

## CURVED ALUMINUM STAIRS

### MATERIALS-ALUMINUM

- A. Extruded Shapes & Bars--Alloy 6061-T6
- B. Bolts, Nuts, Washers 304 Stainless Steel
- C. Concrete Anchors 304 Stainless Steel
- D. Grating- Aluminum Serrated Swage Locked Grating
- E. Nosings- Aluminum Extruded Re-enforced profile with non-slip ribs

### FABRICATION

- A. Brackets:
  - 1. Will bolt directly to tank wall and require no additional holes or welding to tank wall
- B. Stair:
  - 1. Stringers and treads will be fit and shop assembled with stainless steel bolts in 15 to 20 foot sections to conform to tank radius
- C. Platforms:
  - 1. Where indicated will be shop assembled in largest practical sections
  - 2. Weld corners and seams continuous complying with AWS recommendations at exposed connections, grind exposed welds smooth and flush.
- D. Finish:
  - 1. Aluminum stairs and treads to be mill finish.
- E. Standards:
  - 1. Complies with OSHA codes.
  - 2. Designed to support a superimposed live load of 100 psf.

### MANUFACTURER

Breuer Metal Craftsmen Inc.  
500 Beichl Ave.  
Beaver Dam, WI 53916

920-885-2828 [www.breuermetal.com](http://www.breuermetal.com)

## ALUMINUM HANDRAILS

### MATERIALS

- A. Posts --- 1-1/2" SCH80 6005-T5 Aluminum Pipe  
Horizontals- 1-1/2" SCH40 6005-T5 Aluminum Pipe
- B. Toe Plate- 4" where required
- C. All Hardware- 304 Stainless Steel
- D. Post Base Flanges - 3/8 Stainless Steel Plate with an internal Stainless Steel Pipe
- E. Post Spacing- Not to exceed 5'-0"

### FABRICATION

- A. 3'-6" High guardrail shall be provided on both sides of stairs.
- B. All joints machine coped and continuously TIG welded with smooth welds.
- C. Fabricated to match stair rise and tank radius in 15-20 foot sections.
- D. Finished:
  - 1. All handrails to be clear anodized after fabrication
- E. Standards:
  - 1. Complies with OSHA codes.
  - 2. Designed for 200 pound load.

### MANUFACTURER

Breuer Metal Craftsmen Inc.  
500 Beichl Ave.  
Beaver Dam, WI 53916

920-885-2828 [www.breuermetal.com](http://www.breuermetal.com)