



Steelway Building Systems'
**Product Specifications
Guide**



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1.0 Scope

Standard materials furnished for Steelway Building Systems' (Steelway) steel building systems will include primary and secondary structural steel framing members, bracing, metal panels for roofing and siding, flashings, fasteners, sealants, accessories and all other miscellaneous component parts required for a complete building (with the exception of insulation, doors, windows, hardware, foundations, anchor rods and other embedded items, which are excluded). Specific items beyond the scope of standard material may also be furnished if called for by contract documents.

The product specifications in this document will outline the design criteria, material quality and fabrication processes used in steel building systems designed, manufactured and furnished by Steelway.

These product specifications are intended for use as an outline of the performance requirements for the various materials used within Steelway's steel building system. They are further intended to ensure that architects, engineers, builders and owners understand the basis for design, manufacture and application of these materials.

Engineering and mechanical properties of materials utilized by Steelway in its product line are provided or referenced within these specifications, as they are industry specification standards, where applicable.

Steelway utilizes those standards, specifications, interpretations and recommendations of professionally recognized groups and agencies, such as CSA, CWB, CISC, MBMA, AISC, AISI, AWS, ASTM, etc. as the basis in establishing its own design, fabrication and quality criteria, standards, practices, methods and tolerances.

Unless stipulated otherwise in the contract documents, Steelway's design, fabrication and quality criteria, standards, practices, methods and tolerances will govern the work.

Note - Statements, descriptions, specifications and dimensions contained herein are in effect as of the date of this issue. Steelway reserves the right to make material substitutions and changes in specifications and construction methodology as and when deemed necessary.

2.0 Design Standards

- A660, Certification of manufacturers of steel building systems
- S16, Design of steel structures
- AISI S100, North American Specification for the Design of Cold-Formed Steel Structural Members
- NRCC, National Building Code of Canada
- CISC/CPMA 2-75, A Quick-Drying Primer for Use on Structural Steel
- CSSBI 30 M Standard for Steel Building Systems
- CSSBI B8 Building Incorporating Steel Building Systems: Responsibility of Parties Involved
- CSSBI B15, Snow, Wind and Earthquake Load Design Criteria for Steel Building Systems
- CSSBI B15A, Structural and Crane Load Design Criteria for Steel Building Systems
- CSSBI S8, Quality and Performance Specification for Prefinished Sheet Used for Building Products
- CSSBI Bulletin No. 9
- W47.1, Certification of Companies for Fusion Welding of Steel
- W59, Welded Steel Construction (Metal Arc Welding)
- W48, Filler metals and allied materials for metal arc welding

3.0 Product Standards

3.1 Plate, Coil and Hot-Rolled

- CSA G40.20/G40.21, General requirements for rolled or welded structural quality steel/Structural quality steel
- ASTM A529/A529M, High-Strength Carbon-Manganese Steel of Structural Quality
- ASTM A572/A572M, High-Strength Low-Alloy Columbium-Vanadium Structural Steel
- ASTM A653/A653M, Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process
- ASTM A792/A792M, Steel Sheet, 55% Aluminum-Zinc Alloy-Coated by the HotDip Process
- ASTM A992/A992M, Steel Structural Shapes
- ASTM A1011/A1011M, Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low Alloy, High-Strength Low-Alloy with Improved Formability and Ultra-High Strength

3.2 Bolts and Fasteners

- ASTM 325M, Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength
- ASTM A490, Structural Bolts, Alloy Steel, Heat Treated, 150 ksi Minimum Tensile Strength
- SAE J429 – Grade 8.2, Low Carbon Martensite Steel, Quenched and Tempered

4.0 System Description

- Type: rigid frame or beam and column with vertically braced bays as indicated.
- Roof Slope: minimum 1:48 or as indicated on drawings.
- Wall System: through fastened or concealed fastener, single skin.
- Roof System: fully thermally broken standing seam, concealed fastener, single skin or through fastened roof, single skin.
- Stand-Off System: notched zee, hat and chair or metal capped thermal block.
- Liner System: through fastened, single skin.

