weld adjoining members together to form a single unit where indicated.

- C. Size loose lintels for equal bearing of one inch per foot of clear span but not less than 8 inches bearing at each side of openings, unless otherwise indicated.
- D. Galvanize loose steel lintels located in exterior walls.

2.12 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports for applications indicated or which are not a part of structural steel framework, as required to complete work.
- B. Fabricate units to sizes, shapes, and profiles indicated and required to receive adjacent other construction retained by framing and supports. Fabricate from structural steel shapes, plates, and steel bars of welded construction using mitered joints for field connection. Cut, drill, and tap units to receive hardware, hangers, and similar items.
- C. Galvanize miscellaneous framing and supports in the following locations:
 - 1. Exterior locations.

2.13 SHELF & RELIEVING ANGLES

- A. Fabricate shelf and relieving angles from steel angles of sizes indicated and for attachment to framing. Provide slotted holes to receive 3/4 inch bolts, spaced not more than 6 inches from ends and not more than 24 inches o.c., unless otherwise indicated.

2.14 STEEL PIPE RAILINGS AND HANDRAILS

- A. General: Fabricate pipe railings and handrails to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of pipe, post spacings, and anchorage, but not less than that required to support structural loads.
- B. Interconnect railing and handrail members by butt-welding or welding with internal connectors, at fabricator's option, unless otherwise indicated.
 - 1. At tee and cross intersections, notch ends of intersecting members to fit contour of pipe to which end is joined and weld all around.
- C. Form changes in direction of railing members as follows:
 - 1. By insertion of prefabricated elbow fittings.
 - 2. By radius bends of radius indicated.
 - 3. By bending.
 - 4. By any method indicated above, applicable to change of direction involved.
- D. Form simple and compound curves by bending pipe in jigs to produce uniform curvature for each repetitive configuration required; maintain cylindrical cross-section of pipe throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of pipe.
- E. Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated.

- F. Close exposed ends of pipe by welding 3/16 inch thick steel plate in place or by use of prefabricated fittings, except where clearance of end of pipe and adjoining wall surface is 1/4 inch or less.
- G. Toe Boards: Where indicated, provide toe boards at railings around openings and at the edge of open-sided floors and platforms. Fabricate to dimensions and details indicated, or if not indicated, use 4 inches high x 1/8 inch steel plate welded to, and centered between, each railing post.
- H. Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnections of pipe and attachment of railings and handrails to other work. Furnish inserts and other anchorage devices for connecting railings and handrails to concrete or masonry work.
 - 1. For railing posts set in concrete fabricate sleeves from steel pipe not less than 6 inches long and with an inside diameter not less than 1/2 inch greater than the outside diameter of post, with steel plate closure welded to bottom of sleeve.
 - a. Provide friction fit, removable covers designed to keep sleeves clean and hold top edge of sleeve 1/2 inch below finished surface of concrete.
- I. Fillers: Provide steel sheet or plate fillers of thickness and size indicated or required to support structural loads of handrails where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses. Size fillers to produce adequate bearing to prevent bracket rotation and overstressing of substrate.
- J. For interior steel railings formed from steel pipe with black finish, provide nongalvanized ferrous metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.

2.15 STEEL FRAMED STAIRS

- A. General: Construct stairs to conform to sizes and arrangements indicated. Join pieces together by welding, unless otherwise indicated. Provide complete stair assemblies, including metal framing, hangers, columns, railings, newels, balusters, struts, clips, brackets, bearing plates, and other components necessary for the support of stairs and platforms, and as required to anchor and contain the stairs on the supporting structure.
 - 1. NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM "Metal Stair Manual" for class of stair designated, except where more stringent requirements are indicated:
 - a. Commercial class, unless otherwise indicated.
- B. Stair Framing: Fabricate stringers of structural steel channels, or plates, or a combination thereof, 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 strings, newels, and framing members to strings and headers; fabricate and join so that bolts, if used, do not appear on finish surfaces.
 - 1. Where masonry walls support steel stairs, provide temporary supporting struts designed for

erection of steel stair components before installation of masonry.

- C. Metal Pan Risers, Subtreads, and Subplatforms: Shape metal pans for risers and subtreads to conform to configuration shown. Provide thicknesses of structural steel sheet for metal pans indicated, but not less than that required, to support total design loading.
 - 1. Form metal pans of uncoated cold-rolled steel sheet, unless otherwise indicated.
 - 2. Directly weld risers and subtreads to stringers; locate welds on side of metal pans to be concealed by concrete fill.
 - 3. Provide subplatforms of configuration and construction indicated; if not indicated, of same metal as risers and subtreads, in thicknesses required to support design loading. Attach subplatform to platform framing members with welds.
- a. Smooth Soffit Construction: Construct subplatforms with smooth soffits.
- D. Stair Railings and Handrails: Comply with applicable requirements specified elsewhere in this section for steel pipe railings and handrails, and as follows:
 - 1. Railings may be bent at corners, rail returns, and wall returns, instead of using prefabricated fittings.
 - 2. Connect railing posts to stair framing by direct welding, unless otherwise indicated.

2.16 PIPE BOLLARDS

- A. Fabricate pipe bollards from Schedule 40 steel pipe. Cap bollards with 1/4 inch minimum thickness steel base plate.
- B. Fabricate sleeves for bollard anchorage from steel pipe with 1/4 inch thick steel plate welded to bottom of sleeve.

