SECTION 03100

CONCRETE FORMWORK

PART 1 –GENERAL

1.1 SECTION INCLUDES

A. Design, construction, erection and removal of structural concrete formwork.

1.2 MEASUREMENT AND PAYMENT

A. Unit prices.

1. Refer to Section 01200 – Measurement and Payment, for unit price procedures.

B. Stipulated Price (Lump Sum). If the Contract is a Stipulated Price Contract, payment for work in this section is included in the total Stipulated Price.

1.3 REFERENCE STANDARDS

A. ACI 117 - Standard Tolerances for Concrete Construction and Materials.

B. ACI 347 - Recommended Practice for Concrete Formwork.

C. U.S. Product Standard PS1 Construction & Industrial Plywood.

D. U.S. Product Standard PS20 American Softwood Lumber Standard.

1.4 SUBMITTALS

A. Conform to Section 01300 - Submittals.

B. Shop Drawings: Show location, member size and loading of shoring. When reshoring is permitted, submit plans showing locations and member size of reshoring.

C. Product Data and Samples:

1. Corrugated Fiberboard Carton Forms: Submit certification of compliance with design criteria, description of forms, and one-foot-long sample.

2. Form-coating Materials: Submit trade or brand names of manufacturers and complete description of products.

3. Form ties and related accessories, including taper tie plugs, if taper ties are used.

4. Form gaskets.

D. Detailed Layout for Slip-forming: Submit detailed layout of proposed slipforming, including description of equipment, rate of progress, and other data to show suitability of method. Show provisions for ensuring attainment of required concrete surface finish.

PART 2 –PRODUCTS

2.1 MATERIAL

A. Smooth Forms: New plywood, metal, plastic, tempered concrete-form hardboard, dressed lumber faced with plywood or fiberboard lining, or metal-framed plywood-faced panel material, to provide continuous, straight, smooth surfaces. Form material shall be free of raised grain, torn surfaces, worn edges, patches, dents or other defects. Furnish material in largest practical sizes to minimize number of joints and, when indicated on Drawings, conform to joint system indicated. Form material shall have sufficient strength and thickness to withstand pressure of newly placed concrete without bow or deflection.

B. Rough Forms: Plywood, metal, dressed or undressed lumber free of knots, splits or other defects, or other material acceptable to Engineer of sufficient strength and thickness to withstand pressure of newly placed concrete without bow or deflection.

C. Plywood: Conform to PS 1, Class 1.

D. Lumber: Conform to PS 20.

E. Edge Forms and Intermediate Screed Strips: Type and strength compatible with the screed equipment and methods used.

F. Plastic Forms: One-piece forms for domes, beams and pan joists. Single lengths for columns not exceeding height of 7'-6". For columns over 7'-6", use 7'-6" sections and filler sections as needed. To facilitate removal of pan joist forms, taper sides 1 inch per foot.

G. Metal Pan Joist Forms: Removable type; fabricated of minimum 14-gage steel; one piece between end closures. Adjustable forms not allowed. Taper sides 1 inch per foot to facilitate removal.

H. Earth Cuts for Forms:

1. Use earth cuts for forming unexposed sides of grade beams cast monolithically with slabs on grade.

2. Where sides of excavations are stable enough to prevent caving or sloughing, following surfaces may be cast against neat-cut excavations:

a. Sides of footings.

b. Inside face of perimeter grade beams not monolithic with slab on grade. When inside face is cast against earth, increase beam width indicated on Drawings by 1 inch.

c. Both faces of interior grade beams not monolithic with slab on grade. When grade beam is cast against earth, increase beam width indicated on Drawings by 2 inches.

I. Corrugated Fiberboard Carton Forms:

1. Corrugated fiberboard carton forms, when called for, are intended to form a void space beneath pile-supported and pier-supported slabs and other structural elements as shown.

2. Provide products of a reputable manufacturer regularly engaged in commercial production of double-faced corrugated fiberboard carton forms, constructed of waterproof paper and

laminated with waterproof adhesive.

3. Fiberboard forms: Capable of supporting required dead load plus construction loads, and designed to lose their strength upon prolonged contact with moisture and soil bacteria.

4. Seal cuts and ends of each form section by dipping in waterproof wax, unless liners and flutes are completely impregnated with waterproofing.

5. Size forms as indicated on Drawings. Assemble as recommended by manufacturer, either with steel banding at 4'-0" maximum on centers, or, where liners and flutes are impregnated with waterproofing, with adequate stapling.

J. Circular Forms:

1. Form round-section members with paper or fiber tubes, constructed of laminated plies using water-resistant adhesive with wax-impregnated exterior for weather and moisture protection. Provide units with sufficient wall thickness to resist loads imposed by wet concrete without deformation. Provide manufacturer's seamless units to minimize spiral gaps and seams.

2. Fiberglass or steel forms may be used for round-section members.

K. Shores: Wood or adjustable metal, with bearing plates; with double wedges at lower end.

L. Form Ties:

1. Use commercially-manufactured ties, hangers and other accessories for embedding in concrete. Do not use wire not commercially fabricated for use as a form accessory.

2. Fabricate ties so ends or end fasteners can be removed without causing spalling of concrete faces. Depth from formed concrete face to the embedded portion: At least 1 inch, or twice the minimum dimension of tie, whichever is greater.

3. Provide waterstop feature for form ties used on liquid-containing structures and on concrete walls which will have earth backfill on one side.

4. Removable ties: Taper ties may be used when approved by the Owner. In the hole left by the removal of the taper tie, insert a preformed neoprene or polyurethane plug sized to seat at the center of the wall.

M. Form Coating: Commercial formulation of form oil or form-release agent having proven satisfactory performance. Coating shall not bond with, stain or otherwise adversely affect concrete surfaces, or impair their subsequent treatment, including application of bonding agents, curing compounds, paint, protective liners and membrane waterproofing.