5.0 Design Criteria

- Design the steel building system to withstand live loads and dead loads including ceilings, mechanical and electrical systems, as indicated.
- Design the building walls and roof to allow for thermal movement of component materials caused by ambient temperature range from -40 deg C (-40 deg F) to +40 deg C (104 deg F) without buckling, failure of joint seals, undue stress on fasteners or other detrimental effects.
- The building shall be weathertight.

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- Design the building enclosed components to accommodate, by means of expansion joints and clips, any movement in the component itself and between the component and building structure caused by structural movements without permanent distortion, breakage of seals or water penetration.
- Refer to drawings and A660 Certificate of Design and Manufacturing Conformance for additional design criteria.

6.0 Source Quality Control

- Provide a certificate that the steel building system manufacturer is certified to CSA-A660, latest edition.

7.0 Drawings

- Submit erection drawings bearing the stamp and signature of a professional engineer registered in the province/state in which the building is to be erected.
- Submit the following documents in accordance with the CSSBI 30 M paragraph 13; erection drawings showing foundation loads, anchor rod setting details, part numbers, connections and assembly details.
- Indicate plans and grid lines, structural members and connection details, bearing and anchorage details, roof cladding, wall cladding, framed openings, camber (as required), loads and reaction forces, fasteners and field welds (as required), sealant locations and details.
- Indicate shop and erection details including cuts, copes, connections, holes, threaded fasteners, rivets and welds.
- Indicate on erection drawings related provisions required for mechanical, electrical and other work, when such information can be supplied to Steelway at time of the initial order.

8.0 Certification

- Submit A660 Certificate of Design and Manufacturing Conformance stating design criteria used and loads assumed in design. Certificate shall be stamped and signed by a professional engineer registered in the province/state in which the building is to be erected.
- Provide documentation to show steel building systems manufacturer is certified under CSA W47.1, Division 1 or 2.1, for welded fabrication.

9.0 Protection - Factory/Site

- Protect pre-finished steel sheet during fabrication, transportation, site storage and installation in accordance with CSSBI Bulletin No. 9.
- Handle and protect galvalume materials from damage to zinc/aluminum coating. During storage, separate surfaces of galvalume materials to permit free circulation of air.
- Provide protection from weather to all primary and secondary steel components if stored on site by means of properly secured tarps. Components should be prevented from prolonged contact to the ground by means of adequately spaced blocking. Ensure that no ponding occurs.
- Avoid incurring undue stresses on building components from lifting or twisting during building erection.

10.0 Performance Testing Compliance

10.1 Standing Seam Roof System

- Underwriters Laboratories Inc. – U.L. Class 90 rating
- Corps of Engineers Uplift Test – ASTM E1592, 156 psf mean ultimate load obtained
- Factory Mutual Research Corporation – FM4477 Uplift Test – 1-60 and 1-90 rating
- ASTM Air and Water Penetration Testing – ASTM E1680 Air Infiltration – ASTM E1645 Water Leakage

10.2 Through Fastened Roof and Wall Systems

- Underwriters Laboratories Inc. – U.L. Class 90 rating
- Diaphragm tests – ASTM E455

10.3 Architectural/Self-Framing Wall Systems

- Diaphragm testing – ASTM E455
- Compression testing – ASTM E72-98

10.4 Composite Deck Slab Systems

- CSSBI S3 - Criteria for Testing Composite Slabs
- ANSI/ASCE 3 – Standard for the Structural Design of Composite Slabs

11.0 Materials

11.1 Primary Structural

- Bar and plate welded sections: to CSA G40.20/G40.21, Type W, ASTM A572/A572M, A529/A529M, A1011/A1011M, HSLAS or SS, 50 ksi (350/345/340 MPa) minimum yield.
- Hot rolled beam, angle, channel: to G40.20/G40.21, Type W, ASTM A992/A992M, A572/A572M, A529/A529M, 50 ksi (350/345 MPa) minimum yield.
- Hot rolled HSS: to G40.20/G40.21, Type W, Class C, 50 ksi (350 MPa).
- Welded Materials: CSA W48 and W59.
- Surface preparation to SSPC-SP1, SP2 OR SP3 as required.
- Shop Primer Paint: Single Coat Grey Oxide Primer to CISC/CPMA Standard 2-75, 1.5 to 2 mils film thickness. Standard primer not to exceed 90 days exposure to weather. Hot dip galvanized or epoxy paint available upon request (extra).
- Bolts: ASTM A325M (ASTM A490M when required) complete with nuts and washer, plain. Hot dip galvanized (A325 only), F1136 ZC grade 3 (A490 only) available upon request (extra).
- Anchor Rods: G40.20/G40.21, ASTM A572/A572M, A529/A529M, 50 ksi (350/345 MPa) minimum yield, plain (no coating). Hot dip galvanized available upon request (extra).

11.2 Secondary Structural

- Purlins, Girts and Framed Openings: minimum 16 gauge (0.060 inch/1.52 mm), Hot Rolled Sheet Steel conforms to G40.21, ASTM A653/A653M, A1011/A1011M, HSLAS Class 1 or 2, or SS, 55 ksi (380 MPa) minimum yield.
- Shop Primer Paint: Single Coat Grey Oxide Primer to CISC/CPMA Standard 2-75, 1.5 to 2 mils film thickness. Grey Powder Coat Primer (hybrid), 1.5 mils film thickness. Standard primer not to exceed 90 days exposure to weather.
- Bolts: to SAE J429 Grade 8.2.

11.3 Bracing Systems

- Purlin/Girt Stabilizers: Minimum 16 gauge (0.060 inch/1.52 mm) zee section stabilizers factory cut and pre-packaged shall be provided between purlins/girts to stabilize top and bottom flanges on all roofs with standing seam panels and clips. Number of rows per bay to be determined by design. Hot Rolled Sheet Steel conforms to G40.21, ASTM A653/A653M, A1011/A1011M, HSLAS Class 1 or 2, or SS, 55 ksi (380 MPa) minimum yield. Z275 (G90) pre-galvanized coil.
- Flange brace: to G40.21, ASTM A653/A653M, A1011/A1011M, HSLAS Class 1 or 2, or SS, 55 ksi (380 MPa) minimum yield. Z275 (G90) pre-galvanized coil.
- Rod: to G40.21, ASTM A572/A572M, A529/A529M, 50 ksi (350/340 MPa) minimum yield, shop primed with single coat Grey Oxide Primer to CISC/CPMA Standard 2-75, 1.5 to 2 mils film thickness.
- Cable: Galvanized strand to ASTM A475, Grade EHS, 7 wire strand, Class A coating (CSA G12). Design strength based on Steelway's published breaking strengths.
- Eye bolts: Forged, 1030 carbon steel, hot dip galvanized. Design strengths based on Steelway's published breaking strengths.
- Hillside/Sloped Washers: to ASTM A-47, galvanized to A153
- Bracer Hillside Washers: to ASTM 526, grade 65, gray enamel or hot dip galvanized to A153, class A.

11.4 Roof and Floor Deck Systems

- Sheet Steel: 22 gauge (0.030 inch/0.76 mm) minimum standard factory pre-formed sheet steel galvanized coating, composite or non-composite embossments.
- Steel Sheet, Zinc-Coated or Aluminum-Zinc Coated: to ASTM A653/A653M, A792/A792M, structural quality, class 1 or 4, Grade 33 (230 MPa) with ZF75/Z275 for ASTM A653/A653M or AZM150 for ASTM A792/A792M.
- Mechanically Fastened or welded: 22 gauge (0.030inch/0.76 mm) panel minimum, 1.5 inch (38 mm) deep profile, 36 inch (914 mm) coverage. Major corrugations at 6 inch (152 mm) on centre, structural bearing side edge for stable sidelap and clinching.

11.5 Cladding Systems

- Pre-finished System for Steel Sheet Exposed to Exterior: Aluminum-zinc coated material with factory applied paint system:
 - Insulation and Tape: as recommended by Steelway.
 - Insulation Adhesive: purpose made for insulation type and steel liner sheet, incombustible after initial set.
 - Vapor Barrier and Sealing Tape: as recommended by insulation supplier.
 - Sealant: as recommended by Steelway.

11.6 Roof Cladding Systems – Exterior

- Sheet Steel: 26 gauge (0.018 inch/0.46 mm) minimum standard factory pre-formed steel sheet aluminum-zinc coated to match existing, pre-finished profile. Include closures, gaskets, caulking, flashing and fasteners to effect weather tight installation.
- Steel Sheet, Aluminum-Zinc Coated: to ASTM A792/A792M, structural quality, class 1 or 4, Grade 50 (340 MPa) with AZM165 Galvalume Plus coating, regular spangle surface, passivated for unpainted finish and AZM150 unpassivated for paint finish.
- Paint System:
 - exterior – Standard 20000 series colours, use a Silicone Modified Polyester paint system
 - interior – washcoat (minimum)
- Colour: choose from manufacturers Standard Series 20000.
- Screws: corrosion resistant purpose made, head colour to match cladding.
- Through Fastened: 26 gauge (0.018 inch/0.46 mm) panel minimum, 1.5 inch (38 mm) deep profile, 36 inch (914 mm) coverage. Major corrugations at 12 inch (305 mm) on centre, shallow corrugations in panel flat. Structural bearing side edge for stable sidelap.
- Standing Seam: 24 gauge (0.024 inch/0.61 mm) panel minimum, 3 inch (76 mm) raised panel seams, 24 inch (610 mm) coverage. Major corrugations at 24 inch (610 mm) on centre, shallow corrugations in panel flat. Factory applied mastic for sidelap, pre-punched and factory notched.
- Standing Seam Panel Thermal Clips and Related Panel Fasteners: extra heavy duty, 20 gauge (0.036 inch/0.91 mm), corrosion resistant, purpose made clips with movable tabs. Spacing of clips and fasteners to be Steelway's design to suit the loads indicated. Floating clips to allow the roof a 3.5 inch (89 mm) range of thermal movement (1¾inch (44 mm) of expansion and 1 ¾ inch (44 mm) of contraction).
- Thermal Block Spacers: continuous 1 inch (25 mm) thick, extruded polystyrene meeting CAN/CGSB-51.20-M87, Type 4, 210 KPa compressive strength.

11.7 Roof Trim System

- Accessories to Roof Cladding: brake or bend to shape, the material and finish to match roof cladding or wall cladding where applicable, comprising cap flashing, drip flashing, coping and closures for corners, soffit and fascia.
- Ridge Cap: brake or bend to shape, 26 ga (0.018 inch/0.46mm) minimum, colour to suit roof cladding or as specified.
- Gutters: 26 gauge (0.018 inch/0.46 mm) factory brake formed, material and finish to match roof or wall cladding. Include brackets, fasteners, end caps and closures as required.
- Downspouts: Available in QC8273 Bone White or QC8229 Dark Brown, 10' lengths.
- Downspout Elbows: Available in QC8273 Bone White or QC8229 Dark Brown, 135° only.

11.8 Roof Cladding Systems – Interior Liners

- Sheet Steel: 29 gauge (0.014 inch/0.34 mm) minimum standard factory pre-formed steel sheet aluminum-zinc coated to match existing, pre-finished profile. Include closures, gaskets, caulking, flashing and washered fasteners when specified.
- Steel Sheet, Aluminum-Zinc Coated: to ASTM A792/A792M structural quality Grade 33 (230 MPa), 37 (255 MPa), 50 (350 MPa) or Grade 80 (544 MPa) with AZM165 Galvalume Plus coating, regular spangle surface, passivated for unpainted finish and AZM150 unpassivated for paint finish.
- Through Fastened Panel: 28 gauge (0.015 inch/0.38 mm) panel minimum, 1.5 inch (38 mm) deep profile, 36 inch (914 mm) coverage. Major corrugations at 12 inch (305 mm) on centre, shallow corrugations in the panel flat.
- Through Fastened Panel: 29 gauge (0.014 inch/0.34 mm) panel minimum, 0.625 inch (16 mm) deep profile, 36 inch (914 mm) coverage. Major corrugations at 6 inch (152 mm) on centre, shallow corrugations in the panel flat.

11.9 Roof Stand-off Systems

- Notched Zee: 16 gauge (0.06 inch/1.52 mm) minimum, factory notched zee to suit the liner profile. The depth must suit the insulation value required. Hot Rolled Sheet Steel conforms to G40.21, ASTM A1011/A1011M, A653/A653M, HSLAS or SS, Class 1 or 2, 55 ksi (380 MPa) minimum yield, galvanized to G90. Include the required fasteners.
- Hat and Chair: 16 gauge (0.060 inch/1.52 mm) minimum, brake formed to suit the liner profile. The depth must suit the insulation value required. Hot Rolled Sheet Steel conforms to G40.21, ASTM A1011/A1011M, A653/A653M, HSLAS or SS, Class 1 or 2, 55 ksi (380 MPa) minimum yield, galvanized to G90. Include the required fasteners.

11.10 Wall Cladding Systems - Exterior

- Sheet Steel: factory preformed steel sheet, 29 gauge (0.015 inch/0.34 mm) minimum base metal thickness aluminum-zinc coated pre-finished must match the existing profile. Include closures, gaskets, caulking, flashing and fasteners to effect a weather tight installation.
- Steel Sheet, Aluminum-Zinc Coated: must adhere ASTM A792/A792M structural quality Grade 33 (230 MPa), 37 (255 MPa), 50 (350 MPa) or Grade 80 (544 MPa) with AZM165 Galvalume Plus coating, regular spangle surface, passivated for unpainted finish and AZM150 unpassivated for paint finish.
- Steel Sheet, Zinc-Coated or Aluminum-Zinc Coated: must adhere to the ASTM A653/A653M, structural quality, class 1 or 4, Grade 37 (255 MPa) with ZF75/Z275 for ASTM A653/A653M or with AZM165 Galvalume Plus coating, regular spangle surface, passivated for unpainted finish and AZM150 unpassivated for paint finish.
- Paint System: Exterior – Series 20000, interior – washcoat (minimum)
- Colour: choose from manufacturers Standard Series 20000.
- Screws: corrosion resistant purpose made, head colour to match cladding.
- Through Fastened Panel: 26 gauge (0.018 inch/0.46 mm) panel minimum, 1.5 inch (38 mm) deep profile (standard or reversible face (wide rib out)), 36 inch (914 mm) coverage. Major corrugations at 12 inch (305 mm) on centre, shallow corrugations in panel flat. Structural bearing side edge for stable sidelap
- Through Fastened Panel: 29 gauge (0.015 inch/0.34 mm) panel minimum, 0.625 inch (16 mm) deep profile (standard or reversible face (wide rib out)), 36 inch (914 mm) coverage. Major corrugations at 6 inch (152 mm) on centre, shallow corrugations in panel flat.
- Concealed Fastener Panel: 26 gauge (0.018 inch/0.46 mm) panel minimum, 3 inch (76 mm) deep profile, flat face or sculptured, 16 inch (406 mm) coverage, embossed finish (optional).

11.11 Wall Trim System

- Exterior Corners: the material must match the finish and profile of adjacent cladding material, shop cut and brake formed to the correct angle.
- Accessories to Exterior Wall Cladding: brake or bend shape, of material and finish to match wall cladding, consisting of cap flashings, drip flashings, corner flashings, header, jamb and sill trims. Closures to be foam (grey only) or metal (colour and material to match wall cladding). All trim material is to be pre-finished 26 gauge (0.018 inch/0.46 mm) minimum.
- Foam closures: Cross-linked polyethylene with UV stabilizers. Field applied tape sealant as required.
- Downspouts: 26 gauge (0.018 inch/0.46 mm) factory brake formed, material and finish to match wall cladding. 28 gauge (0.015 inch/0.38 mm) minimum, roll formed, aluminum alloy #3105-H14 (Dark Brown QC8229, Bone White QC8273).

11.12 Wall Cladding Systems – Interior Liners

- Steel: 29 gauge (0.014 inch/0.34 mm) minimum standard factory pre-formed steel sheet aluminum-zinc coated to match the existing, pre-finished profile. Include closures, gaskets, caulking, flashing and washered fasteners when specified.
- Steel Sheet, Aluminum-Zinc Coated: adhere to ASTM A792/A792M, structural quality Grade 33 (230 MPa), 37 (255 MPa), 50 (350 MPa) or Grade 80 (544 MPa) with AZM165 Galvalume Plus coating, regular spangle surface, passivated for unpainted finish and AZM150 unpassivated for paint finish.
- Through Fastened: 28 gauge (0.015 inch/0.38 mm) panel minimum, 1.5 inch (38 mm) deep profile, 36 inch (914 mm) coverage. Major corrugations at 12 inch (305 mm) on centre, shallow corrugations in panel flat.
- Through Fastened (low profile): 29 gauge (0.014 inch/0.34 mm) panel minimum, 0.625 inch (16 mm) deep profile, 36 inch (914 mm) coverage. Major corrugations at 6 inch (152 mm) on centre, shallow corrugations in panel flat.
- Through Fastened (low profile): 26 gauge (0.018 inch/0.46 mm) panel minimum, 1.21 inch (307 mm) deep profile, 32 inch (813 mm) coverage. Major corrugations at 32 inch (813 mm) on centre, shallow corrugations in panel flat, factory applied side lap sealant. Panel used as wall vapour barrier with notched zee stand-off system.

11.13 Wall Stand-off Systems

- Notched Zee: 16 gauge (0.06 inch/1.52 mm) minimum, factory notched zee to suit liner profile. Depth must suit the insulation value required. Hot Rolled Sheet Steel conforms to G40.21, ASTM A1011/A1011M, A653/A653M, HSLAS or SS, Class 1 or 2, 55 ksi (380 MPa) minimum yield, galvanized to G60 (minimum). Include required fasteners.
- Metal Capped Thermal Block: 18 gauge (0.048 inch/1.21 mm) minimum factory applied metal cap to ASTM-A 446 grade "A", galvanized steel ASTM-A 525M Z275. Close-cell polystyrene, compressive strength 30 psi (207 kPa). Thermal resistance to ASTM C518-70, RSI 1.74. Include required fasteners.

11.14 Fasteners

- Exposed fasteners are to match adjacent panel colours with the exception being galvalume panels which use Bone White fasteners. Exposed fasteners are to be a nylon or painted steel head to resist corrosion. Washered fasteners are to be used on outer roofing, non-washered fasteners are to be used on outer wall siding. Non-washered fasteners are to be used on liner cladding unless specified otherwise.

12.0 Fabrication

- Fabricate structural members in accordance with shop drawings and to S16 (CSA). Tolerance not to exceed those specified in CSSBI 30 M.
- Provides holes for attachment of other work, as indicated.

13.0 Shop Painting

- Clean, prepare surfaces and shop prime structural steel to S16 (CSA) except where members are zinc coated or zinc-aluminum alloy coated or to be encased in concrete.

14.0 Execution

14.1 Erection

- Perform work in accordance with CSSBI Standard for Steel Building Systems 30 M except where specified otherwise.
- Erect structural framing in accordance with erection drawings and to S16 (CSA). Erection tolerances are not to exceed those specified in CSSBI 30 M.
- Obtain written permission from Steelway prior to field cutting or altering of structural members.
- Touch up with shop primer bolts, rivets, welds, and burned or scratched surfaces where the exterior exposed is at completion of the erection.

14.2 Wall Cladding

- Install wall cladding assemblies ensuring a complete installation.
- Secure to structural wall supports.

14.3 Roof Cladding

- An Erector must be completely familiar with Steelway's products prior to installation. All related erection drawings, details and manuals must be reviewed prior to commencing work.
- Ensure the building is square and plumb before cladding installation. Secure sheets to structural purlins as indicated on erection drawings and details. Terminate sheet ends over structural supports.
- Secure and continuously seal side and end laps. Apply all caulking and closures as per erection details and Steelway's supplied erection manuals.
- Install roof assemblies ensuring a complete and watertight installation.

14.4 Liner Sheets

- Install all necessary closures, gaskets, caulking sealants and flashing as recommended by Steelway, when specified.

14.5 Roof and Floor Decking

- The Erector must ensure they are completely familiar with products prior to installation. All related erection drawings, details and manuals must be reviewed prior to commencing work.
- Ensure the building is square and plumb before decking installation. Secure sheets to structural purlins or OWSJ as indicated on erection drawings and details. Terminate sheet ends over structural supports.
- Secure decking to supports using screws or welds as per the details provided. Clinch side laps as per details provided.
- Ensure shoring requirements are followed for the applicable deck profiles, spans and concrete thickness.