2.17 FINISHES, GENERAL

- A. Comply with NAAMM "Metal Finishes Manual" for recommendations relative to application and designations of finishes.
- B. Finish metal fabrications after assembly.

2.18 STEEL AND IRON FINISHES

- A. Galvanizing: For those items indicated for galvanizing, apply zinc-coating by the hot-dip process compliance with the following requirements:
 - 1. ASTM A 153 for galvanizing iron and steel hardware.
 - 2. ASTM A 123 for galvanizing both fabricated and unfabricated iron and steel products made of uncoated rolled, pressed, and forged shapes, plates, bars, and strip 0.0299 inch thick and heavier.
- B. 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 metal fabrications:

1. Exteriors (SSPC Zone 1B): SSPC-SP6 "Commercial Blast Cleaning."
 2. Interiors (SSPC Zone 1A): SSPC-SP3 "Power Tool Cleaning:
- C. Apply shop primer to uncoated surfaces of metal fabrications, except those with galvanized finish or to be embedded in concrete, sprayed-on fireproofing, or masonry, unless otherwise indicated. Comply with requirements of SSPC-PA1 "Paint Application Specification No. 1" for shop painting.
1. Stripe paint all edges, corners, crevices, bolts, welds, and sharp edges.

PART 3 - EXECUTION

3.1 PREPARATION

- A. Coordinate and furnish anchorages, setting drawings, diagrams, templates, instructions, and directions for installation of anchorages, including concrete inserts, sleeves, anchor bolts, and miscellaneous items having integral anchors that are to be embedded in concrete or masonry construction. Coordinate delivery of such items to project site.
- B. Set sleeves in concrete with tops flush with finish surface elevations; protect sleeves from water and concrete entry.

3.2 INSTALLATION, GENERAL

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing miscellaneous metal fabrications to in-place construction; include threaded fasteners for concrete and masonry inserts, toggle bolts, through-bolts, lag bolts, wood screws, and other connectors as required.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installation of miscellaneous metal fabrications. Set metal fabrication accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete masonry or similar construction.
- D. 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 the surfaces of exterior units which have been hot-dip galvanized after fabrication, and are intended for bolted or screwed field connections.
- E. Field Welding: Comply with AWS Code for procedures of manual shielded metal-arc welding, appearance and quality of welds made, methods used in correcting welding work, and 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 that no roughness shows after finishing and contour of welded surface matches those adjacent.
- F. Corrosion Protection: Coat concealed surfaces of aluminum that will come into contact with grout, concrete, masonry, wood, or dissimilar metals with a heavy coat of bituminous paint or zinc chromate primer.

3.3 SETTING LOOSE PLATES

- A. Clean concrete and masonry bearing surfaces of any bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of bearing plates.
- B. Set loose leveling and bearing plates on wedges, or other adjustable devices. After the bearing members have been positioned and plumbed, tighten the anchor bolts. Do not remove wedges or shims, but if protruding, cut off flush with the edge of the bearing plate before packing with grout.
 1. Use metallic nonshrink grout in concealed locations where not exposed to moisture; use nonmetallic nonshrink grout in exposed locations, unless otherwise indicated.
 2. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.4 INSTALLATION OF STEEL PIPE RAILINGS AND HANDRAILS

- A. Adjust railings prior to anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated, or if not indicated, as required by design loadings. Plumb posts in each direction. Secure posts and railing ends to building construction as follows:
 1. Anchor posts in concrete by means of pipe sleeves preset and anchored into concrete. After posts have been inserted into sleeves, fill annular space between post and sleeve solid with the following anchoring material, mixed and placed to comply with anchoring material manufacturer's directions.
 - a. Nonshrink, nonmetallic grout.
 - b. Leave anchorage joint exposed, wipe off surplus anchoring material, and leave 1/8 inch build-up, sloped away from post. For installations exposed on exterior, or to flow of water, seal anchoring material to comply with grout manufacturer's directions.
 2. Anchor posts to steel with steel oval flanges, angle type or floor type as required by conditions, welded to posts and bolted to steel supporting members.
 3. Anchor rail ends into concrete and masonry with steel round flanges welded to rail ends and anchored into wall construction with lead expansion shields and bolts.
 4. Anchor rail ends to steel with steel oval or round flanges welded to rail ends and bolted to structural steel members, unless otherwise indicated.
- B. Secure handrails to wall with wall brackets and end fittings. Provide bracket with not less than 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 and wall return fittings to building construction as follows:

5. Use type of bracket with pre-drilled hole for exposed bolt anchorage.
2. For concrete and solid masonry anchorage, use drilled-in expansion shield and either concealed hanger bolt or exposed lag bolt, as applicable.
3. For hollow masonry anchorage, use toggle bolts having square heads.

3.5 INSTALLATION OF BOLLARDS

- A. Anchor bollards in concrete by means of pipe sleeves preset and anchored into concrete. After bollards have been inserted into sleeves, fill annular space between bollard and sleeve solid with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's directions.

3.6 ADJUSTING AND CLEANING

- A. Touch-Up Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with same material as used for shop painting to comply with SSPC-PA 1 requirements for touch-up of field painted surfaces.
 1. Apply by brush or spray to provide a minimum dry film thickness of 2.0 mils.
- B. For galvanized surfaces clean welds, bolted connections and abraded areas and apply galvanizing repair paint to comply with ASTM A 780.

END OF SECTION 05500