

DIVISION 5  
METALS

## SECTION 05120: STRUCTURAL STEEL STANDARDS

## I. GENERAL (not used)

## II. MATERIALS

- A. All metal exposed to view or moisture shall be non-ferrous or heavy hot-dipped galvanized conforming to ASTM Specification A153-60. Dissimilar metals shall not touch.

## III. EXECUTION

## A. Painting

## 1. Shop Priming

- a. Galvanized metal: touch up with Galv-Weld, or equal (*second mfr must be named*).
- b. Other metal: paint one coat approved metal primer.
- c. Paint concealed areas before assembly.

## 2. Remove rust, scale, grease and oil after fabrication and before shop priming. (Refer to Section 09900 for additional information)

## 3. Field Painting: At all galvanized metal surfaces, the following procedure should be followed.

- a. Acid etch all surfaces with muriatic acid.
- b. Prime with an oil-based primer specifically intended for galvanized surfaces.
- c. Two (2) finish coats (minimum) of specified paint to be applied.

## SECTION 05500: METAL FABRICATION STANDARDS

## I. GENERAL

A. *Exterior Metal Ironwork*

1. *All exterior metal ironwork shall be heavy hot dip galvanized after fabrication. No field welding.*

B. *Exterior Handrails*

1. *Where joints are required, due to lengths too long to transport or hot dip galvanize, provide joints which allow for expansion and contraction (slip joints) and which do not require field welding or work which will disturb the hot dip galvanization.*
2. *Refer to Part VI, Detail 5.5-1.*
3. *Paint shall be avoided at exterior handrails.*
4. *Steel sleeves used in concrete for steel handrails shall be hot dip galvanized after fabrication.*

## II. MATERIALS

- A. All metal exposed to view or moisture shall be non-ferrous or heavy hot-dipped galvanized conforming to ASTM Specification A153-60. Dissimilar metals shall not touch.

## III. EXECUTION

## A. Painting:

1. Shop Priming
  - a. Galvanized metal: touch up with Galv-Weld, or equal (*second mfr must be named*).
  - b. Other metal: paint one coat of approved metal primer.
  - c. Paint concealed areas before assembly.
2. Remove rust, scale, grease, and oil after fabrication and before shop priming. (Refer to Section 09900 for additional information.)
3. Field Painting: At all galvanized metal surfaces, the following procedure should be followed.
  - a. Acid etch all surfaces with muriatic acid.
  - b. Prime with an oil-based primer specifically intended for galvanized surfaces.
  - c. Two (2) finish coats (minimum) of specified paint to be applied.