

# Standard for Steel Roof Deck

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HISTORICAL REFERENCE ONLY  
OBSOLETE



CANADIAN  
**SHEET STEEL**  
BUILDING INSTITUTE

## PREFACE

One of the objects of the Canadian Sheet Steel Building Institute is the development of product standards to promote safety and sound construction practices. This Standard is intended to assist specifiers, designers, buyers, fabricators and erectors of steel roof deck by providing information which can be adopted by reference where desired.

The requirements contained herein are in accordance with sound engineering principles, augmented by experience. They include recommended minimum requirements for grade of steel, base steel nominal thickness, coating designation, loads, resistances and deflections, as well as design, fabrication and erection in general.

Steel roof deck is a basic component of the overall roof system which normally would also include the roof framing, the various roofing materials, and other items necessary to provide a complete assembly. A compatible relationship between the various roof system components is an important consideration when job plans and specifications are being developed. It is hoped that this *Standard for Steel Roof Deck* will provide useful guidance to designers and specifiers, as well as to suppliers and trades involved in roof construction.

# CONTENTS

	Page
1. SCOPE	1
2. GENERAL	1
3. DEFINITIONS	1
4. SHEET STEEL REQUIREMENTS	
4.1 Materials	1
4.2 Nominal Thickness Limitation	1
4.3 Minimum Base Steel Thickness	1
4.4 Metallic Coatings	1
5. FABRICATION	
5.1 General	2
5.2 Tolerances	2
6. COLLATERAL MATERIALS	
6.1 General	2
6.2 Vapour Retarder	2
6.3 Insulation	2
6.4 Sheet Metal Work	2
6.5 Field Painting	2
7. SAFETY DURING ERECTION	2
8. GUIDE SPECIFICATION FOR STEEL ROOF DECK	
8.1 General Conditions	2
8.2 Work Included	2
8.3 Work Not Included	3
8.4 Materials	3
8.5 Drawings	3
8.6 Design	3
8.7 Erection	4
8.8 Limitations	5
8.9 Access	5
8.10 Storage of Materials on Site	5
8.11 Cleanup	6

## REFERENCE PUBLICATIONS

This Standard makes reference to the following:

**Canadian Sheet Steel Building Institute (CSSBI)**

- 101M Specification for Zinc Coated Structural Quality Steel Sheet for Steel Deck.
- 201M Specification for Aluminum-Zinc Alloy (AZ) Coated Structural Quality Steel Sheet for Steel Deck.
- 301M Specification for Electrolytic Zinc Coated, Chromate Treated, Structural Quality Steel Sheet for Steel Deck.

**Canadian Standards Association (CSA)**

CAN3-S136 Cold Formed Steel Structural Members.

- W47.1 Certification of Companies for Fusion Welding of Steel Structures.

# STANDARD for STEEL ROOF DECK

## 1. SCOPE

- 1.1 This Standard covers the design, fabrication and erection of steel roof deck intended for use with appropriate roofing materials installed on top of the deck.
- 1.2 This Standard applies to roof deck sections formed from metallic coated steel sheet which have:
  - (a) a nominal depth not greater than 77 mm;
  - (b) a nominal flute spacing not greater than 200 mm;
  - (c) a flute width not greater than 75 mm;
  - (d) a flat top width between flutes not less than 75 mm; and
  - (e) side laps to interconnect adjacent parallel units.
- 1.3 This Standard is not intended to apply to prefinished or factory post-painted steel roof deck without appropriate modifications in respect of fabrication, handling, transportation, storage, erection, and method of attachment to the supporting structure.

## 2. GENERAL

- 2.1 This Standard is to govern in those cases where the provisions of building codes, architects' plans and specifications are not specific. In the event of any conflict between this Standard and any legal regulations, such regulations shall apply and this Standard shall only amplify, as applicable.
- 2.2 Where reference is made to another publication, such reference shall be considered to refer to the latest revision or edition approved by the organization issuing that publication, unless otherwise noted.
- 2.3 When details of design are not clearly specified in the plans and specifications furnished by the Buyer, the Fabricator shall furnish all materials required in accordance with the current specifications and standards of the Canadian Sheet Steel Building Institute (CSSBI).
- 2.4 Supplementary rules or requirements may be necessary for specific applications such as insulated roof membrane assemblies, diaphragm action to resist in-plane shear forces, composite slab roofs, and roofs which will be subjected to heavy moving loads.

## 3. DEFINITIONS

- 3.1 **Buyer** means the person, firm or company contracting with the Fabricator or Erector for the supply and installation of steel roof deck.

- 3.2 **Erector** means an erector of steel roof deck, who may also be a fabricator.
- 3.3 **Fabricator** means a fabricator of steel roof deck.
- 3.4 **Roofing Materials** include vapour retarder, insulation, felts, sheathing, gravel, concrete, gypsum thermal barrier, and other materials placed on top of the steel roof deck as roofing, including related adhesives and mechanical fasteners.
- 3.5 **Span** of steel roof deck means the lesser of:
  - (a) the distance centre to centre of structural supports; or
  - (b) the clear distance between structural supports plus the depth of the deck.
- 3.6 **Thickness** of sheet steel used for steel roof deck means the base steel thickness, exclusive of any coatings. **Nominal Thickness** means the representative base steel thickness used to establish section properties of the deck. **Minimum Thickness** means the least thickness obtained by measurement at any point located at least 10 mm from an edge or corner bend.

## 4. SHEET STEEL REQUIREMENTS

- 4.1 **Materials**

Sheet steel used for steel roof deck shall conform to one of the following material specifications:

  - (a) CSSBI 101M *Zinc Coated Structural Quality Steel Sheet for Steel Deck*;
  - (b) CSSBI 201M *Aluminum-Zinc Alloy (AZ) Coated Structural Quality Steel Sheet for Steel Deck*; or
  - (c) CSSBI 301M *Electrolytic Zinc Coated, Chromate Treated, Structural Quality Steel Sheet for Steel Deck*.
- 4.2 **Nominal Thickness Limitation**

The nominal base steel thickness of sheet used for roof deck shall not be less than 0.76 mm.
- 4.3 **Minimum Base Steel Thickness**

The minimum base steel thickness (excluding any coatings) of sheet used for roof deck shall not be less than the specified nominal base steel thickness minus the permissible negative deviation (under tolerance).
- 4.4 **Metallic Coatings**
  - 4.4.1 The minimum metallic coating designations for steel roof deck not exposed in service to the weather are ZF75 (zinc-iron alloy coat) for CSSBI 101M material, AZ150 (aluminum-zinc alloy coat) for CSSBI 201M material, and ZincGuard

102-C (minimum 31.1 g/m<sup>2</sup> zinc coating, total both sides, chromate treated) for CSSBI 301M material.

- 4.4.2 The minimum metallic coating designations for steel roof deck exposed in service to the weather are Z275 (zinc coating) for CSSBI 101M material and AZ150 (aluminum-zinc alloy coating) for CSSBI 201M material.

## 5. FABRICATION

### 5.1 General

Steel roof deck shall be fabricated in accordance with the applicable requirements of CAN3-S136 *Cold Formed Steel Structural Members*.

### 5.2 Tolerances

- 5.2.1 Upon completion of fabrication, the depth of steel roof deck shall not be more than 1 mm under the design depth.
- 5.2.2 Upon completion of fabrication, the cover width of steel roof deck shall not exceed the design width by more than 10 mm per metre of width.

## 6. COLLATERAL MATERIALS

### 6.1 General

Collateral materials are items such as vapour retarder, thermal barrier, insulation, waterproofing membrane, and related sheet metal work normally supplied by parties other than the Fabricator and/or Erector. This Standard is not intended to encroach upon the standard practices of suppliers of collateral materials and related trades, but is intended only to supplement and amplify such practices.

### 6.2 Vapour Retarder

A vapour retarder is required for the majority of applications.

### 6.3 Insulation

Steel roof deck shall be insulated with a suitable insulating material of sufficient thermal resistance to prevent condensation under normal occupancy conditions. Additional insulation, beyond this minimum requirement, is usually desirable for thermal efficiency. Insulation shall be properly installed.

### 6.4 Sheet Metal Work

All sheet metal work, such as flashings, shall be detailed and furnished by others unless otherwise specified.

### 6.5 Field Painting

Any field painting is the responsibility of the Buyer who should check with the paint supplier for the proper paint type and

application procedures. It is recommended that following installation ZF75 (zinc-iron alloy coated) and ZincGuard 102-C (electrogalvanized, chromate treated) material be painted without delay with a good quality paint suitable for the exposure condition.

## 7. SAFETY DURING ERECTION

- 7.1 Minimum safety requirements for steel roof deck erection are outlined in 7.2 to 7.6 inclusive. In the event of any conflict between these requirements and any legal regulations, such regulations shall apply and these requirements shall only amplify.
- 7.2 All steel roof deck being hoisted to the working level shall be adequately banded and carefully slung employing steel wire rope and using a choker type sling or multi-lift beams.
- 7.3 All bundles shall be tag lined during the ascent of the hoisting operation. Bundles shall be placed so as to avoid overloading the supporting structure.
- 7.4 All steel roof deck sheets after being laid and aligned, shall be properly secured in place prior to leaving the jobsite at the end of a working day.
- 7.5 All loose bundles of steel roof deck sheets shall be secured at the completion of each working day.
- 7.6 All steel roof deck cuttings, strapping, packaging material, and other debris pertaining to steel roof deck shall be removed from the roof area and lowered to the ground at the completion of each working day.

## 8. GUIDE SPECIFICATION FOR STEEL ROOF DECK

### 8.1 General Conditions

The General Conditions shall apply.

### 8.2 Work Included

- 8.2.1 Furnish all labour, materials and equipment necessary to fabricate and, where shown or called for by the tender documents, hoist into position and erect the steel roof deck.
- 8.2.2 Supply and install accessories where shown or called for by the tender documents (e.g. *cell closures*).
- 8.2.3 Cut and reinforce holes and openings up to 450 mm across the flutes. Cut only, holes and openings larger than 450 mm across the flutes, where shown or called for by the tender documents.

### 8.3 Work Not Included

- 8.3.1 Reinforcing or structural framing of openings larger than 450 mm across the flutes.
- 8.3.2 Field painting including touch-up to the underside of top chords or flanges of supporting steel members where discolouration due to welding has occurred.
- 8.3.3 Mechanical clips, nails, adhesives or other fasteners for securing insulation, thermal barrier, or vapour retarder to steel roof deck.
- 8.3.4 Cutting and drilling of holes for the attachment of suspended ceiling hangers, or for attachment of any work of other trades.
- 8.3.5 Bearing plates, shelf angles, and other structural steel required to support the steel roof deck.
- 8.3.6 Wood nailers, cants, vapour retarder, insulation, thermal barrier, waterproofing membrane, and ballast.
- 8.3.7 Architectural trim.

### 8.4 Materials

- 8.4.1 Steel roof deck shall be formed of metallic coated sheet steel conforming to one of the following specifications:
  - (a) CSSBI 101M *Zinc Coated Structural Quality Steel Sheet for Steel Deck*, minimum Grade A with a base steel nominal thickness of 0.76 mm or greater and a minimum zinc coating designation of ZF75;
  - (b) CSSBI 201M *Aluminum-Zinc Alloy (AZ) Coated Structural Quality Steel Sheet for Steel Deck*, minimum Grade 230 with a base steel nominal thickness of 0.76 mm or greater and a minimum aluminum-zinc alloy coating designation of AZ150; or
  - (c) CSSBI 301M *Electrolytic Zinc Coated, Chromate Treated, Structural Quality Steel Sheet for Steel Deck*, minimum Grade C with a base steel nominal thickness of 0.76 mm or greater and a minimum zinc coating designation of ZincGuard 102-C (minimum 31.1 g/m<sup>2</sup> zinc coating, total both sides, chromate treated).

**NOTE:** Specification writer may specify a heavier base steel nominal thickness and/or a heavier metallic coating to satisfy any special requirements.

### 8.5 Drawings

- 8.5.1 The Buyer shall provide complete architectural plans, specifications, and approved structural support spacings, correctly dimensioned.
- 8.5.2 The Erector shall submit . . . copies of erection drawings for approval. The Buyer shall return one copy with his approval, or with such corrections as he may deem necessary.
- 8.5.3 Erection drawings shall show clearly the location of various sheet lengths, sheet quantities, thicknesses, and metallic coating designations.
- 8.5.4 When changes are made by the Buyer, the cost of such changes shall be the basis for re-negotiating the contract.

### 8.6 Design

- 8.6.1 In the absence of laws, regulations, ordinances and specifications to the contrary, structural design of the steel roof deck shall be in accordance with 8.6.2 to 8.6.9 inclusive.
- 8.6.2 Structural properties and member resistances shall be calculated in accordance with CAN3-S136 *Cold Formed Steel Structural Members*.
- 8.6.3 Wherever structural framing permits, and subject to reasonable limitations for handling, steel roof deck shall be designed and fabricated to span continuously over at least four structural supports (three spans).
- 8.6.4 Steel roof deck shall be fastened to structural steel by arc spot welding unless otherwise specified.