N. Coating for Plastic Forms: Alkali-resistant gel-coat.

O. Chamfer Strips: Unless otherwise indicated on Drawings, provide 3/4 inch chamfer strips in corners of forms to produce beveled edges where required by Part 3, Execution.

P. Form Gaskets: Polyethylene rod, closed cell, 1-inch diameter.

2.2 DESIGN OF FORMWORK

A. Conform to ACI 117, ACI 347 and Owner building codes, unless more restrictive requirements are specified or shown on Drawings. Contractor shall design and engineer concrete formwork, including shoring and bracing. Design formwork for applicable gravity loads, lateral pressure, wind loads and allowable stresses. Camber formwork to compensate for anticipated deflection during placement of concrete when required to maintain specified tolerances. Design formwork to be readily removed without impact, shock or damage to concrete surfaces and adjacent materials.

B. Slip Forming: Permitted on written approval of Owner. Contractor shall demonstrate suitability of method proposed.

PART 3 –EXECUTION

3.1 INSTALLATION

A. Formwork Construction

1. Construct and maintain formwork so that it will maintain correct sizes of members, shape, alinement, elevation and position during concrete placement and until concrete has gained sufficient strength. Provide for required openings, offsets, sinkages, keyways, recesses, moldings, anchorages and inserts.

2. Construct forms for easy removal without damage to concrete surfaces.

3. Make formwork sufficiently tight to prevent leakage of cement paste during concrete placement. Solidly butt joints and provide backup material at joints as required to prevent leakage and fins. Provide gaskets for wall forms to prevent concrete paste leakage at their base.

4. Place chamfer strips in forms to bevel edges and corners permanently exposed to view, except top edges of walls, and slabs which are indicated on Drawings to be tooled. Do not bevel edges of formed joints and interior corners unless indicated on Drawings. Form beveled edges for vertical and horizontal corners of equipment bases. Unless otherwise indicated on Drawings, make bevels 3/4 inch wide.

5. Provide temporary openings at bases of column and wall forms and other points as required for observation and cleaning immediately before concrete is placed.

6. Where runways are required for moving equipment, support runways directly on the formwork or structural members. Do not allow runways or supports to rest on reinforcing steel.

7. Use smooth forms on formed concrete surfaces required to have smooth form finish or rubbed finish as specified in Section 03345 - Concrete Finishing.

8. Rough forms may be used on formed concrete surfaces indicated to have rough form finish as specified in Section 03345 - Concrete Finishing.

B. Forms for Surfaces Requiring Smooth Form Finish:

1. Drill forms to suit ties used and to prevent leakage of concrete mortar around tie holes. Uniformly space form ties and align in horizontal and vertical rows. Install taper ties, if used, with the large end on the wet face of the wall.

2. Provide sharp, clean corners at intersecting planes, without visible edges or offsets. Back up joints with extra studs or girts to maintain true, square intersections.

3. Form molding shapes, recesses and projections with smooth-finish materials and install in forms with sealed joints to prevent displacement.

4. Form exposed corners of beams and columns to produce square, smooth, solid, unbroken lines.

5. Provide exterior exposed edges with 3/4-inch chamfer or 3/4-inch radius.

6. Arrange facing material in orderly and symmetrical fashion. Keep number of joints to practical minimum. Support facing material adequately to prevent deflection in excess of allowable tolerances.

7. For flush surfaces exposed to view in completed structure, overlap previously- placed hardened concrete with form sheathing by approximately 1 inch. Hold forms against hardened concrete to maintain true surfaces, preventing offsets or loss of mortar.

C. Forms for Surfaces Requiring Rubbed Finish: Provide forms as specified in paragraph 3.01B, Smooth Form Finish. Use smooth plywood or fiberboard linings or forms, in as large sheets as practicable, and with smooth, even edges and close joints.

D. Edge Forms and Screed Strips for Slabs: Set edge forms or bulkheads and intermediate screed strips for slabs to obtain required elevations and contours in finished slab surface. Provide and secure supports for types of screeds required.

E. Circular Forms: Set forms in one piece for full height of member.

F. Surfaces to Receive Membrane Waterproofing: Coordinate surface finish, anchors, reglets and similar requirements with membrane waterproofing applicator.

G. Fireproofing Steel Member: Construct forms to provide not less than the concrete thickness necessary, measured from face of steel member, to provide the required fire rating. Forms for concealed surfaces may be unlined.

H. Tolerances:

1. Unless noted otherwise on Drawings, construct formwork so concrete surfaces will conform to tolerance limits listed in Tables 03100A and 03100B at end of this Section.

2. Establish sufficient control points and bench marks as references for tolerance checks. Maintain these references in undisturbed condition until final completion and acceptance of the Work.

I. Adjustment of Formwork:

1. Use wedges or jacks to provide positive adjustment of shores and struts. After final inspection and before concrete placement, fasten in position wedges used for final adjustment of forms.

2. Brace forms securely against lateral deflections. Prepare to compensate for settling during concrete placement.

3. For wall openings, construct wood forms that facilitate necessary loosening to counteract

TABLE 03100A
TOLERANCES FOR FORMED SURFACES
CONCRETE IN BUILDINGS**

VARIATION FROM	VARIATION IN	FOR ANY 10-FOOT LENGTH	FOR ANY 20-FOOT LENGTH OR ANY BAY	MAXIMUM FOR ENTIRE DIMENSION
PLUMB OR SPECIFIED BATTER	LINES AND SURFACES OF COLUMNS, PIERS, WALLS AND ARRISES	1/4"	---	1"
	EXPOSED CORNER COLUMNS, CONTROL JOINT GROOVES, AND OTHER CONSPICUOUS LINES	---	1/4"	1/2"
LEVEL OR SPECIFIED GRADE	SLAB SOFFITS, CEILINGS, BEAM SOFFITS, AND ARRISES (MEASURED BEFORE REMOVAL OF SHORES)	1/4"	3/8"	3/4"
	EXPOSED LINTELS, SILLS, PARAPETS, HORIZONTAL GROOVES AND OTHER CONSPICUOUS LINES	---	1/4"	1/2"
DRAWING DIMENSIONS	POSITION OF LINEAR BUILDING LINES, COLUMNS, WALLS, AND PARTITIONS	---	1/2"	1"
	SIZE AND LOCATION OF SLEEVES, FLOOR OPENINGS AND WALL OPENINGS	---	---	±1/4"
	CROSS SECTION OF COLUMNS, BEAMS, SLABS, AND WALLS	---	---	+1/2", -1/4"
	FOOTINGS* IN PLAN	---	---	+2", -1/2"
	FOOTING MISPLACEMENT OR ECCENTRIOWNER IN DIRECTION OF ERROR (THE LESSER OF)	---	---	2% OF WIDTH OR 2"
	FOOTING THICKNESS DECREASE	---	---	5%
	FOOTING THICKNESS INCREASE	---	---	NO LIMIT
	STEP RISE IN FLIGHT OF STAIRS	---	---	±1/8"
	STEP TREAD IN FLIGHT OF STAIRS	---	---	±1/4"
	CONSECUTIVE STEP RISE	---	---	±1/16"
	CONSECUTIVE STEP TREAD	---	---	±1/8"

* Footing tolerances apply to concrete dimensions only, not to positioning of vertical reinforcing steel, dowels, or embedded items.

** Includes water and wastewater process structures.

TABLE 03100B
TOLERANCES FOR FORMED SURFACES
CONCRETE IN BRIDGES, WHARVES AND MARINE STRUCTURES

VARIATION FROM	VARIATION IN	MAXIMUM
PLUMB OR SPECIFIED BATTER	SURFACES OF COLUMNS, PIERS AND WALLS	1/2" in 10'
LEVEL OR SPECIFIED GRADE	TOP SURFACES OF SLABS	See Section 03345
	TOP SURFACES OF CURBS AND RAILINGS	3/16" in 10'
DRAWING DIMENSIONS	CROSS SECTION OF COLUMNS, CAPS, WALLS, BEAMS AND SIMILAR MEMBERS	+1/2", -1/4"
	THICKNESS OF DECK SLABS	+1/4", - 1/8"
	SIZE AND LOCATION OF SLAB AND WALL OPENINGS	± 1/2"
	FOOTINGS IN PLAN	+2", -1/2"
	FOOTING MISPLACEMENT OR ECCENTRIOWNER IN DIRECTION OF ERROR (THE LESSER OF)	2% of WIDTH OR 2"
	FOOTING THICKNESS DECREASE	5%
	FOOTING THICKNESS INCREASE	NO LIMIT
	STEP RISE IN FLIGHT OF STAIRS	±1/8"
	STEP TREAD IN FLIGHT OF STAIRS	±1/4"
	CONSECUTIVE STEP RISE	±1/16"
	CONSECUTIVE STEP TREAD	±1/8"

END OF SECTION

M. CRSI MSP-1 - Manual of Standard Practice.

1.4 SUBMITTALS

A. Conform to Section 01300 - Submittals.

B. Shop Drawings:

1. Submit shop drawings detailing reinforcement fabrication, bar placement location, splices, spacing, bar designation, bar type, length, size, bending, number of bars, bar support type and other pertinent information, including dimensions. Provide sufficient detail for placement of reinforcement without use of Contract Drawings. Information shall correspond directly to data listed on bill of materials.

2. Use of reproductions of Contract Drawings by Contractor, Subcontractor, erector, fabricator or material supplier in preparation of shop drawings (or in lieu of preparation of shop drawings) signifies acceptance by that party of information shown thereon as correct, and acceptance of obligation to pay for any job expense, real or implied, arising due to errors that may occur thereon. Remove references to Design Engineer, including seals, when reproductions of Contract Drawings are used as shop drawings.

3. Detail shop drawings in accordance with ACI 315, Figure 6.

4. Submit shop drawings showing location of proposed additional construction joints as required under Section 03250 - Joints in Concrete Structures, and obtain approval of Owner, prior to submitting reinforcing steel shop drawings.

C. Bill of Materials: Submit with shop drawings.

D. Product Data:

1. Mechanical Bar Splices: Submit manufacturer's technical literature, including specifications and installation instructions.

2. Epoxy grout proposed for anchoring reinforcing dowels to hardened concrete: Submit manufacturer's technical literature including recommended installation procedures.

E. Certificates:

1. Submit steel manufacturer's certificates of mill tests giving properties of steel proposed for use. List manufacturer's test number, heat number, chemical analysis, yield point, tensile strength and percentage of elongation. Identify proposed location of steel in work.

2. Foreign-manufactured reinforcing bars shall be tested for conformance to ASTM requirements by a certified independent testing laboratory located in United States. Certification from any other source is not acceptable. Submit test reports for review. Do not begin fabrication of reinforcement until material has been approved.

1.5 HANDLING AND STORAGE

A. Store steel reinforcement above ground on platforms, skids or other supports. Protect reinforcing from mechanical injury, surface deterioration and formation of excessive, loose or flaky rust caused by exposure to weather. Protect epoxy-coated reinforcing from formation of any amount of rust.

1.6 QUALITY CONTROL

A. Notify Owner at least 24 hours before concrete placement so that reinforcement may be inspected, and errors corrected, without delaying Work.

PART 2 –PRODUCTS

2.1 MATERIAL

A. Reinforcing Bars: Deformed bars conforming to ASTM A615, grade as indicated on Drawings, except column spirals and those shown on Drawings to be smooth bars. Where grade is not shown on Drawings, use Grade 60.

B. Smooth Bars: Where indicated on Drawings, use smooth bars conforming to ASTM A36; ASTM A615, Grade 60; or ASTM A675, Grade 70.

C. Column Spirals: Bars conforming to ASTM A615, Grade 60, or wire conforming to ASTM A82.

D. Epoxy-Coated Deformed Bars, Column Spirals and Smooth Bars: Conform to ASTM A775/A775M.

E. Welded Wire Fabric:

1. Welded Smooth Wire Fabric: Conform to ASTM A185.

2. Welded Deformed Wire Fabric: Conform to ASTM A497.

3. Provide wire size, type and spacing as shown. Where type is not shown on Drawings, use welded smooth wire fabric.

4. Furnish welded wire fabric in flat sheets only.

F. Tie Wire: 16-1/2 gage or heavier annealed steel wire. Use plastic-coated tie wire with epoxy-coated reinforcing steel.

G. Bar Supports: Provide chairs, riser bars, ties and other accessories made of plastic or metal, except as otherwise specified. Use bar supports and accessories of sizes required to provide required concrete cover. Where concrete surfaces are exposed to weather, water or wastewater, provide plastic accessories only; do not use galvanized or plastic-tipped metal in such locations. Provide metal bar supports and accessories rated Class 1 or 2 conforming to CRSI MSP-1 Manual of Standard Practice. Use epoxy-coated bar supports with epoxy-coated reinforcing bars.

H. Slabs on Grade: Provide chairs with sheet metal bases or provide precast concrete bar

supports 3 inches wide, 6 inches long, and thick enough to allow required cover. Embed tie wires in 3-inch by 6-inch side.

I. Mechanical Bar Splices:

1. Conform to ACI 318; use where indicated on Drawings.

a. Compression splices shall develop ultimate stress of reinforcing bar.

b. Tension splices shall develop 125 percent of minimum yield point stress of reinforcing bar.

2. Regardless of chemical composition of steel, any heat effect shall not adversely affect performance of reinforcing bar.

J. Welded Splices:

1. Provide welded splices where shown and where approved by the Owner. Welded splices of reinforcing steel shall develop a tensile strength exceeding 125 percent of the yield strength of the reinforcing bars connected.

2. Provide materials for welded splices conforming to AWS D1.4.

K. Epoxy Grout: High-strength rigid epoxy adhesive, conforming to ASTM C881, Type IV, manufactured for purpose of anchoring dowels into hardened concrete and the moisture condition, application temperature and orientation of the hole to be filled. Unless otherwise shown, depth of embedment shall be as required to develop the full tensile strength (125 percent of yield strength) of dowel, but not less than 12 diameters.

2.2 FABRICATION

A. Bending: Fabricate bars to shapes indicated on Drawings by cold bending. Bends shall conform to minimum bend diameters specified in ACI 318. Do not straighten or rebend bars. Fabricate epoxy-coated reinforcing steel to required shapes in a manner that will not damage epoxy coating. Repair any damaged epoxy coating with patching material conforming to Item 4.4 of ASTM A775/A775M.

B. Splices:

1. Locate splices as indicated on Drawings. Do not locate splices at other locations without approval of Engineer. Use minimum number of splices located at points of minimum stress. Stagger splices in adjacent bars.

2. Length of lap splices: As shown on Drawings.

3. Prepare ends of bars at mechanical splices in accordance with splice manufacturer's requirements.

C. Construction Joints: Unless otherwise shown, continue reinforcing through construction joints.

D. Bar Fabrication Tolerances: Conform to tolerances listed in ACI 315, Figures 4 and 5.

E. Standard Hooks: Conform to the requirements of ACI 318.

F. Marking: Clearly mark bars with waterproof tags showing number of bars, size, mark, length and yield strength. Mark steel with same designation as member in which it occurs.

PART 3 –EXECUTION

3.1 PREPARATION

A. Clean reinforcement of scale, loose or flaky rust and other foreign material, including oil, mud or coating that will reduce bond to concrete.

3.2 INSTALLATION

A. Placement Tolerances: Place reinforcement within tolerances of Table 03210A at the end of this Section. Bend tie wire away from forms to maintain the specified concrete coverage.

B. Interferences: Maintain 2-inch clearance from embedded items. Where reinforcing interferes with location of other reinforcing steel, conduit or embedded items, bars may be moved within specified tolerances or one bar diameter, whichever is greater. Where greater movement of bars is required to avoid interference, notify Owner. Do not cut reinforcement to install inserts, conduit, mechanical openings or other items without approval of Owner.

C. Concrete Cover: Provide clear cover measured from reinforcement to face of concrete as listed in Table 03210B at the end of this Section, unless otherwise indicated on Drawings.

D. Placement in Forms: Use spacers, chairs, wire ties and other accessory items necessary to assemble, space and support reinforcing properly. Provide accessories of sufficient number, size and strength to prevent deflection or displacement of reinforcement due to construction loads or concrete placement. Use appropriate accessories to position and support bolts, anchors and other embedded items. Tie reinforcing bars at each intersection, and to accessories. Blocking reinforcement with concrete or masonry is prohibited.

E. Placement for Concrete on Ground: Support bar and wire reinforcement on chairs with sheet metal bases or precast concrete blocks spaced at approximately 3 feet on centers each way. Use minimum of one support for each 9 square feet. Tie supports to reinforcing bars and wires.

F. Vertical Reinforcement in Columns: Offset vertical bars by at least one bar diameter at splices. Provide accurate templates for column dowels to ensure proper placement.

G. Splices:

1. Do not splice bars, except at locations indicated on Drawings or reviewed shop drawings, without approval of Owner.

2. Lap Splices: Unless otherwise shown or noted, Class B, conforming to ACI 318-89, Section 12.15.1. Tie securely with wire prior to concrete placement, to prevent displacement of splices during concrete placement.

3. Mechanical Bar Splices: Use only where indicated on Drawings. Install in accordance with manufacturer's instructions.

   a. Couplers located at a joint face shall be of a type which can be set either flush or recessed from the face as shown. Seal couplers prior to concrete placement to

completely eliminate concrete or cement paste from entering.

b. Couplers intended for future connections: Recess 1/2inch minimum from concrete surface. After concrete is placed, plug coupler and fill recess with sealant to prevent contact with water or other corrosive materials.

c. Unless noted otherwise, match mechanical coupler spacing and capacity to that shown for the adjacent reinforcing.

H. Construction Joints: Place reinforcing continuous through construction joints, unless noted otherwise.

I. Welded Wire Fabric: Install wire fabric in as long lengths as practicable. Unless otherwise indicated on Drawings, lap adjoining pieces at least 6 inches or one full mesh plus 2 inches, whichever is larger. Lace splices with wire. Do not make end laps midway between supporting beams, or directly over beams of continuous structures. Offset end laps in adjacent widths to prevent continuous laps. Conform to WRI - Manual of Standard Practice for Welded Wire Fabric.

J. Field Bending: Shape reinforcing bent during construction operations to conform to Drawings. Bars shall be cold-bent; do not heat bars. Closely inspect reinforcing for breaks. When reinforcing is damaged, replace, Cadweld, or otherwise repair, as directed by Owner. Do not bend reinforcement after it is embedded in concrete.

K. Epoxy-coated Reinforcing Steel: Install in accordance with Paragraph 3.02 J, Field Bending, and in a manner that will not damage epoxy coating. Repair damaged epoxy coating with patching material as specified in Paragraph 2.02 A, Bending.

L. Field Cutting: Cut reinforcing bars by shearing or sawing. Do not cut bars with cutting torch.

M. Welding of reinforcing bars is prohibited, except where shown on Drawings.

3.3 GROUTING OF REINFORCING AND DOWEL BARS

A. Use epoxy grout for anchoring reinforcing and dowel steel to existing concrete in accordance with epoxy manufacturer's instructions. Drill hole not more than 1/4 inch larger than steel bar diameter (including height of deformations for deformed bars) in existing concrete. Just before installation of steel, blow hole clean of all debris using compressed air. Partially fill hole with epoxy, using enough epoxy so when steel bar is inserted, epoxy grout will completely fill hole around bar. Dip end of steel bar in epoxy and twist bar while inserting into partially-filled hole.

[Tables 03210A and 03210B: See following pages]

TABLE 03210A
REINFORCEMENT PLACEMENT TOLERANCES

PLACEMENT	TOLERANCE IN INCHES
Clear Distance -	
To formed soffit:	-1/4
To other formed surfaces:	□1/4
Minimum spacing between bars:	-1/4
Clear distance from unformed surface to top reinforcement -	
Members 8 inches deep or less:	□1/4
Members more than 8 inches deep but less than 24 inches deep:	-1/4, +1/2
Members 24 inches deep or greater:	-1/4, +1
Uniform spacing of bars (but the required number of bars shall not be reduced):	□2
Uniform spacing of stirrups and ties (but the required number of stirrups and ties shall not be reduced):	□1
Longitudinal locations of bends and ends of reinforcement -	
General:	□2
Discontinuous ends of members:	□1/2
Length of bar laps:	-1-1/2
Embedded length -	
For bar sizes No. 3 through 11:	-1
For bar sizes No. 14 and 18:	-2

TABLE 03210B
MINIMUM CONCRETE COVER FOR REINFORCEMENT

SURFACE	MINIMUM COVER IN INCHES
Slabs and Joists -	
Top and bottom bars for dry conditions -	
No. 14 and No. 18 bars:	1-1/2
No. 11 bars and smaller:	1
Formed concrete surfaces exposed to earth, water or weather; over, or in contact with, sewage; and for bottoms bearing on work mat, or slabs supporting earth cover -	
No. 5 bars and smaller:	1-1/2
No. 6 through No. 18 bars:	2
Beams and Columns -	

For dry conditions - Stirrups, spirals and ties: Principal reinforcement: Exposed to earth, water, sewage or weather - Stirrups and ties: Principal reinforcement:	 1-1/2 2 2 2-1/2
Walls - For dry conditions - No. 11 bars and smaller: No. 14 and No. 18 bars: Formed concrete surfaces exposed to earth, water, sewage or weather, or in contact with ground - Circular tanks with ring tension: All others:	 1 1-1/2 2 2
Footings and Base Slabs - At formed surfaces and bottoms bearing on concrete work mat: At unformed surfaces and bottoms in contact with earth: Over top of piles: Top of footings -- same as slabs	 2 3 2

END OF SECTION

SECTION 03250

JOINTS IN CONCRETE STRUCTURES

PART 1 – G E N E R A L

1.1 SECTION INCLUDES

A. Waterstops and similar joints in concrete structures intended to retain water or withstand hydrostatic pressure.

1.2 MEASUREMENT AND PAYMENT

A. Unit prices.
   1. Refer to Section 01200 – Measurement and Payment, for unit price procedures.

B. Stipulated Price (Lump Sum). If the Contract is a Stipulated Price Contract, payment for work in this section is included in the total Stipulated Price.

1.3 REFERENCES

A. Federal Specification TT-S-0227E(3) Sealing Compound, Elastomeric Type, Multi-Component, for Caulking, Sealing and Glazing Buildings and Other Structures.

B. U.S. Army Corps of Engineers Specification CRD-C572 PVC Waterstop.

C. ASTM A775 - Standard Specification for Epoxy-Coated Reinforcing Steel Bars.

D. ASTM C920 - Specification for Elastomeric Joint Sealants.

E. ASTM D412 - Test Methods for Rubber Properties in Tension.

F. ASTM D624 - Test Method for Rubber Property -- Tear Resistance.

G. ASTM D638 - Test Method for Tensile Properties of Plastics.

H. ASTM D746 - Test Method for Brittleness Temperature of Plastics and Elastomers by Impact.

I. ASTM D747 - Test Method for Apparent Bending Modulus of Plastics by Means of a Cantilever Beam.

J. ASTM D1056 - Specification for Flexible Cellular Materials -- Sponge or Expanded Rubber.

K. ASTM D1752 - Specification for Preformed Sponge Rubber and Cork Expansion Joint Fillers for Concrete Paving and Structural Construction.

L. ASTM D2000 - Specification for Rubber Products in Automotive Applications.

M. ASTM D2240 - Test Method for Rubber Property -- Durometer Hardness.

N. ASTM D2241 - Specification for PVC Tubing.

1.4 DEFINITIONS

A. The following definitions refer to concrete joints in water-retaining structures. Unless otherwise indicated, all such joints shall have a waterstop or sealant groove to prevent water penetration

at the joint.

B. Construction Joint: The joint or surface between two concrete pours, produced by placing fresh concrete in contact with a hardened concrete surface.

1. A bond breaker may or may not be used, as indicated.

2. Reinforcing steel is continuous through the joint, unless otherwise indicated.

C. Contraction Joint: A joint similar to a construction joint, but intended to accommodate concrete shrinkage and similar movement.

1. A bond breaker is always used.

2. Reinforcing steel is held back 4-1/2 inches from the joint surface, and sleeved dowels are used so pours can move apart, unless otherwise indicated.

D. Expansion Joint: A joint similar to a construction or contraction joint, but intended to accommodate both expansion and contraction.

1. Compressible joint filler is placed against the hardened concrete, to form and separate the second pour so pours can move together or apart.

2. A centerbulb waterstop and joint sealant are used to fill the gap, unless otherwise indicated.

3. Reinforcing steel is held back, and sleeved dowels are used to allow and control movement, unless otherwise indicated.

E. Control Joint: A groove cut or formed in the face of a single pour, producing a weaker plane more likely to crack; used in an attempt to control locations of normal shrinkage cracks.

1. Joint sealant is used to fill the groove.

2. Reinforcing steel is continuous, since the pour is monolithic.

1.5 SUBMITTALS

A. Submit under provisions of Section 01300 - Submittals.

B. Product Data: Information sufficient to indicate compliance with Contract Documents, including manufacturer's descriptive literature and specifications.

C. Shop Drawings: Indicate type, size and location of each joint in each structure, and installation details.

D. Samples: For extrusions, submit 6-inch lengths. For molded or fabricated items, submit whole items. Submit 6-inch beads for sealants and 6-inch square samples for coatings, on appropriate substrates.

E. Quality Control Submittals: Submit manufacturer's instructions and recommendations for storage, handling and installation including material safety data sheets, and, where specified, test reports certified by an independent testing laboratory or the manufacturer, and manufacturer's certification that products furnished comply with Contract Documents.

1.6 QUALITY CONTROL

A. Waterstop Inspection: Notify Engineer to schedule inspection at least 24 hours prior to work involving waterstop installation or fabrication of waterstop field joints.

B. Defects include but are not limited to the following:
   1. Offsets at joints greater at any point than 1/16 inch or 15 percent of material thickness, whichever is less.

   2. Exterior cracks at joints due to incomplete bond, which are deeper at any point than 1/16 inch or 15 percent of material thickness, whichever is less.

   3. At any point, any combination of offsets or exterior cracks resulting in a net reduction in the cross-sectional area of the waterstop greater than 1/16 inch or 15 percent of material thickness at any point, whichever is less.

   4. Misalignment of joint resulting in misalignment of the waterstop in excess of 1/2 inch in 10 feet.

   5. Porosity in the welded joint as evidenced by visual inspection.

   6. Bubbles or inadequate bond which can be detected with a pen knife. If, while probing the joint with the point of a pen knife, the knife breaks through the outer portion of the weld into a bubble, the joint is defective.

C. Field Joint Samples: Prior to use of the waterstop material in the field, fabricate and submit for review a sample of a fabricated mitered cross and a tee constructed of each size or shape of material to be used. Fabricate samples so material and workmanship represent fittings to be furnished. Field samples of fabricated fittings (crosses, tees, etc.) will be selected at random by the Owner for testing by a laboratory at Owner's expense; they shall have a tensile strength across the joints equal to at least 600 psi when tested in accordance with ASTM D638. Contractor shall pay cost of failed tests and retesting required by failures.

D. Construction Joint Sealant: Prepare adhesion and cohesion test specimens, as specified, at intervals of 5 working days while sealants are being installed.

E. Sealant material shall show no signs of adhesive or cohesive failure when tested in accordance with the following procedure in laboratory and field tests:

   1. Prepare sealant specimen between 2 concrete blocks (1 inch by 2 inches by 3 inches); spacing between the blocks shall be 1 inch. Use coated spacers (2 inches by 1-1/2 inches by 1/2 inch) to ensure sealant cross-sections of 1/2 inch by 2 inches with a width of 1 inch.

   2. Cast and cure sealant according to manufacturer's recommendations except that curing period shall be not less than 24 hours.

   3. Following curing period, widen the gap between blocks to 1-1/2 inches. Use spacers to maintain this gap for 24 hours prior to inspection for failure.

F. Sealant Installer: A competent waterproofing specialty contractor, approved by sealant manufacturer, having a record of successful performance in similar installations. Before beginning work, sealant manufacturer's representative shall instruct installer's crew in proper method of application.

1.7 WARRANTY

A. Provide a written warranty covering entire sealant installation against faulty and incompatible

materials and workmanship, and agreeing to repair or replace defective work at no additional cost to the Owner, for a period of 5 years.

1.8 DELIVERY, STORAGE AND HANDLING

A. Deliver, store and handle materials in accordance with manufacturer's printed instructions.

B. Store waterstops to permit free circulation of air around waterstop material.

PART 2 –PRODUCTS

2.1 EPA POTABLE CLASSIFICATION

A. All joint materials shall be materials that reach acceptability for use in potable water systems no later than 30 days after installation, as classified by the Environmental Protection Agency.

2.2 PVC WATERSTOPS

A. Extrude from virgin polyvinyl chloride elastomer. Use no reclaimed or scrap material. Submit waterstop manufacturer's current test reports and manufacturer's written certification that the material furnished meets or exceeds Corps of Engineers Specification CRD-C572 and other specified requirements.

B. Flat Strip and Center-Bulb Waterstops: As detailed, and as manufactured by: Kirkhill Rubber Co., Brea, California; Water Seals, Inc., Chicago, Illinois; Progress Unlimited, Inc., New York, New York; Greenstreak Plastic Products Co., St. Louis, Missouri; or equal acceptable to the Engineer, provided that at no place shall waterstop thickness be less than 3/8 inch.

C. Multi-Rib Waterstops: As detailed, and as manufactured by Water Seals, Inc., Chicago, Illinois; Progress Unlimited, Inc., New York, New York; Greenstreak Plastic Products Co., St. Louis, Missouri; or equal acceptable to the Engineer. Use prefabricated joint fittings at intersections of ribbed-type waterstops.

D. Other Waterstops: When types of waterstops not listed above are indicated on the Drawings, they are subject to these specifications.

E. Waterstop Properties: When tested in accordance with specified standards, waterstop material shall meet or exceed the following requirements:

Physical Property, Sheet Material	Value	ASTM Standard
Tensile Strength-min (psi):		1750 D638, Type IV
Ultimate Elongation-min (percent):	350	D638, Type IV
Low Temp Brittleness-max (degrees F):	-35	D746
Stiffness in Flexure-min (psi):		400 D747
Accelerated Extraction (CRD-C572) -		
Tensile Strength-min (psi):		1500 D638, Type IV
Ultimate Elongation-min (percent):	300	D638, Type IV
Effect of Alkalies (CRD-C572) -		
Change in Weight (percent):		+0.25/-0.10 ------
Change in Durometer, Shore A:		+5 D2240
Finished Waterstop -		
Tensile Strength-min (psi):		1400 D638, Type IV
Ultimate Elongation-min (percent):	280	D638, Type IV

2.3 JOINT SEALANT

A. Material: Polyurethane polymer designed for bonding to concrete which is continuously submerged in water. Use no material with an unsatisfactory history of bond or durability when used in joints of liquid-retaining structures.

B. Sealant Properties at 73 degrees F, 50 percent relative humidity:

1. Work Life: 45 - 180 minutes

2. Time to Reach 20 Shore A Hardness (at 77 degrees F, 200 gr quantity): 24 hours, maximum

3. Ultimate Hardness (ASTM D2240): 20 - 45 Shore A

4. Tensile Strength (ASTM D412): 200 psi, minimum

5. Ultimate Elongation (ASTM D412): 400 percent, minimum

6. Tear Resistance (Die C ASTM D624): 75 pounds per inch of thickness, minimum

7. Color: Light Gray

C. Polyurethane Sealants for Waterstop Joints in Concrete:

1. Sealant: 2-part polyurethane; when cured, sealant shall meet or exceed ANSI/ASTM C920 or Federal Specification TT-S-0227 E(3) for 2-part material.

2. Vertical and overhead horizontal joints: Use only "non-sag" compounds meeting ANSI/ASTM C920, Class 25, Grade NS, or Federal Specification TT-S-0227 E(3), Type II, Class A.

3. Plane horizontal joints: Self-leveling compounds meeting ANSI/ASTM C920, Class 25, Grade P, or Federal Specification TT-S-0227 E(3), Type I. For joints subject to either pedestrian or vehicular traffic, use a compound providing non-tracking characteristics and having a Shore A hardness range of 35 to 45.

4. Primer: Use only compatible materials manufactured or recommended for the application by the sealant manufacturer, in accordance with the printed instructions and recommendations of the sealant manufacturer.

D. Acceptable Products: Polymeric Systems Inc. "PSI-270"; Pacific Polymers "Elastothane 227R"; Sika Corporation "Sikaflex 2C", or equal acceptable to the Engineer.

2.4 MISCELLANEOUS MATERIALS

A. Bearing Pad: ASTM D2000 neoprene, Grade 2 or 3, Type BC, tensile strength 1450 psi, 60 durometer hardness, unless otherwise indicated.

B. Neoprene Sponge: ASTM D1056, Type 2C3-E1 closed-cell expanded neoprene.

C. Preformed Joint Filler: ASTM D1752 Type I non-extruding type; neoprene sponge or polyurethane of firm texture, except as otherwise specified. Bituminous fiber type will not be permitted.

D. Control Joint Former: Continuous plastic insert strips with anchorage ribs located at the bottom

enlarged upper portion that is readily removable without damage to the concrete, and is o form sealant groove. Size to extend to at least 1/4 slab depth.

g Rod: Extruded closed-cell polyethylene foam rod, compatible with joint sealant als used, with a tensile strength not less than 40 psi, and compression deflection imately 25 percent at 8 psi. Size: 1/8-inch larger in diameter than joint width, except use :h diameter rod for 3/4-inch wide joints.

reaker: "Super Bond Breaker" manufactured by Burke Company, San Mateo, California; Cure CRB", manufactured by Select Products Co., Upland, California, or equal able to the Engineer. Bond breaker shall contain a fugitive dye so areas of application readily distinguishable.

wels: Smooth epoxy-coated bars conforming to ASTM A775.

ubing: ASTM D2241, Schedule SDR 13.5.

ATERSTOP

l: 75 percent bentonite, mixed with butyl rubber-hydrocarbon containing less than 1.0 volatile matter, and free of asbestos fibers or asphaltics.

cturer's rated temperature ranges: For application, 5 to 125 degrees F; in service, -40 to grees F.

ectional dimensions, unexpanded waterstop: One inch by 3/4 inch.

with adhesive backing capable of producing excellent adhesion to concrete surfaces.

N

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waterstops in concrete across joints as shown. Waterstops shall be continuous for the f the joint; make splices necessary to provide such continuity in accordance with cturer's instructions. Support and protect waterstops during construction operations; replace waterstops damaged during construction.

aterstops in concrete on one side of joints, leaving other side exposed until the next hen a waterstop will remain exposed for 2 days or more, shade and protect the l waterstop from direct rays of the sun during the entire exposure and until the exposed of the waterstop is embedded in concrete.

ATERSTOPS

aterstops by heat-sealing adjacent waterstop sections in accordance with the cturer's printed instructions.

o not damage material by heat sealing.

olice tensile strength: At least 60 percent of unspliced material tensile strength.

aintain continuity of waterstop ribs and tubular center axis.

-to-end joints of 2 identical waterstop sections may be made in the forms during nt of waterstop material.

SECTION 03310

STRUCTURAL CONCRETE

PART 1 – G E N E R A L

1.1 SECTION INCLUDES

A. Cast-in-place normal-weight structural concrete and mass concrete.

1.2 MEASUREMENT AND PAYMENT

A. Unit prices.

1. Refer to Section 01200 – Measurement and Payment, for unit price procedures.

B. Stipulated Price (Lump Sum). If the Contract is a Stipulated Price Contract, payment for work in this section is included in the total Stipulated Price.

1.3 REFERENCES

A. ACI 301 - Specifications for Structural Concrete for Buildings.

B. ACI 304.2R - Placing Concrete by Pumping Methods

C. ACI 305R - Hot Weather Concreting.

D. ACI 306.1 - Standard Specification for Cold Weather Concreting.

E. ACI 309R - Guide for Consolidation of Concrete.

F. ACI 318 - Building Code Requirements for Reinforced Concrete.

G. ACI 350R - Environmental Engineering Concrete Structures.

H. ASTM C31 - Standard Practice for Making and Curing Concrete Test Specimens in the Field.

I. ASTM C33 - Standard Specification for Concrete Aggregates.

J. ASTM C39 - Standard Test Method for Compressive Strength of Cylindrical Concrete Specimens.

K. ASTM C42 - Standard Method of Obtaining and Testing Drilled Cores and Sawed Beams of Concrete.

L. ASTM C88 - Standard Test Method for Soundness of Aggregates by Use of Sodium Sulfate or Magnesium Sulfate.

M. ASTM C94 - Standard Specifications for Ready-Mixed Concrete.

N. ASTM C127 - Standard Test Method for Specific Gravity and Absorption of Coarse Aggregate.

O. ASTM C131 - Standard Test Method for Resistance to Degradation of Small-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine.

P. ASTM C136 - Sieve Analyses of Fine and Coarse Aggregates.

Q. ASTM C143 - Standard Test Method for Slump of Hydraulic Cement Concrete.

R. ASTM C150 - Standard Specification for Portland Cement.

S. ASTM C157 - Test Method for Length Change of Hardened Hydraulic Cement Mortar and Concrete.

T. ASTM C172 - Standard Practice for Sampling Freshly Mixed Concrete.

U. ASTM C173 - Standard Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method.

V. ASTM C192 - Method of Making and Curing Concrete Test Specimens in the Laboratory.

W. ASTM C231 - Standard Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method.

X. ASTM C260 - Standard Specification for Air-Entraining Admixtures for Concrete.

Y. ASTM C330 - Standard Specification for Lightweight Aggregates for Structural Concrete.

Z. ASTM C494 - Standard Specification for Chemical Admixtures for Concrete.

AA. ASTM C535 - Standard Test Method for Resistance to Degradation of Large-Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine.

AB. ASTM C567 - Standard Test Method for Unit Weight of Structural Lightweight Concrete.

AC. ASTM C1064 - Standard Test Method for Temperature of Freshly Mixed Portland Cement Concrete.

AD. Concrete Plant Manufacturer's Bureau (CPMB), Plant Mixer Manufacturers Division: Concrete Plant Mixer Standards.

AE. National Ready-Mixed Concrete Association (NRMCA): Certification of Ready-Mixed Concrete Production Facilities (checklist with instructions).

AF. John Wiley and Sons, Interscience Publishers Division, "Encyclopedia of Industrial Chemical Analysis," Vol. 15, Page 230 (alkalinity test procedure).

1.4 DEFINITIONS

A. Mass Concrete: Concrete sections 4 feet or more in least dimension.

B. Hot Weather: Any combination of high air temperature, low relative humidity and wind velocity tending to impair quality of fresh or hardened concrete or otherwise resulting in abnormal properties.

C. Cold Weather: Period when, for more than 2 successive days, mean daily temperature is below 40 degrees F.

1.5 SUBMITTALS

A. Conform to Section 01300 - Submittals.

B. Mill Certificates: Required for bulk cement.

C. Design Mixes:

1. Submit test data on proposed design mixes for each type of concrete in the Work, including each class, and variations in type, source or quantity of material. Include type, brand and amount of cementitious materials; type, brand and amount of each admixture; slump; air content; aggregate sources, gradations, specific gravity and absorption; total water (including moisture in aggregate); water/cement ratio; compressive strength test results for 7 and 28 days; and shrinkage tests for Class C and D concrete at 21 or 28 days of drying.

2. