

Course Title:

*Lath Selection & Specification
to Enhance Stucco
Performance*

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Structa Wire ULC
1395 North Grandview Hwy.
Vancouver, BC V5N 1N2
Tel: 604 254 9868
Fax: 604 254 8530
info@structawire.com
1 800 887 4708
Web: www.structawire.com

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HOUSEKEEPING

- Thanks for joining us today
- All Attendees are muted
- Question? Please use the “Q&A” button on the bottom of your screen

LEARNING OBJECTIVES

- Explore stucco and stucco composition as a naturally energy efficient cladding
- Evaluate and Compare various lathing alternatives in terms of sustainability
- Identify specific challenges of stucco wall systems while reviewing best practices and solutions
- Explore Energy Efficient Systems for 3 & 1 Coat Stucco
- ASTM standards and evaluations

Properties of Stucco

- Stucco cladding is a combination of:
 - Portland cement
 - Type S lime
 - Sand
 - Water
- Compression strength = 1500 to 5000 psi
- Tensile strength = 200 to 400 psi

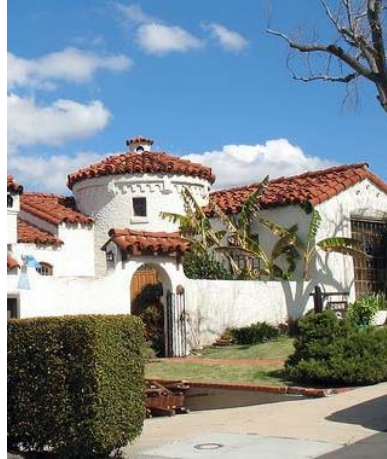


History of Lath

- Originally the lath and plaster technique used spaced strips of wood installed horizontally on the wall or ceiling that would support the wet plaster until it cured.



Lath & Plaster Today



Advantages of Stucco

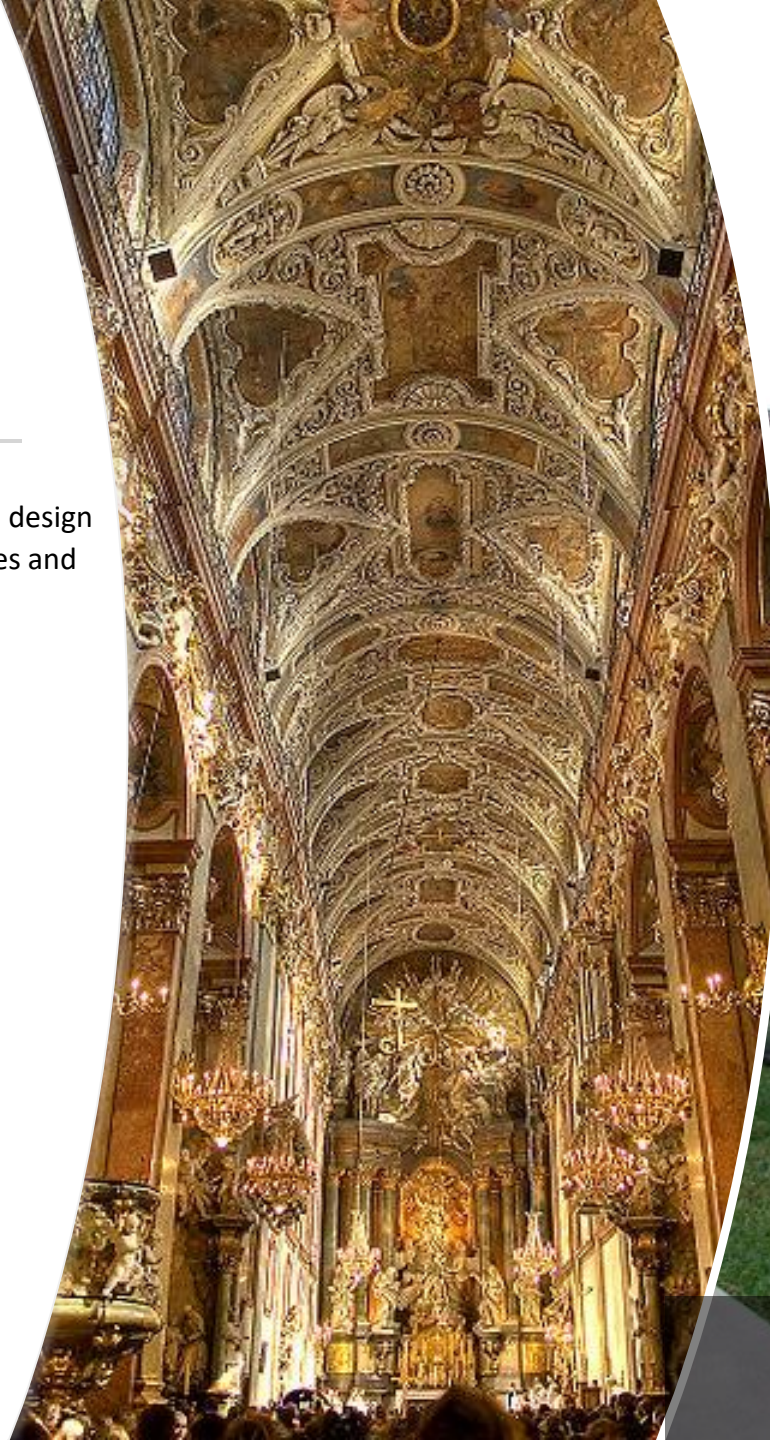
- Versatility of architectural design
- Variety of finishes, textures and colors

Performance Benefits

- Fade resistant
- Good sound isolation
- Water resistant
- impact resistance
- Fire resistant

Economical

- Low maintenance
- Airtight = energy savings





Pine View Community Center



Cal State University Long Beach
ARCHITECT: Zimmer Gunsul Frasca Architects

PEPPERDINE UNIVERSITY STUDENT HOUSING



Pepperdine University Student Housing, Malibu California

Product: Twin Trac 2.5

Architect: Harley Devereaux

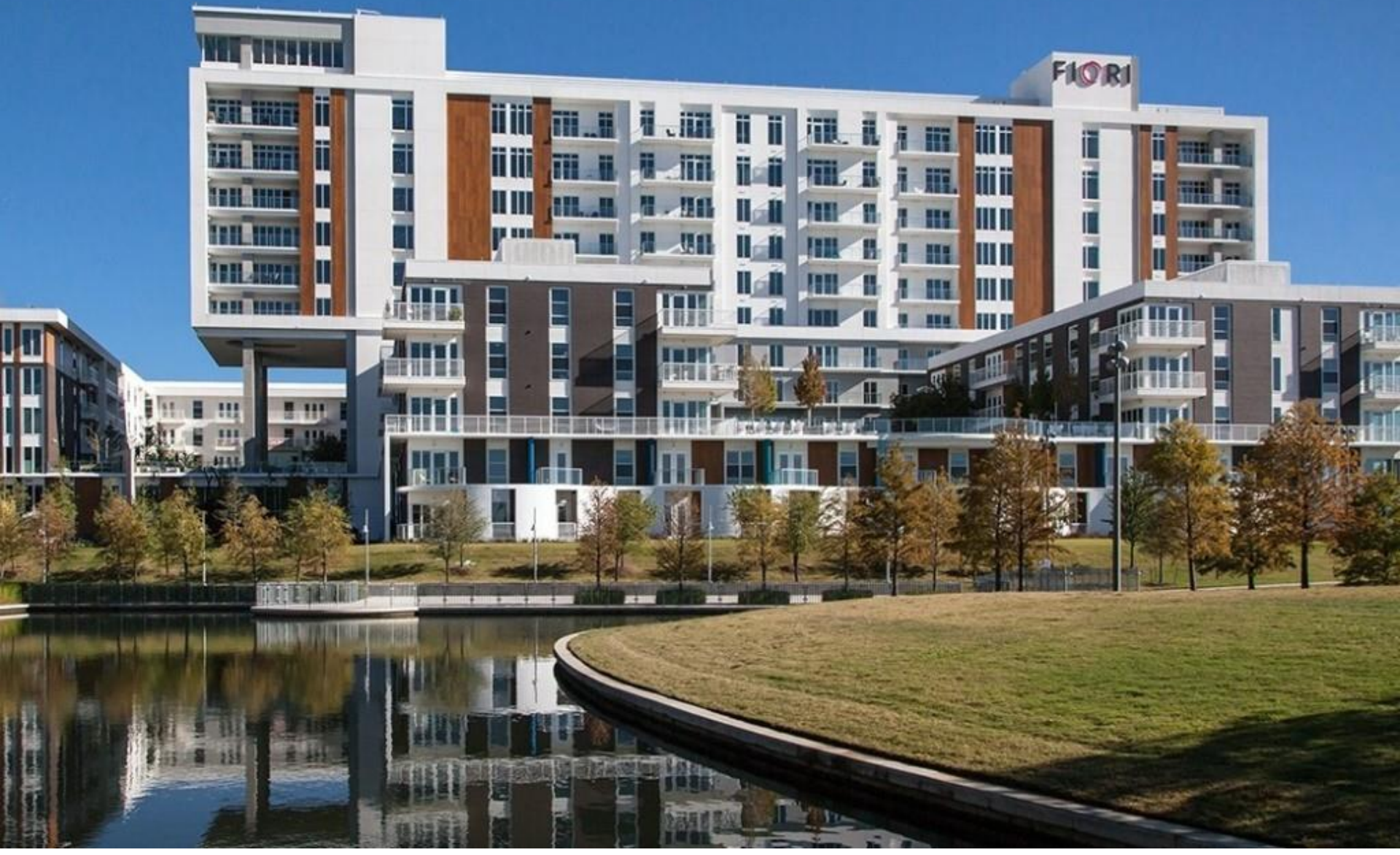
GC: Suffolk

Applicator: Perlite Plastering



Sofi Stadium Performance Venue
Architect: HKS
Applicator: Raymond Group
Product: Mega Lath

Fiori on Vitruvian Park



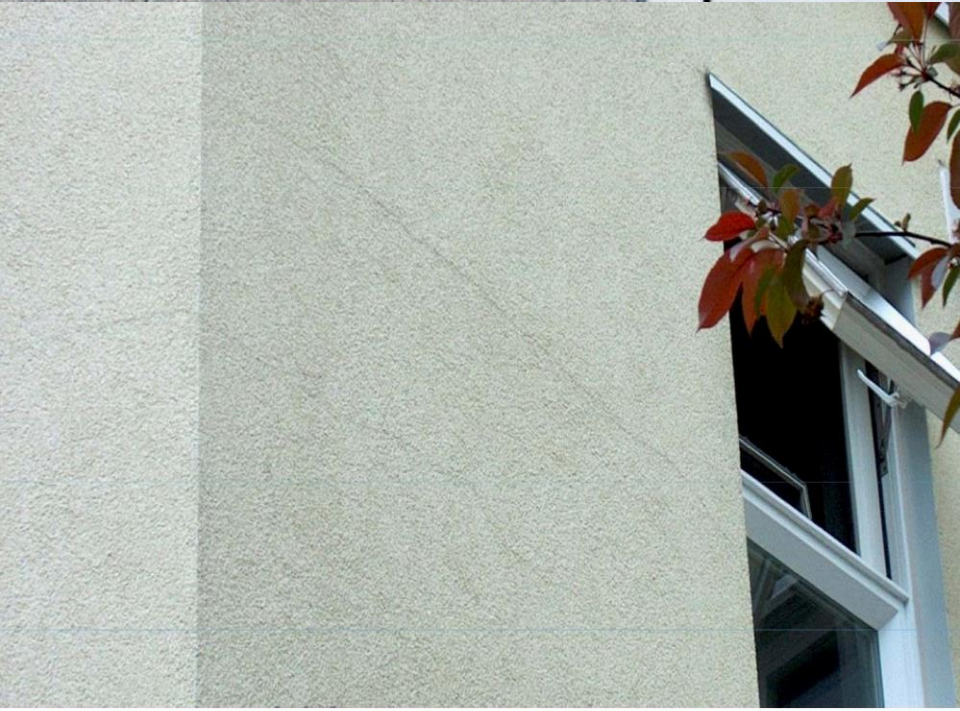


Orlando Four Seasons Hotel
Architect: HKS

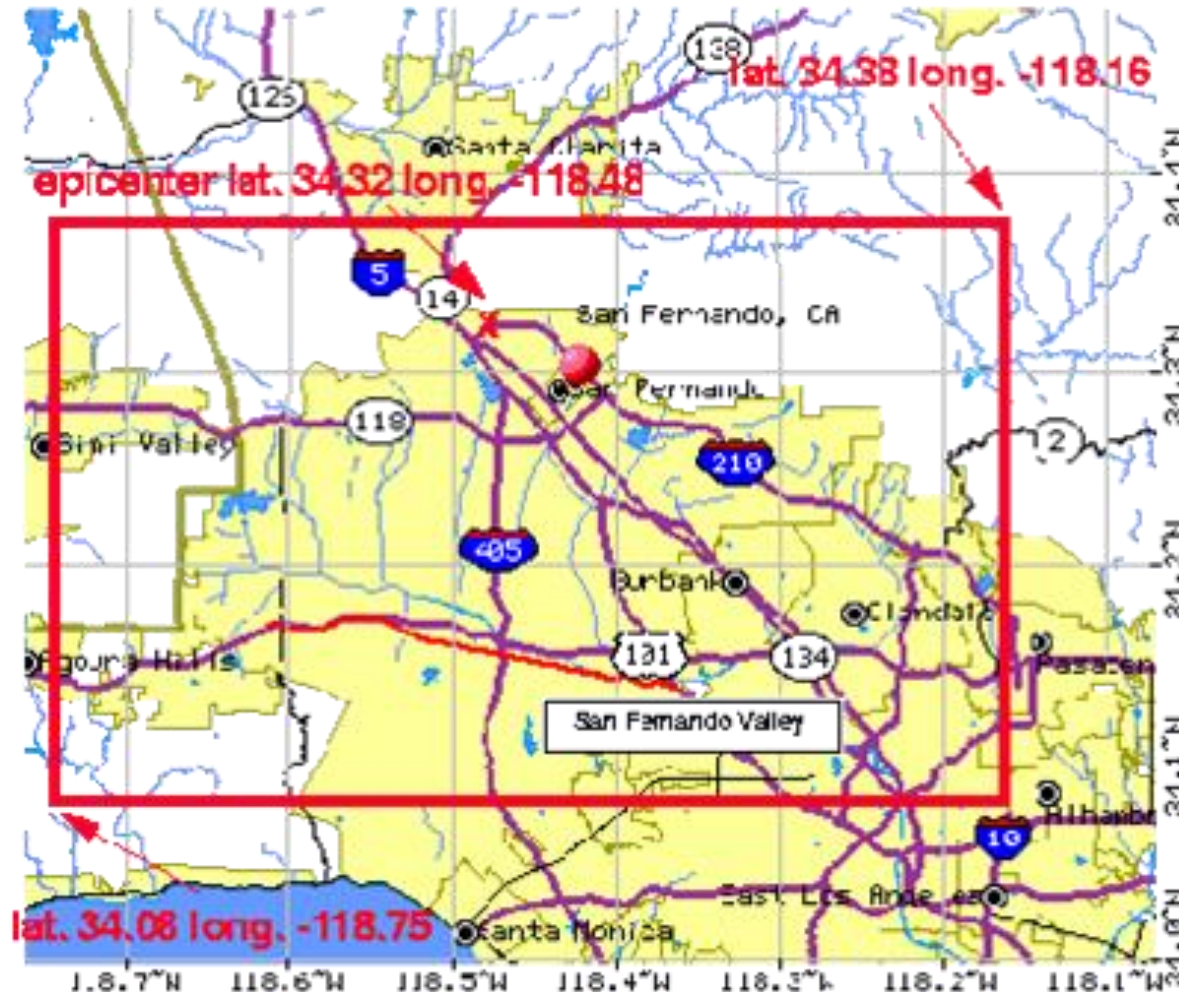
Challenges with Stucco

- Cracking
 - Shrinkage during curing
 - Expansion/contraction
 - Building movement
 - Seismic activity






Stucco Seismic Issues- Northridge



- 20 Billion in Damage
- 6.7 Magnitude
- Ground Movement one of highest ever recorded



Northridge Stucco Failure





Seismic - Lath Performance

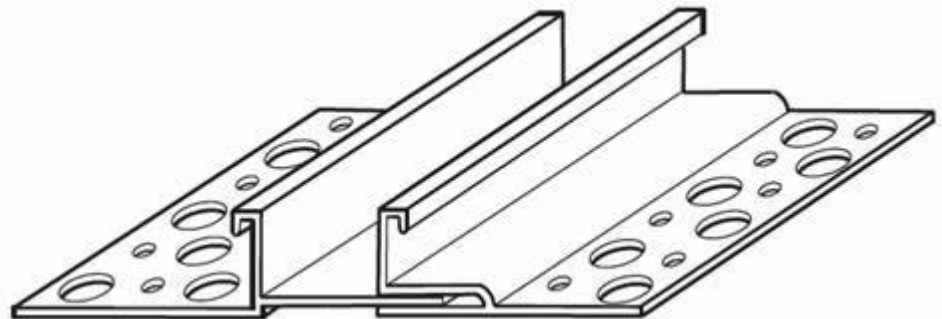
Subsequent research has found that welded wire laths contribute the highest level of security and strength in stucco walls during seismic events.

Reasons:

- Furring of welded wire laths are designed to fully meet the ¼" requirement
- Fastener can securely attach to framing

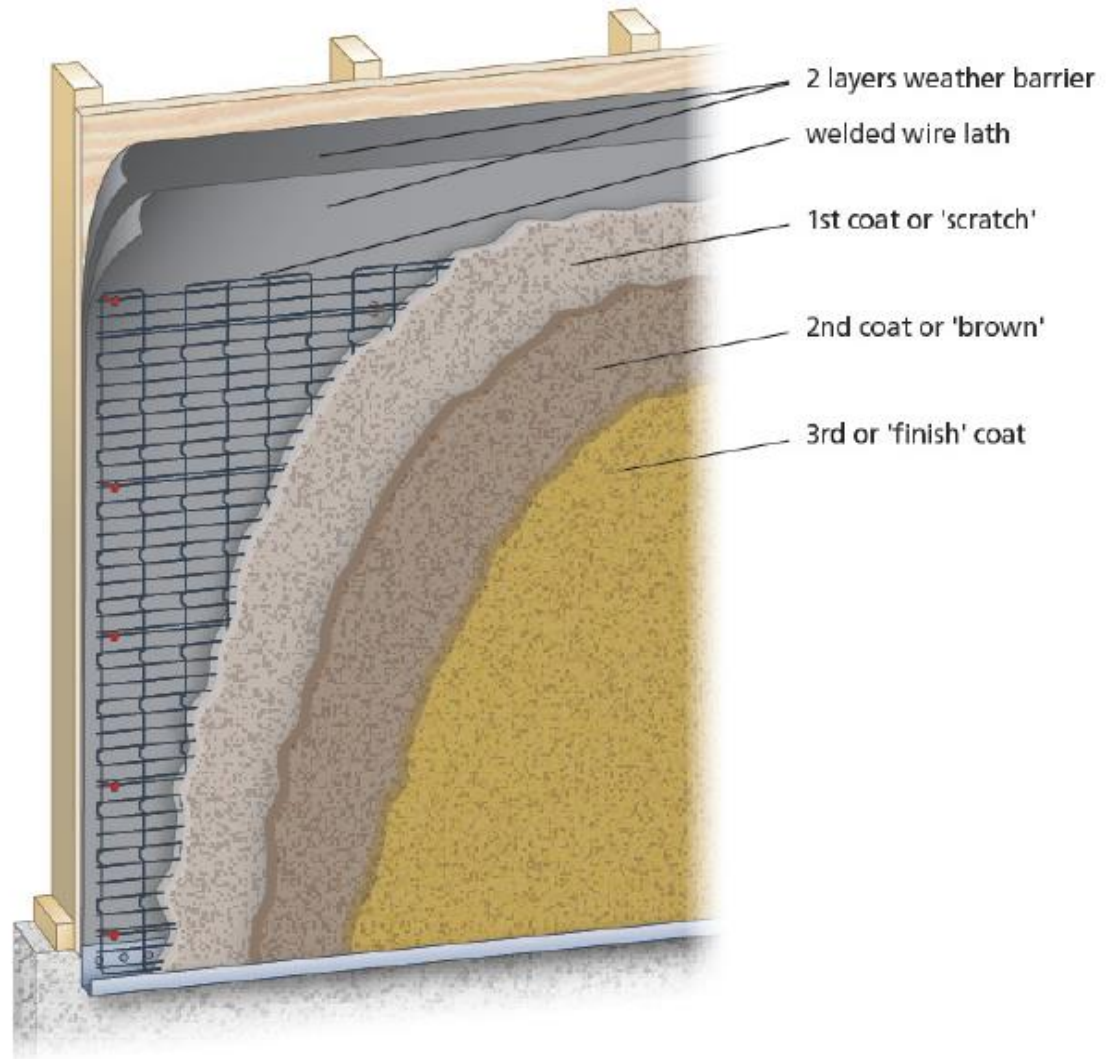
Challenges with Stucco: Control Joints

- Control joints should be properly installed
- Vertically at the side of openings such as windows or doors and at each floor level.
- ASTM prescribes control joints every 144 square feet or no more than 18 ft. In any direction
- Lath must be cut at the control joint.





Traditional Stucco Wall

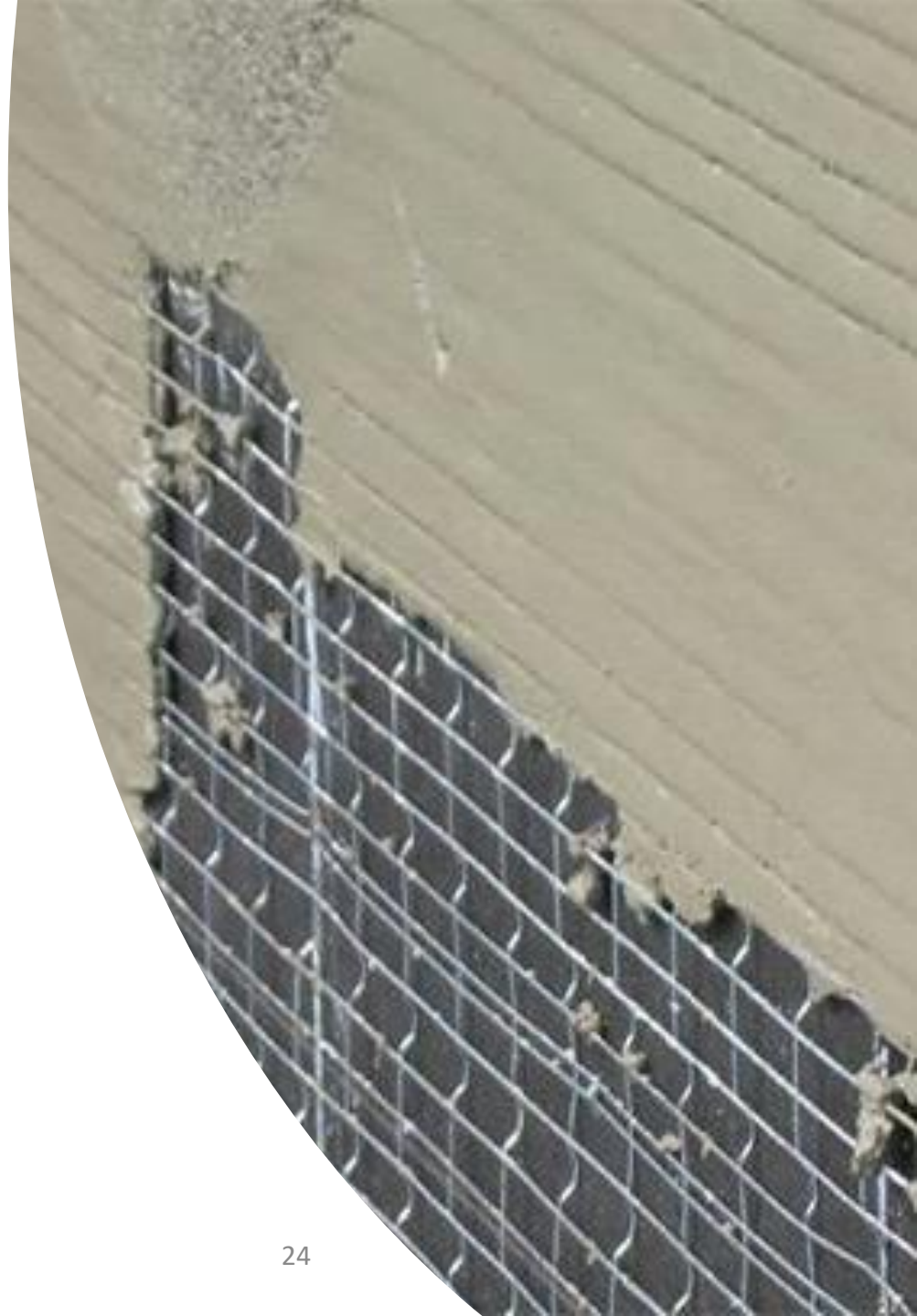


Stucco Lath

Stucco requires a lathing for attachment to a framed structure

General types of lath:

- Expanded metal
- Woven wire
- Welded wire



Pole Question?

What type of Lath products do you typically specify for your stucco finish?



Relevant ASTM Standards

- *C 847 Metal Lath*
- ***C 933 Specification for Welded Wire Lath***
- *C 1032 Specification for Woven Wire Plaster Base*
- *C 1063 Specification for Installation of Lathing and Furring to Receive Interior and Exterior Portland Cement based Plaster*
- *C 926 Specification for Application for Portland Cement*
- *A641 is “Standard Specification for Zinc-Coated (Galvanized) Carbon Steel Wire”.*
- *C1861 Standard Specification for lathing and furring accessories, and fasteners, for interior and exterior Portland Cement base plaster.*

09 20 00**Plaster and Gypsum Board****09 21 00****Plaster and Gypsum Board Assemblies**

09 21 13

Plaster Assemblies

09 21 16

Gypsum Board Assemblies

09 21 16.23

Gypsum Board Shaft Wall Assemblies

09 21 16.33

Gypsum Board Area Separation Wall Assemblies

09 22 00**Supports for Plaster and Gypsum Board**

09 22 13

Metal Furring

09 22 13.13

Metal Channel Furring

09 22 13.23

Resilient Channel Furring

09 22 16

Non-Structural Metal Framing

09 22 16.13

Non-Structural Metal Stud Framing

09 22 26

Suspension Systems

09 22 26.23

Metal Suspension Systems

09 22 26.33

Plastic Suspension Systems



09 22 36

Lath

09 22 36.13

Gypsum Lath

09 22 36.23

Metal Lath

09 22 39

Veneer Plaster Base

09 23 00**Gypsum Plastering**

09 23 13

Acoustical Gypsum Plastering

09 23 82

Fireproof Gypsum Plastering

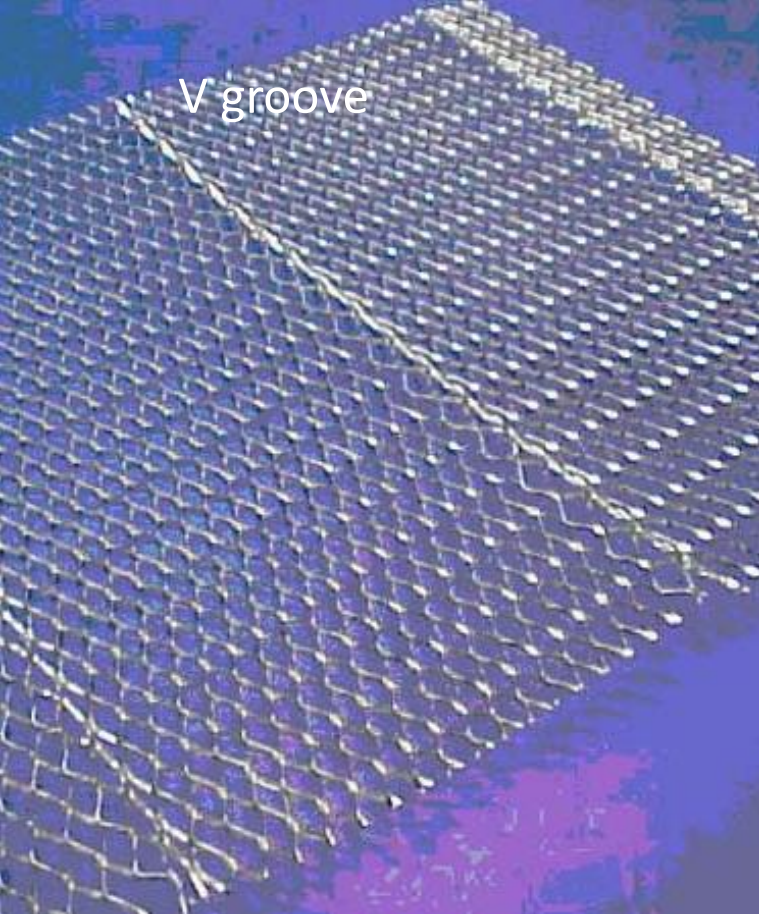
**09 24 00****Cement Plastering**

09 24 13

Adobe Finish

09 24 23

Cement Stucco



V groove



FLAT



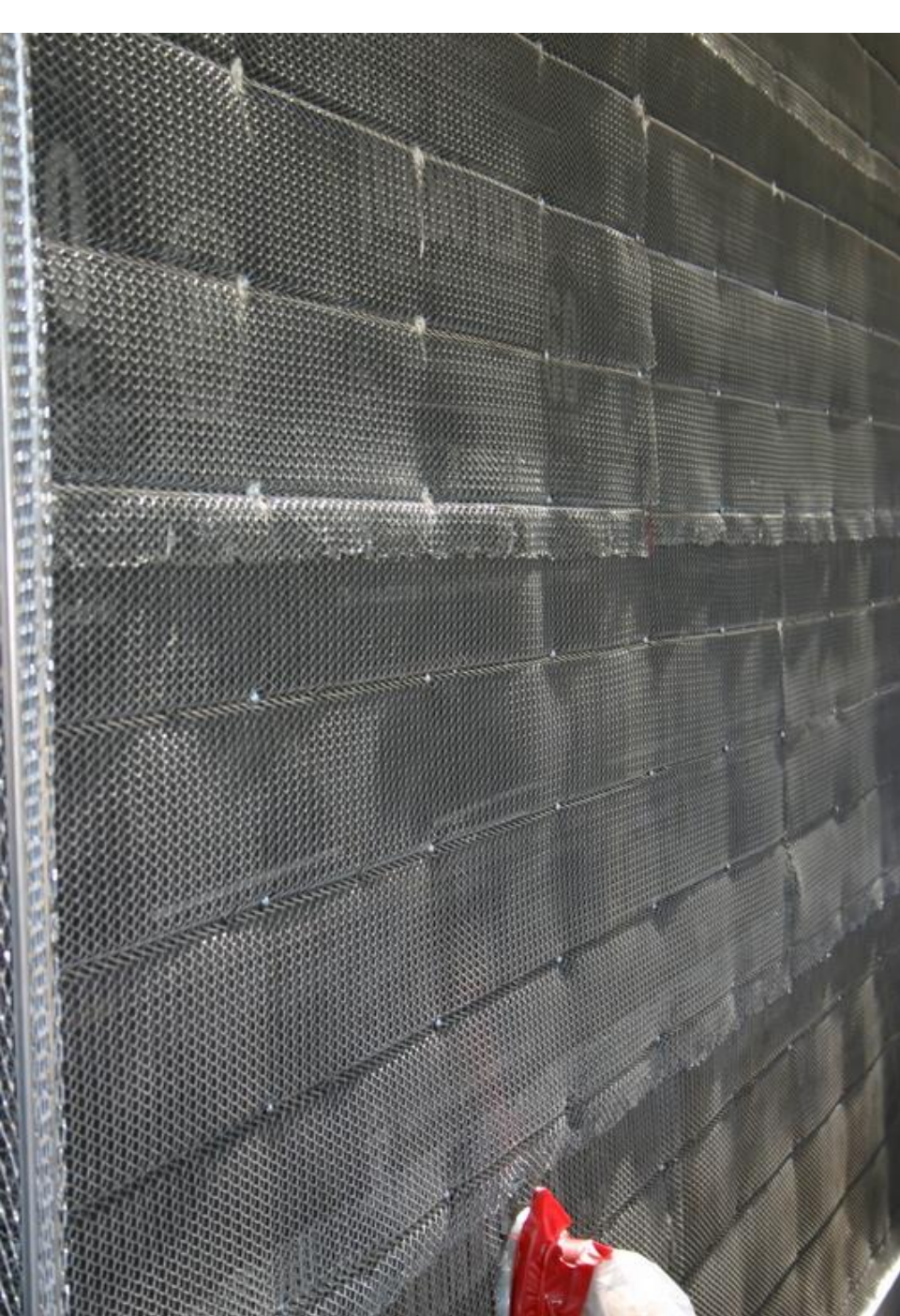
Dimpled

Expanded Metal Lath

Expanded lath is available in two different weights for walls and ceilings

2.5 lbs/yd²

3.4 lbs/yd²

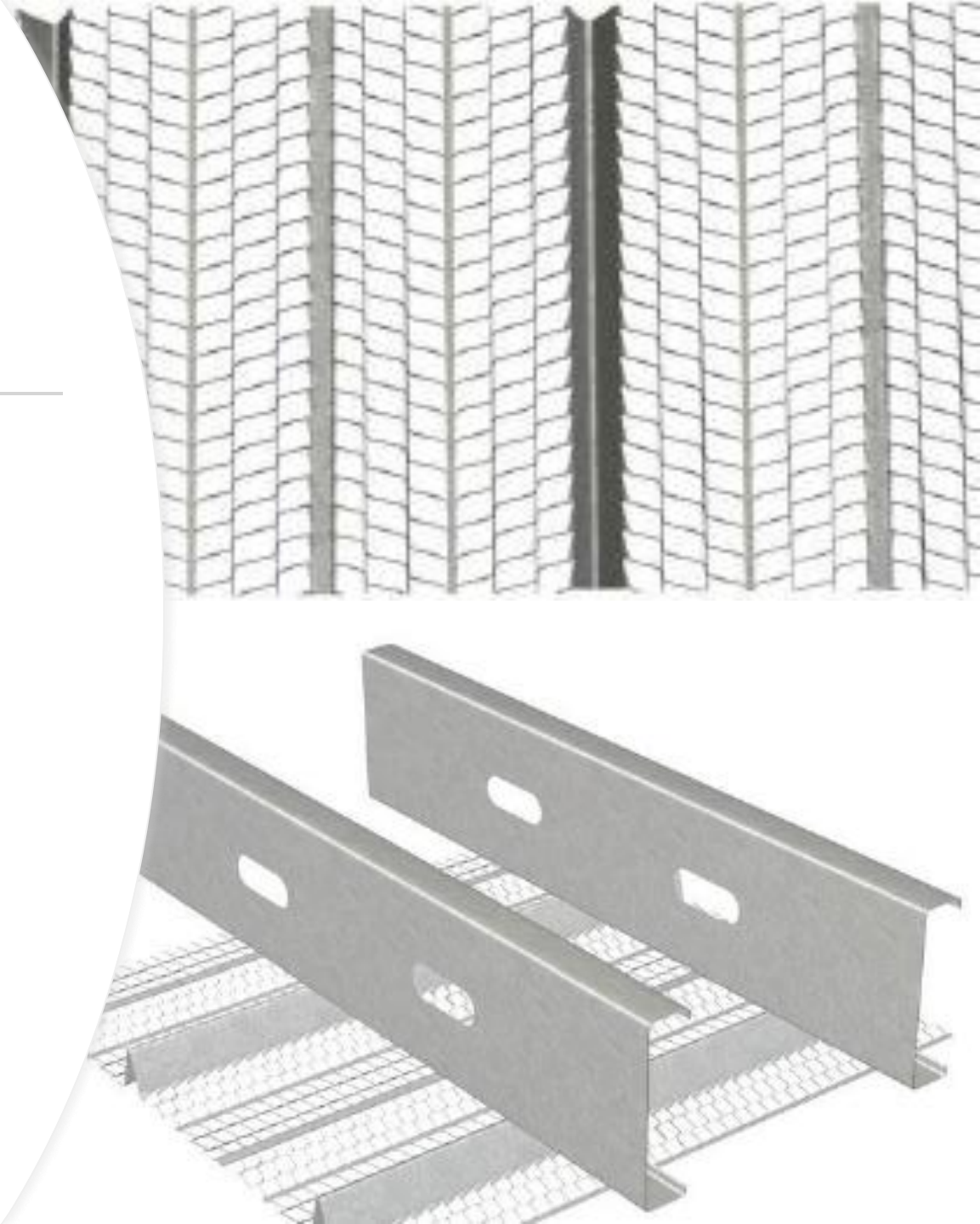


- Expanded Metal Lath is required to be fastened at furring points
- Fastener spacing minimum 6"
- Sheets can be wavy
- Must cut at interior & exterior corners
- Minimum overlap of $\frac{1}{2}$ " on Horizontal & 1" on vertical joints



High Rib Expanded Metal Lath

- High Rib Lath is available in one weight:
 - 3.4 lbs/yd²
- Commonly used for soffits and ceilings
- 3/8" V-shaped ribs every 4-1/2"





Rib Lath must be side lapped
full rib with fastened located at ribs



Metal Lath Advantages

- Long History in the Market place
- Adequate keying of stucco
- Less initial worker training required
- Good for fastening on steel stud



Metal Lath Differences

Sharp edges can be a safety issues

Requires horizontal tying between framing members beyond 16 inches OC

Can not run continuous around interior/exterior corners

Higher number of laps with sheets

Overlaps can not exceed 1 ½"

Laps increase areas of thinner stucco; difficult for stucco to penetrate two layers at the overlaps

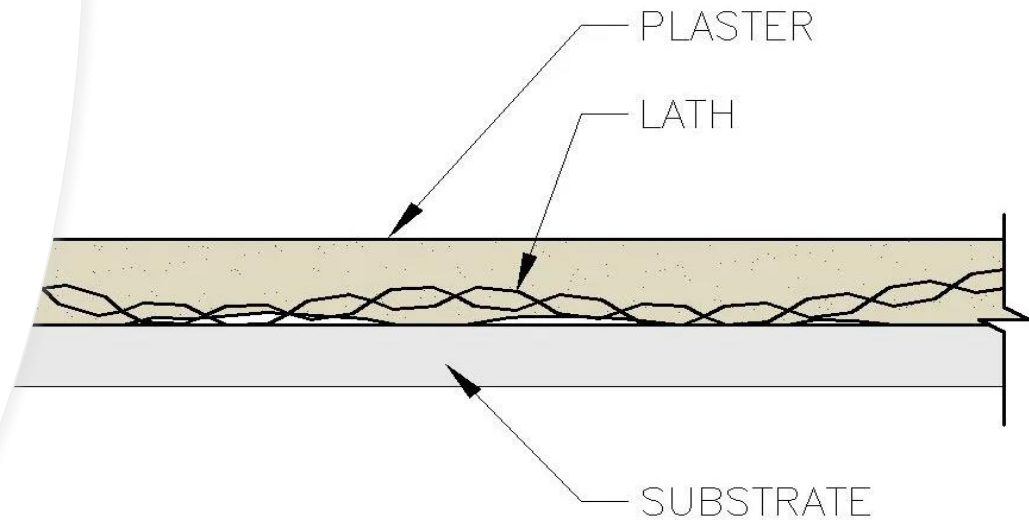
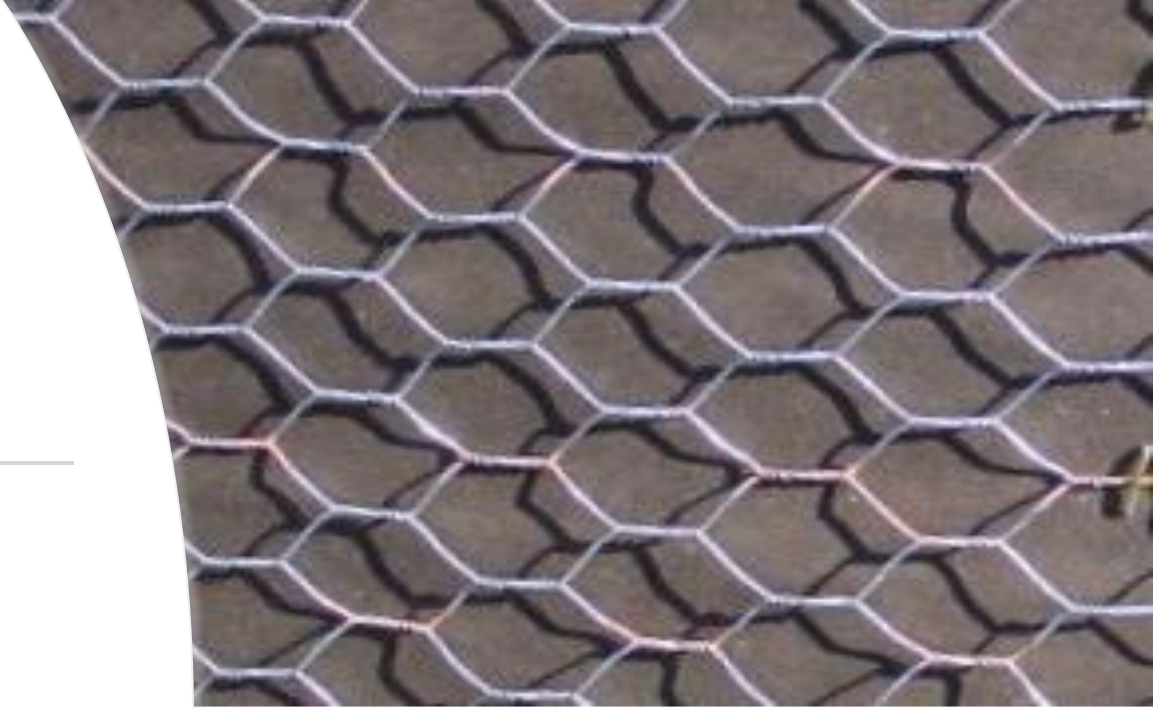
There is higher incidence of cracking without good embedment

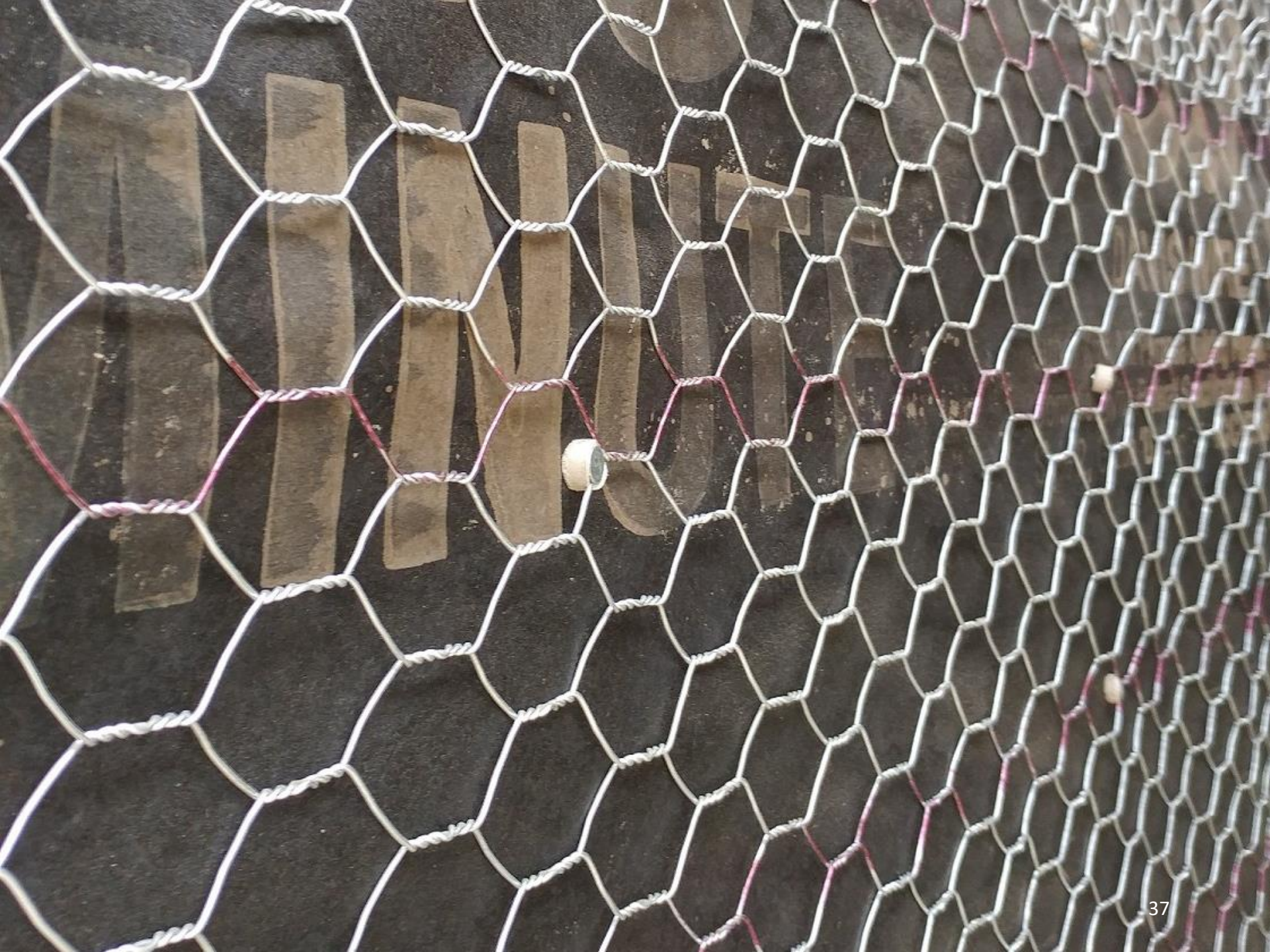
Woven Wire Lath

- Woven wire lath or 'chicken wire' was originally designed for fencing applications
- 1-1/2" hexagonal openings
- 1 " openings for one coat stucco systems
- Manufactured from 17 ga wire
- Available:
 - Rolls
 - With paper backing



Woven Wire must
be fastened at
furred locations





Woven Wire Lath Advantages

- Available in rolls which reduces laps
- Labor savings to install
- Easily bends around exterior & interior corners
- Rolls are wider than expanded metal sheets; quicker to install

Woven Wire Differences

Lacks good keying of stucco without the use of furring nails

Vertical reinforcement can be challenged – can contribute to horizontal cracking

Difficult to install on steel framing

Roll is heavy & difficult to handle

Woven Wire must be fastened at furred locations



Welded Wire Lath

Welded Wire

3 Different weights

- 1-1/2" x 1-1/2" x 17 gauge (Structa Lath)
 - 1" x 1-1/2" x 17 gauge (Twin Track)
 - 0.7" x 1.5" x 17 gauge (Mega Lath)
 - Welded wire laths are made of galvanized wires, precision welded at each intersection 17 gauge
 - Square/rectangular shaped openings
 - Rolls or sheets
-



STRUCTAFUSION

Specification Sheet

Approved to meet prevailing building codes. See IAPMO ER 2017



STRUCTAFUSION is an alternative to woven wire lath specified in ASTM C1032 and is recognized for use as reinforcement for $\frac{3}{8}$ -inch-thick or $\frac{1}{2}$ -inch-thick stucco systems. **STRUCTAFUSION** combines an expanded metal base with welded wire to create a rolled product that is easy to use while providing performance benefits.

FEATURES

- **STRUCTAFUSION** for One-Coat provides superior reinforcing, great stucco keying and full embedment of the wires in stucco matrix

DETAILS

- Expanded metal is fabricated from cold-formed steel with G60 galvanized coating for corrosion resistant lath
- Expanded metal stands up flat and to

PACKAGING

- 38 $\frac{3}{8}$ inch roll size
- 142 ft long / 50 yd² rolls


Structa Lath = Alternative to Woven Wire



Twin Trac 2.5

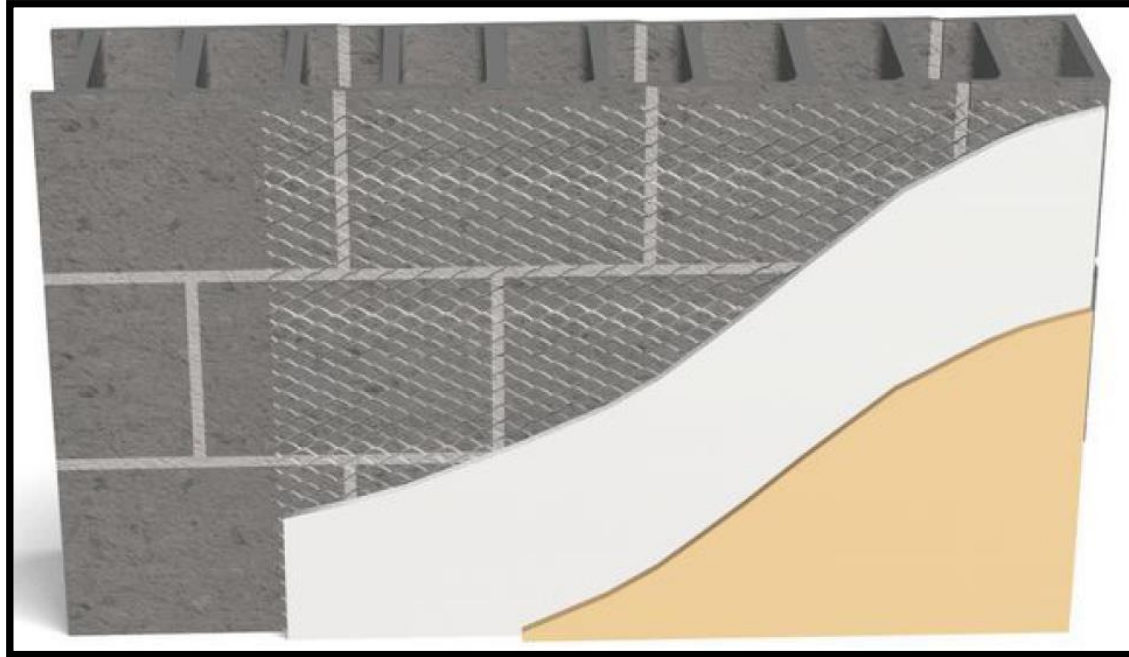
Alternate to
2.5 Expanded
Metal Lath





Mega Lath
Alternative to 3.4
diamond lath

RECOMMENDED INSTALLATION FOR 3 COAT STUCCO OVER CMU



Concrete or masonry

- Concrete galvanized nails – either power driven, powder actuated, or hand driven.
- $\frac{3}{4}$ -inch minimum length, 0.120-inch minimum diameter, and with heads not less than $\frac{3}{8}$ -inch diameter.
- To be installed in accordance with ASTM C1063 Section 7.10.5

LATH FASTENERS

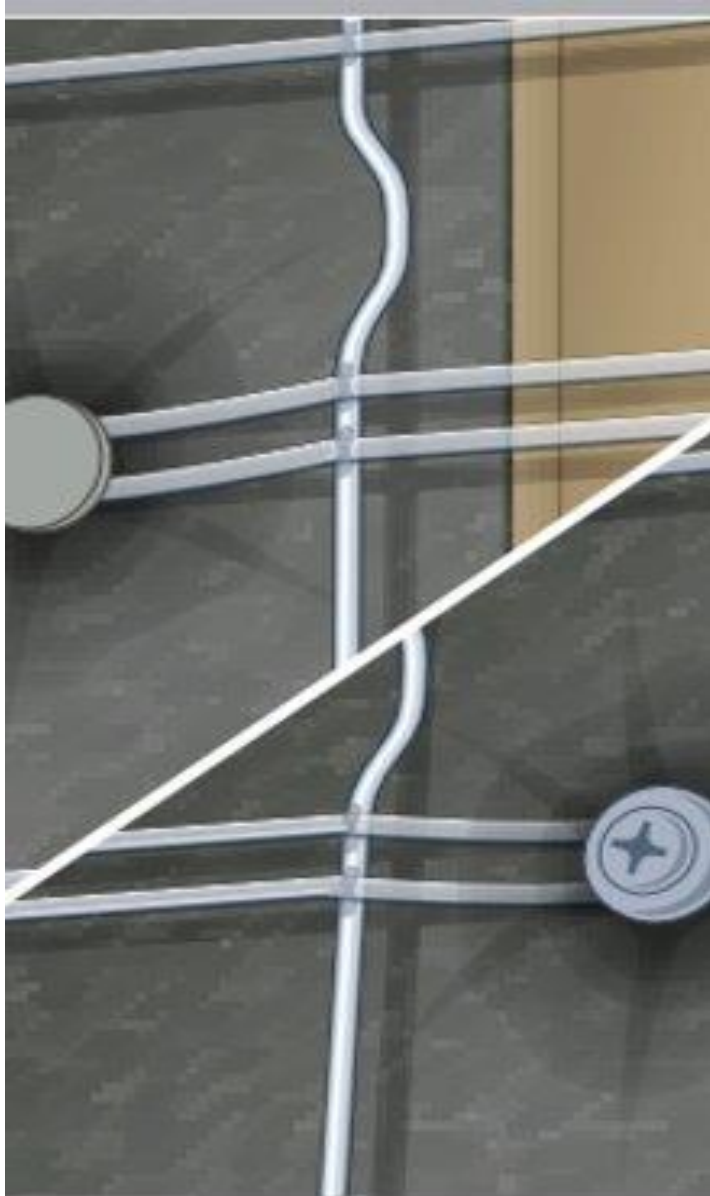


TABLE 3 Lath and Lathing Accessory Fasteners

Fastener Type		Fastener Length, min ^A					
		Vertical Framing Members			Horizontal Framing Members		
		Wood Studs or Furring	Metal Studs or Furring	Solid Bases	Wood Joists	Metal Joists	Concrete Joists
Nails (Specification F1667)	Roofing nail, barbed, 0.1205-in., 11 gauge (3.06 mm) shank diameter, and 7/16 in. (11 mm) head diameter, min	1 in. (25 mm)			1 1/2 in. (38 mm) typical, or 2 in. (50 mm) for 3/4 in. Rib Lath		
	Common nail	6d		3/4 in. (19 mm)			3/4 in. (19 mm)
Screws For fastening into steel framing members from 0.033 to 0.112 in. (0.84 to 2.84 mm) thick (Specification C954) For fastening into steel framing members less than 0.033 in. (0.84 mm) thick, and wood framing members (Specification C1002)	Concrete stub nail, 3/8 in. (10 mm) head diameter min						
	No. 6 shank diameter min, 7/16 in. (0.437 in., 11.1 mm) head diameter min, full length threads. No. 2 Phillips drive recess, flat or contoured top of screw head, flat underside of screw head (pan washer head, modified truss head or round washer head). Screw thread: Type A, coarse-pitch tapping screw thread for fastening metal plaster bases to wood or cold-formed steel. Screw points: For fastening into steel framing members 0.033 to 0.112 in. (0.84 to 2.84 mm) thick: Self-drilling and tapping point. For fastening into steel framing members less than 0.033 in. (0.84 mm) thick and wood framing members: Self-piercing and tapping point (Sharp point).	1 in. (25 mm), which shall also penetrate 3/8 in. (16 mm) min into framing member when the lath is installed.	Length sufficient to allow fasteners to extend through the steel connection with a min of three (3) exposed threads.		1 in. (25 mm), which shall also penetrate 3/8 in. (16 mm) min into framing member when the lath is installed.	Length sufficient to allow fasteners to extend through the steel connection with a min of three (3) exposed threads.	
Staples (Specification F1667)	16 gauge, 3/4 in. (19 mm) crown width, min for lathing 9 gauge, 0.1483-in. (3.77 mm) diameter for hanger wire	1 in. (25 mm) for lathing, which shall also penetrate not less than 3/4 in. (19 mm) into framing members			1-1/2 in. (38 mm) typical for lathing, which shall also penetrate not less than 1 1/4 in. (32 mm) into framing members 2 in. (50 mm) for 3/4 in. Rib Lath which shall also penetrate not less than 1 1/4 in. (44 mm) into framing members 1 1/2 in. (38 mm) for hanger wire		
Power Actuated Fasteners (Requires approval by Authority Having Jurisdiction)				3/4 in. (19 mm)			3/4 in. (19 mm)

^A Fastener lengths indicated in this table are for fasteners installed directly into framing members or solid bases without additional components such as sheathing, furring wads, continuous insulation or a defined drainage space. Fastener length requirements shall be increased by the thickness of additional components installed between the lath and framing member or solid base such as sheathing, furring wad, continuous insulation, and a defined drainage space, where used.



Welded Wire Lath in Sheet Alternative to 3.4 lbs/yd² Hi Rib

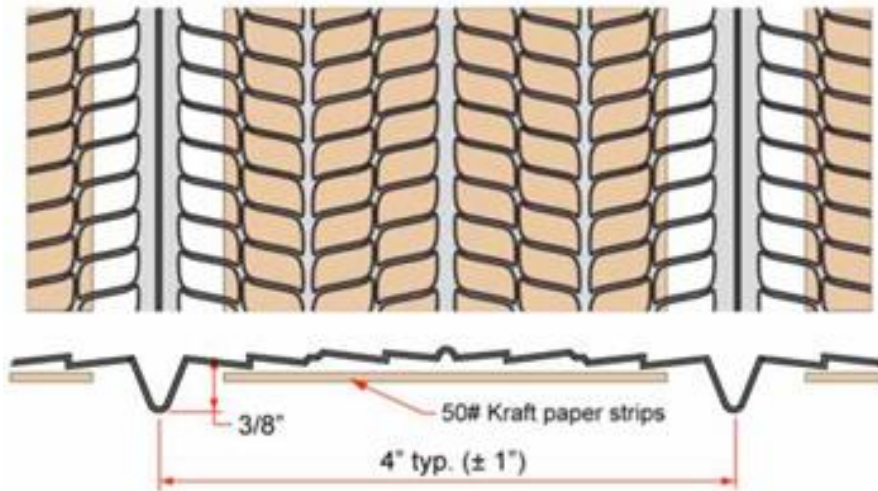
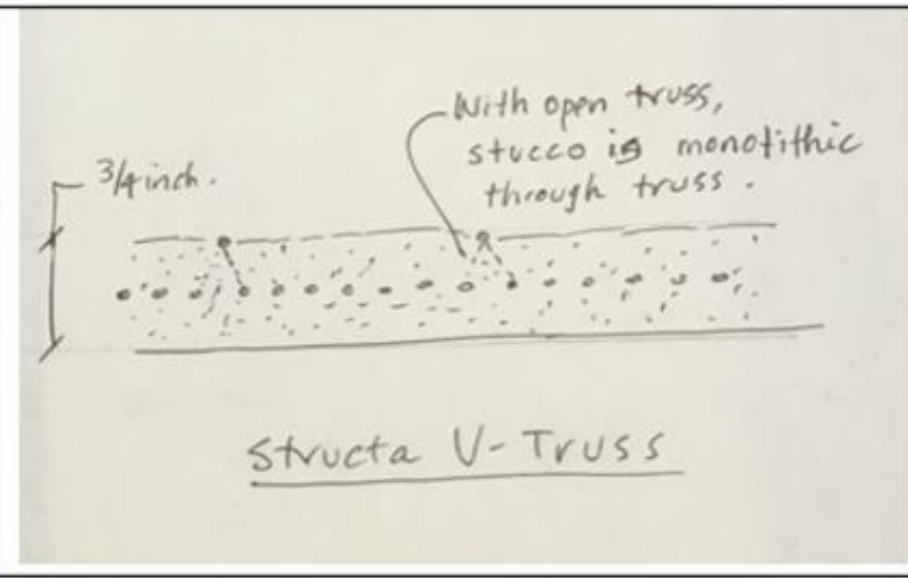
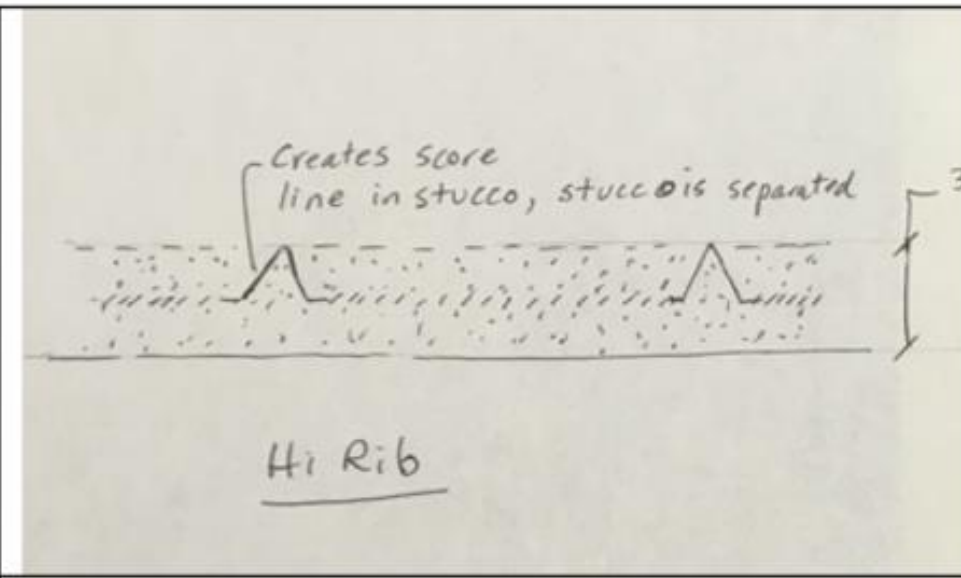


Overhead Product Comparison



High Rib vs Welded Wire Alternative

For soffits or overhangs



Backside of a Soffit



Welded Wire Advantages

- Sheets or rolls
- Better stucco embedment
- Less overlaps means less cracking
- Rolls out straight and will not spring back
- Double Track acts as a template to help eliminate missing a stud
- Easy to install
- Increased productivity
- Uniform finish
- Less call backs

Welded Wire Differences

- Weld quality is critical
- Broken Welds are rare
- Some concern of zinc is burnt off during weld process
- The zinc has a self-healing property and testing shows that the galvanizing at the weld points of welded wire lath is not reduced by the welding and the zinc when burnt off – migrates from areas close to the weld point – to heal the lost zinc.

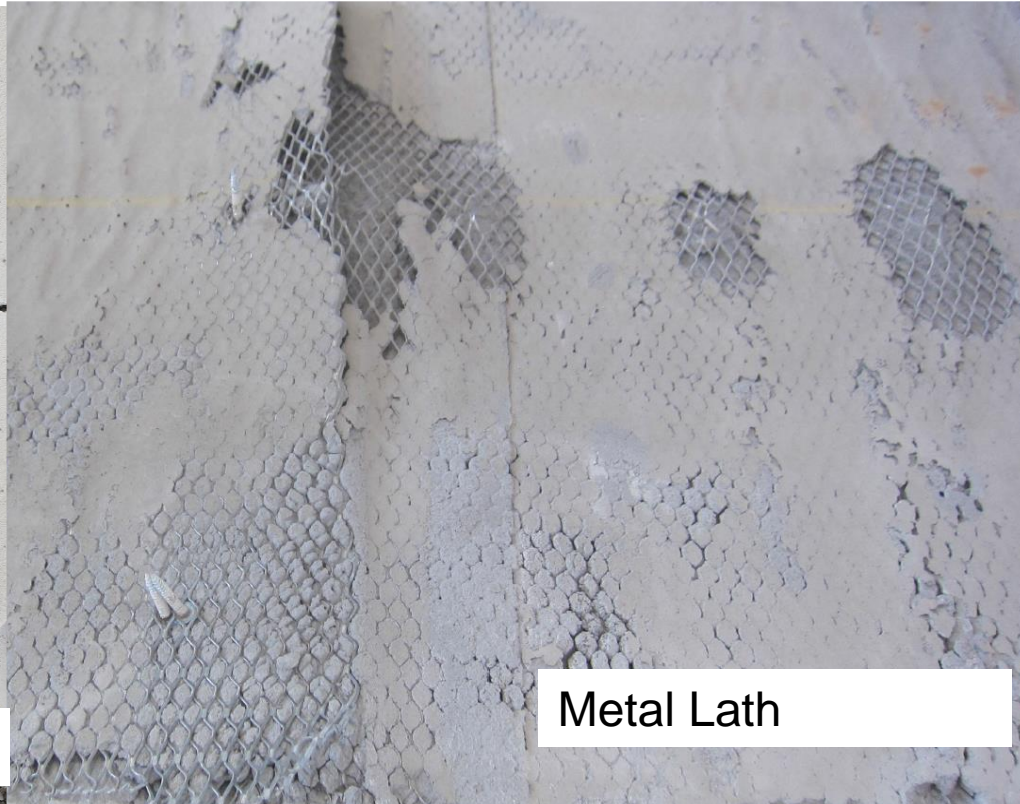
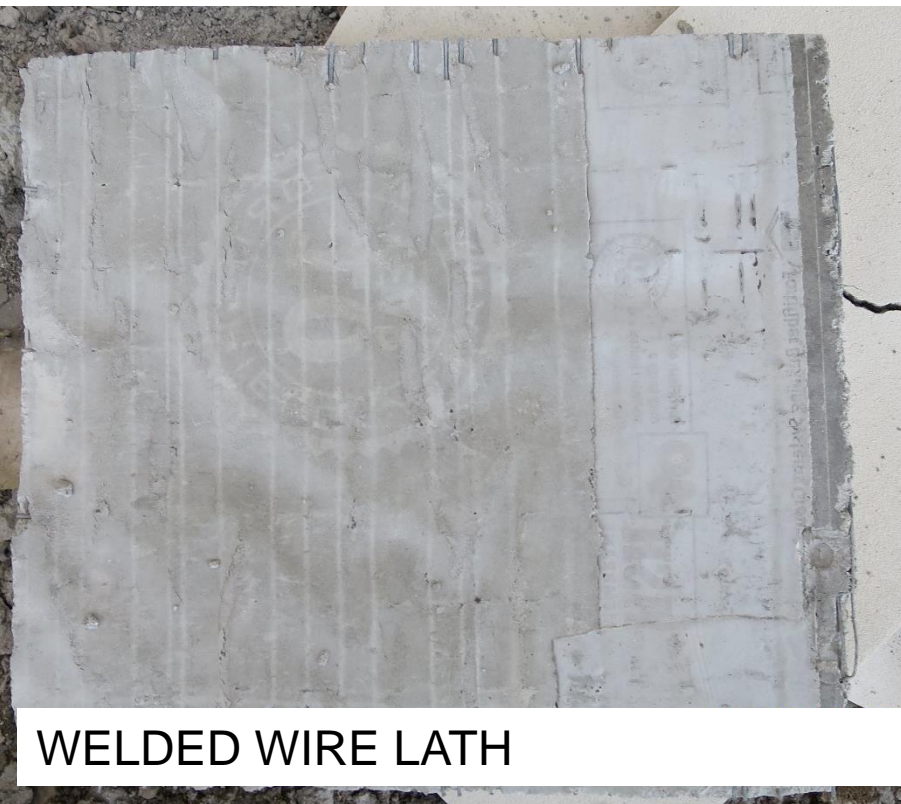


Corners

- STRAIGHT | BULLNOSE | SHORT FLANGE | ARCH
- Features Twin Trac feature for easier, secure attachment
- Promotes superior embedment
- Overlaps — lower profile at laps, less wire build up
- Spring loaded camber — ends contact top and bottom first, then gentle force in middle obtain straight corner
- Superior Packaging Robust package — reduces shipping damage 50 carton



PERFORMANCE COMPARISON



The areas where embedment is insufficient are prone to issues from moisture penetration and corrosion.

PERFORMANCE COMPARISON WELDED WIRE LATH VS EXPANDED METAL

SUMMARY TABLE OF TRANSVERSE LOAD TESTING

	Positive Transverse Load (psf)	Negative Transverse Load (psf)
2.5 lb/yd ² Expanded Metal Lath	476	92
1.14 lb/yd ² Welded Wire Lath	719	149
3.4 lb/yd ² Expanded Metal Lath	688	119
1.95 lb/yd ² Welded Wire Lath	967	162
3.4 lb/yd ² Hi-Rib Expanded Metal Lath	67	34
2.2 lb/yd ² Welded Wire Rib Lath with paper backing	175	38

Notes:

1. First two groups are at 16 inch framing centers, last group is 24 inch framing centers
2. Testing performed by an accredited laboratory in accordance with ICC AC 191

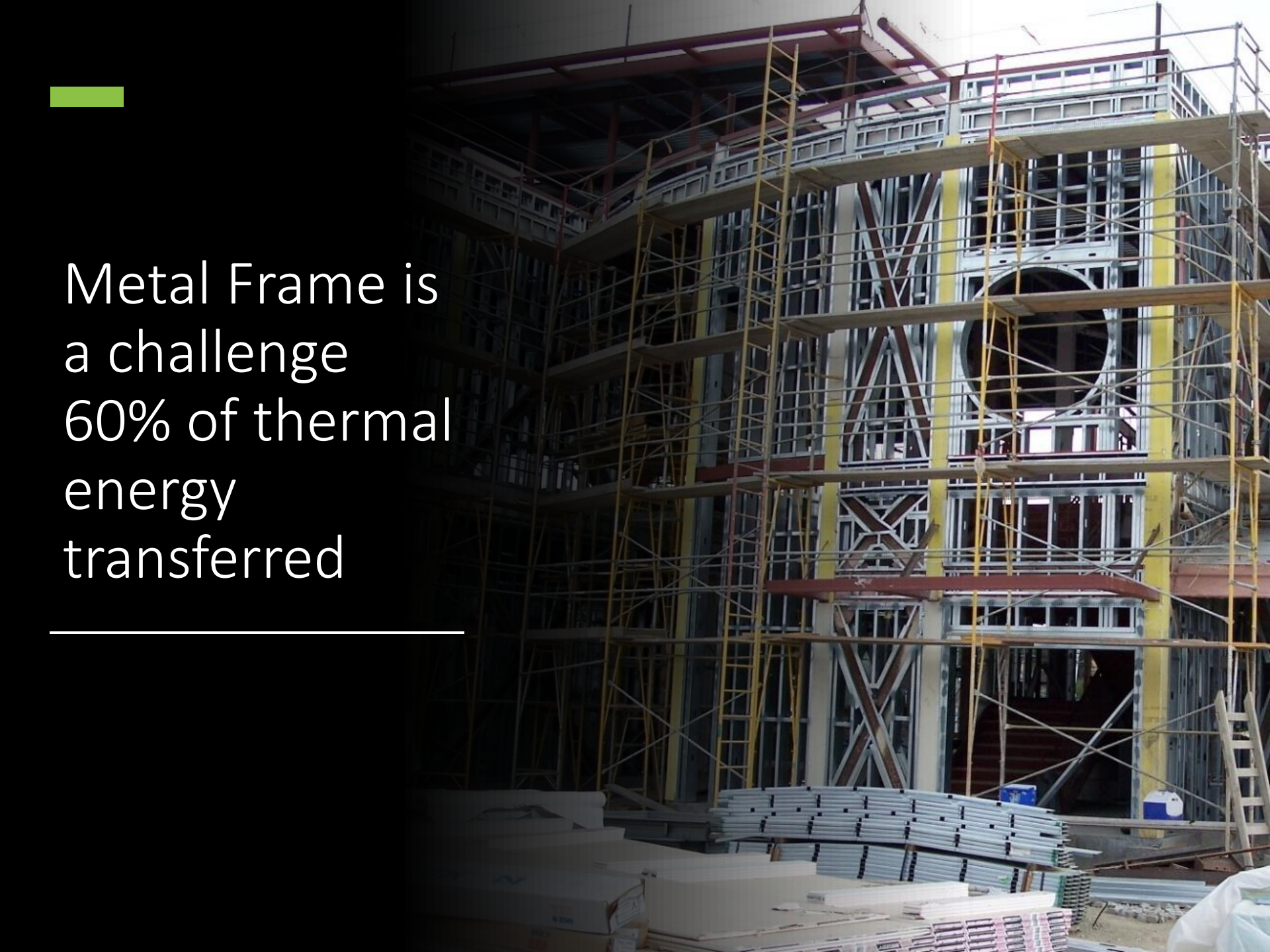


Relevant ASTM Standards

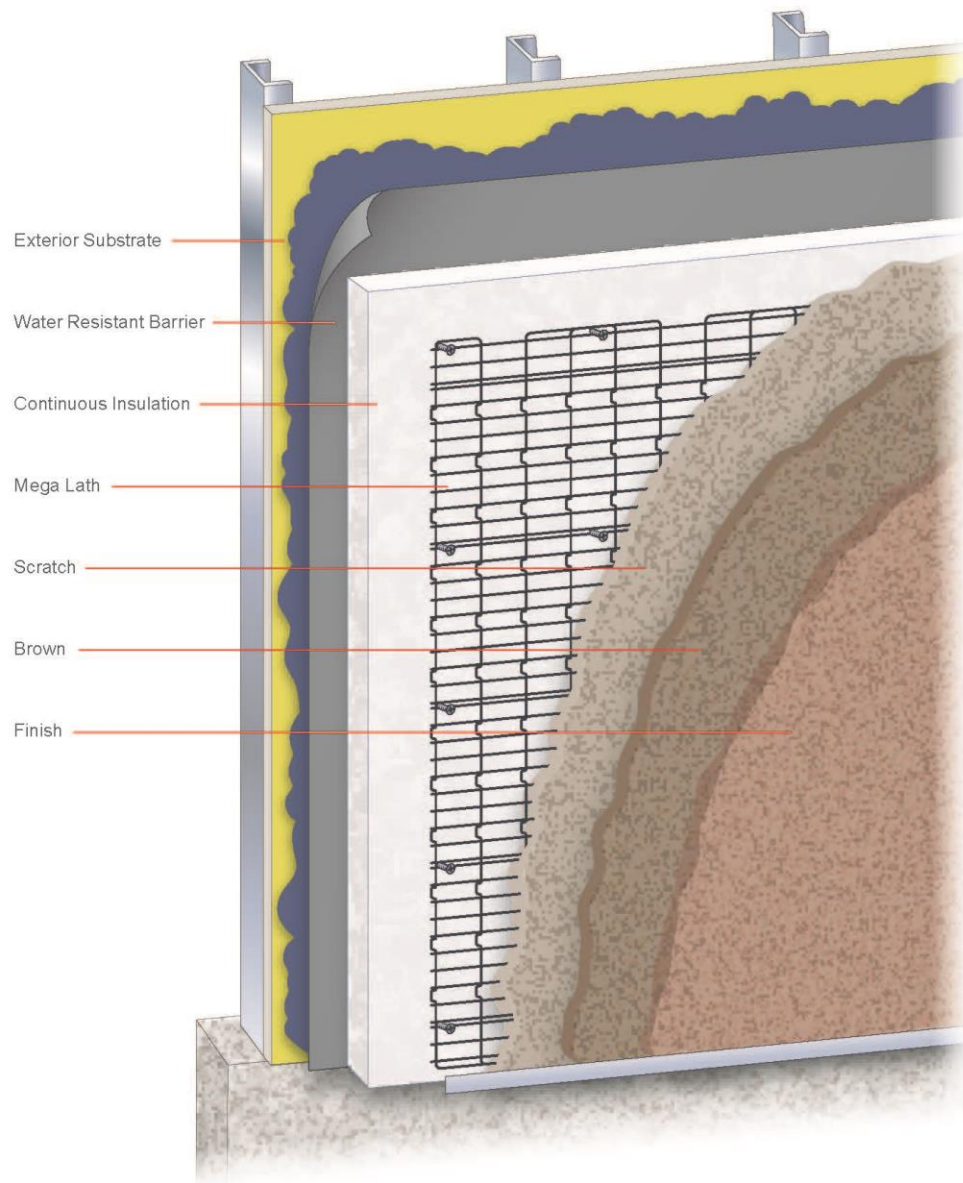
ASTM C1063 Table 3 Summary Lath and Maximum Support Spacing

Lath Type	Weight of Metal Base	Walls		Ceilings	
		Wood	Steel	Wood	Steel
Diamond Mesh	2.5	16	16	12	12
	3.4	16	16	16	16
Flat Rib	2.75	16	16	16	16
	3.4	19	19	19	19
3/8" Hi Rib	3.4	24	24	24	24
Welded Wire	1.14	16	16	16	16
	1.95	24	24	24	24
Woven Wire	1.4	24	16	24	16

Structa Wire	Typical Uses	Stucco	Furr Depth
Structalath III	Alternative 1.75lb ML Typical Residential/Single standing commercial buildings	3 Coat Stucco – 7/8" - 3/4"	1/4" Furr
<u>Structalath</u> Twin Trac2.5	Alternative to 2.5lb ML Higher End Homes- Custom Multi Family- Multi Unit Commercial Steel Stud and Wood Frame	3 Coat Stucco – 7/8" - 3/4" Veneer Stone Applications	1/4" Furr
<u>Structalath</u> III 316 (Decreased Furr)	Alternative to 1.75lb ML Typical Residential/Single standing commercial buildings	One Coat or 1/2" stucco – over sheathing or over foam	3/16" Furr
<u>Structalath</u> Twin Trac 2.5 316(Decreased Furr)	Alternative to 2.5lb ML Multi Family – Commercial Steel Stud and Wood Frame	One Coat Stucco or 1/2" stucco – over sheathing or over foam	3/16" Furr
Mega Lath	Heavy Duty Product Higher end institutional and commercial Steel stud and Wood Frame	Everything and Everywhere where finer stucco is desired – smooth trowel and flat walls. Higher end stucco products Veneer Stone Applications .	1/4" Furr
VTWC Rib Lath	For use on overhead stucco areas – Commercial / Residential Steel and Wood Frame	One Coat and Three Coat applications Open frame or over sheathing	¼" Furr

A photograph of a multi-story building under construction. The structure is heavily encased in yellow and red scaffolding. The metal frame is visible, showing a complex arrangement of beams and supports. In the foreground, there are stacks of construction materials, including white panels and metal rods. The background shows a clear sky.

Metal Frame is
a challenge
60% of thermal
energy
transferred

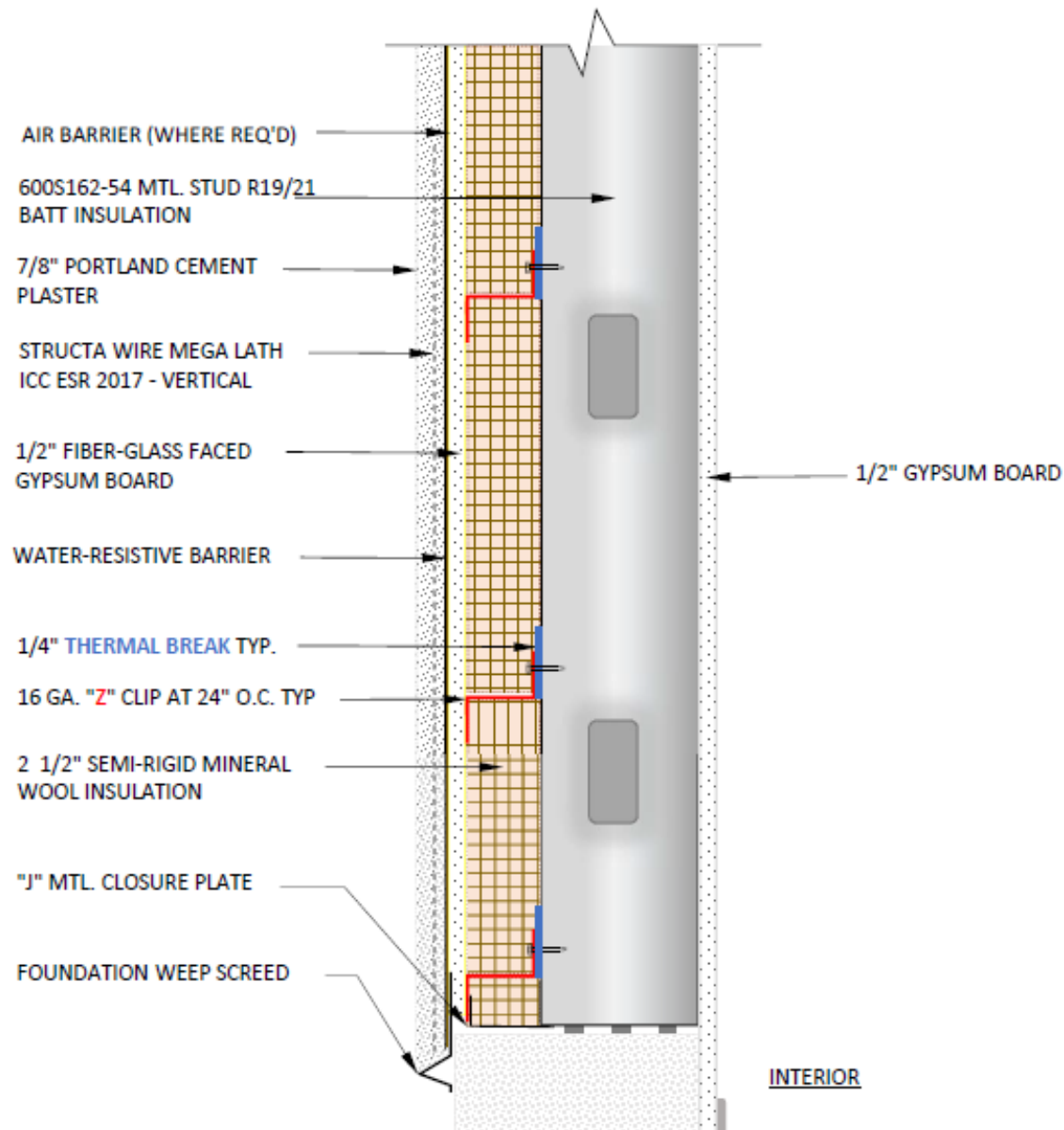


Alternatives To Improve Energy Efficiencies Of Stucco Systems

- Mega Lath Horizontal over EPS Foam behind 3 Coat Stucco
- Mega Lath Vertical with Exterior Insulation and Z channels behind 3 coat stucco
- SL 316 over EPS Foam with One Coat Stucco Systems
- EIFS



Z Clip Assembly

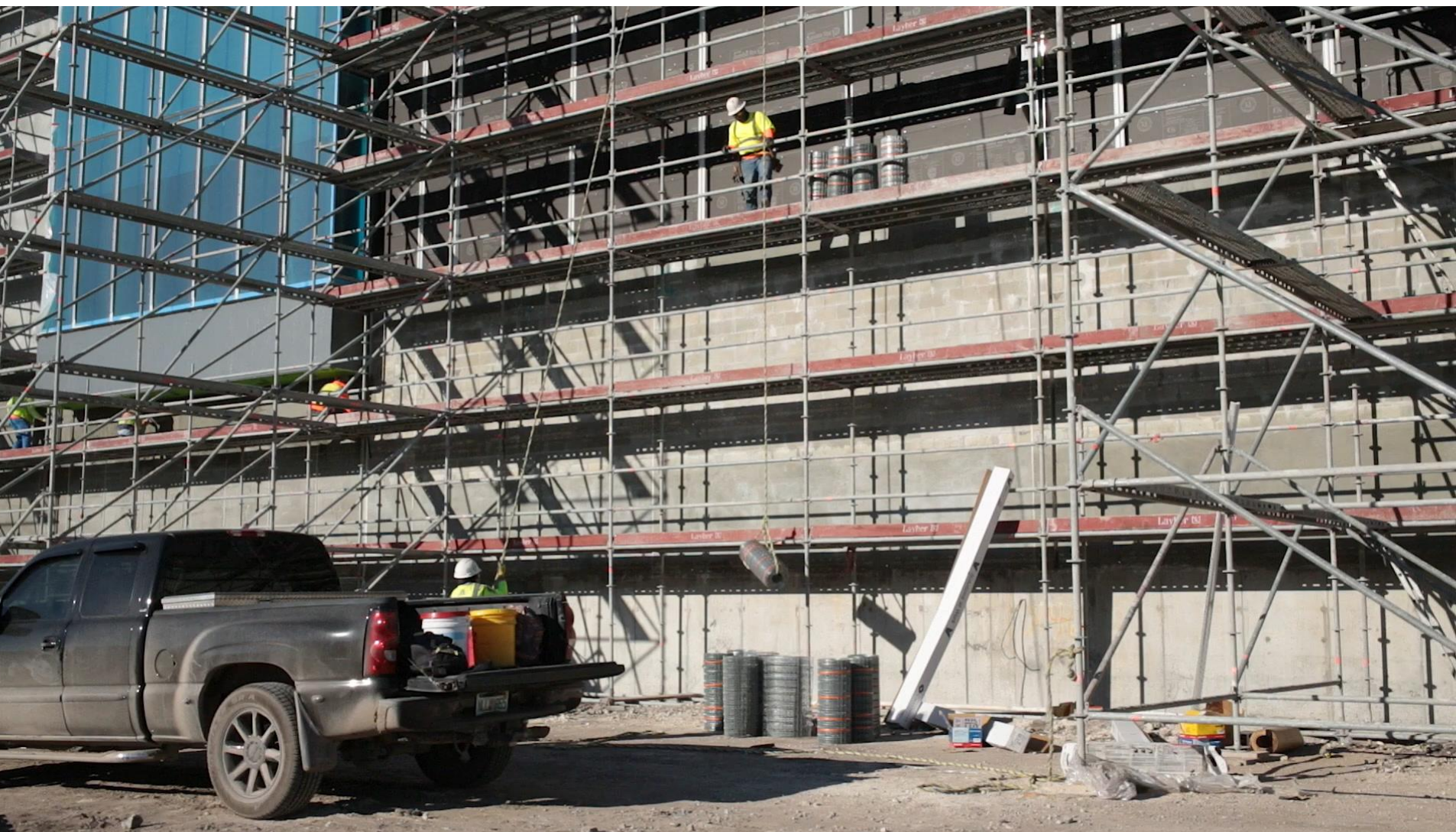






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Installation of Vertical STRUCTA MEGALATH

to ensure that cross wires are located over the Z-girts



Step 1

Determine the length of lath required and precut on the ground. Add a little bit to ensure the lath reaches the next girt if girt spacing is varying. e.g. if the desired length is 24 ft, make it 24.5 to 25 ft.

Step 2

Install 3 to 4 screws at top of desired lath start. Leave screws projecting about $\frac{1}{2}$ inch. Screws need to be longer than the normal lathing screws.

Step 3

Hang MEGALATH on the screws resting on the top cross wire. Let lath run all the way down. The same can be achieved by pulling the lath up from below.

Step 4

At top, place a lathing screw near middle of lath between TwinTrac wires and snug the screw. At bottom, align lath to desired vertical orientation, pull lath tight and install screw to hold lath in position. Do not completely snug the fastener tight.

Step 5

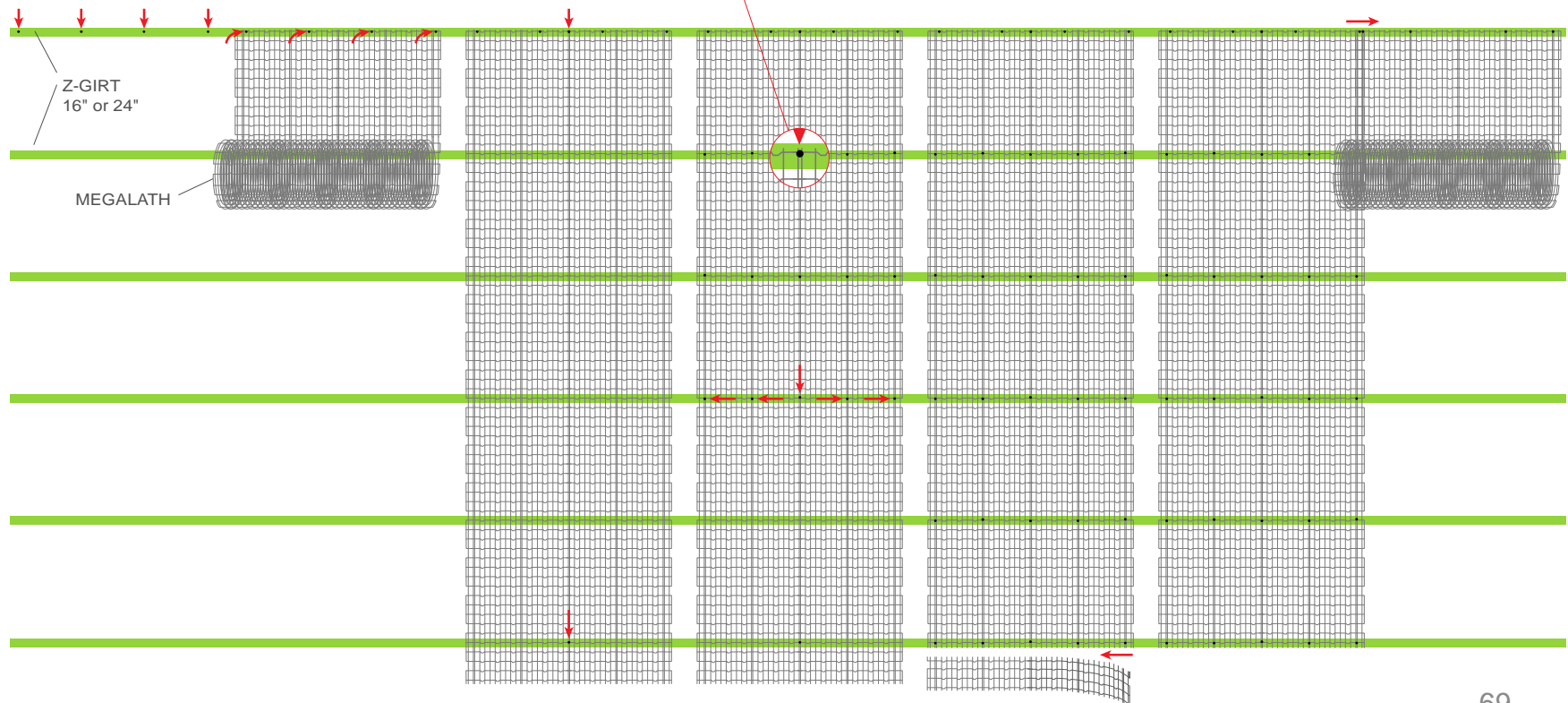
Starting at top, fasten off this lath course. Apply tension to the lath downward, and then outward as screws are applied to the sides. **Ensure that 75% of the fasteners are below the cross wire and 25% above.**

Step 6

Cut off extra lath at bottom, leave provision for one mesh overlap for subsequent continuation of the lath. It is important to only have a one mesh overlap if a control joint or expansion joint is to be installed in this location.

Step 7

Continue with adjacent courses.





Relevant ASTM Standards



- C 847 Metal Lath
- **C 933 Specification for Welded Wire Lath**
- C 1032 Specification for Woven Wire Plaster Base
- C 1063 Specification for Installation of Lathing and Furring to receive Interior and Exterior Portland Cement based Plaster
- C 926 Specification for Application for Portland Cement
- **A641 is "Standard Specification for Zinc-Coated (Galvanized) Carbon Steel Wire".**

PART 1.03

REFERENCE STANDARDS

A. ASTM International (ASTM): 1. ASTM A153 – Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware.

1. ASTM A641 – Standard Specification for Zinc-Coated (Galvanized) Carbon Steel Wire.

2. ASTM A653 – Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process.

3. ASTM C150 – Standard Specification for Portland Cement.

4. ASTM C841 - Standard Specification for Installation of Interior Lathing and Furring.

5. ASTM C847 - Standard Specification for Metal Lath.

6. ASTM C926 – Standard Specification for Application of Portland Cement-Based Plaster.

7. ASTM C933 – Standard Specification for Welded Wire Lath

8. ASTM C1002 - Standard Specification for Steel Self-Piercing Tapping Screws for the Application of Gypsum Panel Products or Metal Plaster Bases to Wood Studs or Steel Studs

9.. ASTM C1032 Woven Wire Plaster Base

10. ASTM C1063 - Standard Specification for Installation of Lathing and Furring to Receive Interior and Exterior Portland Cement-Based

PART 2 - PRODUCTS

2.01 METAL LATH AND WEATHER RESISTIVE BACKING

1. Metal Lath:

1. Walls and Ceilings: Diamond mesh expanded metal lath, in conformance to ASTM C847, without paper backing. 3.4 pounds per square yard, hot-dip galvanized coating G60 in accordance with ASTM A653. Alabama Metal Industries Corporation (AMICO), California Expanded Metal Products Company (CEMCO), ClarkDietrich, Marino-Ware, or equal.

a. V-grooved self-furring type for installation over sheathing. Lath shall be furred out a minimum of 1/4 inch when installed over a solid surface in accordance to DSAIR 25-4.

b. Flat type for installation over spaced framing.

2. Walls: Self-furring Welded Wire Lath: Weight 1.95 pounds per square yard, with Class 1 galvanized coating in conformance to ASTM A641. Structa Mega Lath per IAPM) ESR-2017, as manufactured by Structa Wire Corp, or equal.

3. V-Truss Ceiling Lath: Self-furring Welded Wire Lath: Weight 2.2 pounds per square yard, with Class 1 galvanized coating in conformance to ASTM A641 with heavy perforated Kraft paper. V-Truss per IAPMO ESR-2017, as manufactured by Structa Wire Corp, or equal.

GALVANIZING LATH – STANDARDS & SPECIFICATIONS

ZINC REQUIREMENT FOR LATH

Specifications for stucco reinforcing lath are as follows:

Lath Type: **Welded & Woven Wire**

Zinc Coating Requirement: **ASTM Class 1**

Lath Type: **Expanded Metal**

Zinc Coating Requirement: **G60**



EVALUATION REPORT

Number: **2017**

Originally Issued: 08/28/2015

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Valid Through: 08/31/2021

STRUCTA WIRE ULC
1395 NORTH GRANDVIEW HIGHWAY
VANCOUVER, BC V5N 1N2
(604) 254-9868
info@structawire.com
www.structawire.com

STRUCTALATH III NO. 17 SFCR,
STRUCTALATH NO. 17 SFCR TWIN TRAC 2.5,
STRUCTA MEGA LATH, STRUCTA MEGA
POWER TIE LATH, V-TRUSS WALLS AND
CEILINGS LATH, STRUCTALATH III 316 SFCR

CSI Section:
09 22 36.23 Metal Lath

act as reinforcement of exterior plaster complying with IBC Sections 2507 and 2512, or 2018 and 2015 IRC Section 703.7 (2012 and 2009 IRC Section R703.6).

3.1 Installation

3.3.1 Installation General: The laths shall be installed in accordance with IBC Section 2510, and either Section 2511 or 2512; 2018 and 2015 IRC Section R703.7 (2012 and 2009 IRC Section R703.6); ASTM C1063; or an evaluation report on exterior cementitious wall coating systems issued by an approved and accredited evaluation report service. The long dimension of the lath shall be perpendicular to supports, except that at gable walls on exterior installations, the lath may be installed with the long dimension parallel to the roof slope.



masterspec

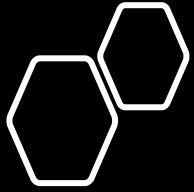
Environmentally Efficient



SPECIFICATIONS

As design professionals, what do we need to do to enable the stucco industry to utilize these lathing products on our projects?

- In the contract and bid documents the specifications need to state that ASTM/ ICC recognized alternate lathing products can be proposed as alternatives.



In Conclusion...

- There are many advantages to using stucco cladding but attention to details such as control joints is essential for a successful application.
- Stucco requires a lathing for attachment to a structure. There are three general types of lath.
- Welded wire lath can be used as a viable alternative for expanded metal lath.
- Careful lath specification that accounts for fastening, details, building movement minimizes cracking and improves the performance of stucco wall systems.
- Our UES Evaluation Report provides code compliance verification for ASTM requirements.

Questions?

Could you see the benefits of including ASTM C933 Welded Wire Lath in your Spec Documents?



Thank you!

Others services offered by **Structa Wire** include:

- **Specification Reviews:** We will review your specifications (Division 09 – 24-00) and return a copy to you. Contact:
- **Jan Finseth** – jan.finseth@clarkdietrich.com
- **Lola Wilson** – lola.wilson@clarkdietrich.com

- **Technical Literature:** Update your library with copies of our product binder. We are your source for all of your stucco reinforcing requirements. For the latest information visit us at **www.structawire.com**