#### NOTES:

(1) *The thickness and width of the supporting steel element to which the deck is to be attached is a factor in producing satisfactory arc spot welds. A minimum thickness of 2.5 mm and a minimum width of 38 mm is recommended.*

(2) *Where deck is required to be fastened to structural supports by mechanical fasteners such as screws, pneumatic or powder-actuated pins or other fasteners, the Specification Writer should state the fastening requirements clearly.*

- 8.6.5 Steel roof deck shall have at least the minimum strength and stiffness appropriate for the application and performance of conventional types of built up roofing. Unless otherwise specified, the minimum uniform total

factored load for the design of steel roof deck in limit states design shall be 3.5 kPa. Deflection shall not exceed 1/240 of the span under a minimum uniform unfactored live load of 1.9 kPa.

*NOTE: The load and deflection requirements of 8.6.5 are intended to provide the minimum deck strength and stiffness which combined with a sufficiently sturdy framing system, are considered to be appropriate for the application and performance of conventional types of built-up roofing. The loads specified in 8.6.5 are not those due to wind, snow or other forces which, for a particular locality, may be higher or lower. Where other criteria are to apply, the Specification Writer should state the requirements clearly.*

- 8.6.6 Loads due to wind, snow or other forces, and related loading distributions, shall be as prescribed by the structural plans and specifications.
- 8.6.7 Deck deflection due to unfactored live load, uniformly distributed, shall be calculated as follows:  
For a single span:  
$$\Delta = \frac{5WL^4}{384EI}$$
  
For two equal spans:  
 $\Delta = 0.42$  times single span value  
For three or more equal spans:  
 $\Delta = 0.53$  times single span value  
Where,  
 $\Delta$  = calculated live load deflection, mm  
 $W$  = maximum uniform unfactored live load, kPa  
 $L$  = span, mm  
 $E$  = modulus of elasticity of steel, (203 000 MPa)  
 $I$  = moment of inertia of the steel roof deck at midspan, when supporting the specified unfactored live load,  $W$ , with top flange of the deck in compression, mm<sup>4</sup>/m of width

- 8.6.8 Steel roof deck shall have a factored moment resistance capable of resisting the effects of the uniformly distributed factored loads determined as follows:  
For a single span:  
 $M_f \geq 0.125 (\alpha W) L^2$

For two equal spans:

$$M_f \geq 0.070 (\alpha W) L^2$$

$M_f \geq 0.125 (\alpha W) L^2$ , at the interior support

For three or more equal spans:

$$M_f \geq 0.080 (\alpha W) L^2$$

$M_f \geq 0.100 (\alpha W) L^2$ , at the interior supports

Where,

$M_f$  = factored span moment resistance, N.mm/m width

$M_f$  = factored support moment resistance, N.mm/m width (for the definition of the other symbols see 8.6.9)

- 8.6.9 Steel roof deck shall have a factored web crippling resistance capable of resisting the effects of the factored uniform loads determined as follows:

For a single span:

$$P_r \geq 0.50 (\alpha W) L$$

For two equal spans:

$P_r \geq 1.25 (\alpha W) L$ , at the interior support

$P_r \geq 0.375 (\alpha W) L$ , at the end supports

For three or more equal spans:

$P_r \geq 1.10 (\alpha W) L$ , at the interior supports

$P_r \geq 0.40 (\alpha W) L$ , at the end supports

Where,

$P_r$  = factored web crippling resistance, N/m width

$\alpha W = \psi [\alpha_L W_L + \alpha_Q W_Q] + \alpha_D W_D$

$\alpha_L$  = live load factor = 1.50

$\alpha_Q$  = live load factor for wind = 1.50

$\alpha_D$  = dead load factor = 1.25

$W_L$  = live loads (excluding wind), kPa

$W_Q$  = wind loads, kPa

$W_D$  = dead loads, kPa

$\psi$  = load combination factor

= 1.0 when either  $W_L$  or  $W_Q$  act

= 0.7 when both  $W_L$  and  $W_Q$  act

$L$  = span, mm

*NOTE: The length of bearing of steel roof deck on structural supports should be equal to the depth of the deck section, where practicable.*

## 8.7 Erection

- 8.7.1 All erection work, including field welding, shall be the responsibility of the Fabricator and such work shall be carried out by Fabricator's trained



erection crews or the Fabricator's approved Erector, all in accordance with the Fabricator's and these specifications. Fabricators shall be qualified in accordance with CSA Standard W47.1 *Certification of Companies for Fusion Welding of Steel Structures*. Welders shall be qualified for deck welding by the Canadian Welding Bureau.

*NOTE: Since steel roof deck is an engineered product, it is desirable to have single source responsibility for fabrication and erection. If erection is to be carried out by others, the Specification Writer should so indicate.*

- 8.7.2 Steel roof deck units shall be placed, and adjusted to final position, on the supporting structure before being permanently fastened thereto. If structural supports are not in proper alignment, the problem shall be reported to the General Contractor in order that the necessary correction can be made before proceeding with the work.
- 8.7.3 Steel roof deck units shall be adequately fastened to structural supports. The maximum spacing of fastenings along bearing supports shall be 400 mm or 2 flute spacings, whichever is the lesser. Arc spot welds shall have a 20 mm nominal top diameter.
- 8.7.4 End laps shall be not less than 50 mm and shall be formed over supports.
- 8.7.5 Side laps of adjacent units shall be mechanically fastened, or welded using 25 mm welds, at intervals not greater than 900 mm. Closer spacing may be required for diaphragm action, as determined by design.
- 8.7.6 For openings up to 150 mm across the flutes, no reinforcement is necessary provided that not more than two vertical webs are removed.
- 8.7.7 For openings over 150 mm to 300 mm across the flutes, provide not less than a 50 x 50 x 6 mm angle reinforcement to frame across each side of the opening in a direction perpendicular to the flutes. The angles shall be welded to at least two flutes on each side of the opening. Alternatively, reinforcing shall be provided based on a structural analysis of the loads involved.

8.7.8 For openings over 300 mm to 450 mm across the flutes, provide suitable reinforcement based on a structural analysis of the loads involved.

8.7.9 If additional openings not shown or called for by the tender documents are required, such openings shall be cut and reinforced by the Erector but the cost of such extra work shall be charged to the Buyer.

8.7.10 Where steel roof deck is welded in place, the steel deck surface shall be immediately inspected, and all topside areas where the metallic coating has been burned by welding shall be covered by a suitable primer, applied according to the primer manufacturer's instructions.

## 8.8 Limitations

8.8.1 Any damage or alterations by others to the steel roof deck, including that due to construction loads applied at any time, shall not be the responsibility of the Erector or the Fabricator.

## 8.9 Access

8.9.1 Access for unloading bundles of deck onto the structure shall be provided by the General Contractor.

## 8.10 Storage of Materials on Site

8.10.1 Steel roof deck shall normally be delivered to the jobsite as required for erection, but if site storage becomes necessary, the following requirements shall be observed:

- (1) tilt bundles for drainage;
- (2) block bundles off ground for effective drainage and ventilation;
- (3) block long bundles to prevent sagging; and
- (4) store away from chemically corrosive substances (e.g. *salt, cement, fertilizer*), away from materials that could contaminate the surface (e.g. *diesel oil, paint, grease*), and away from site traffic.

*NOTE: Moisture can cause wet storage staining of deck material and usually occurs in one of three ways: (1) condensation from high humidity and/or temperature cycling; (2) wet shipping conditions; or (3) wind-driven rain penetration (outdoor storage). The usual progression is from visible water staining to unsightly white rust (dark grey to dull*

*black on aluminum-zinc alloy coated sheet) to red rust. On material where wet storage stain has occurred, it should be noted that a minor amount of white or gray staining is not detrimental to the functioning of the product and is usually considered acceptable.*

8.10.2 Areas for storage shall be provided by the General Contractor as close to the building as is practicable.

8.10.3 Protection against damage shall be provided by the general contractor.

**8.11 Cleanup**

8.11.1 Remove all debris of this trade and leave work ready for other trades.

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The Canadian Sheet Steel Building Institute, the national association of the structural sheet steel industry, promotes the use of sheet steel in building construction through engineered design and standards of quality and performance. Activities focus on sheet steel building products and steel building systems for commercial, industrial and institutional applications and similar products and systems for farm applications.

The institute provides information regarding the standards of design, fabrication and erection, and offers technical assistance in the use of cold formed and pre-engineered steel products. The CSSBI also represents its members in technical matters connected with government, and provides liaison with organizations such as Canadian Standards Association and National Research Council.

CSSBI Member Companies are voluntarily committed to maintaining high industry standards in the design, manufacture and installation of cold formed steel building products and systems. Specifying requirements to CSSBI Standards and dealing with CSSBI Member Companies, can provide added assurance of quality construction. Only CSSBI Member Companies are authorized to display the CSSBI logo on drawings, stationery, company literature and advertising.



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[All CSSBI publications are available upon request free of charge.]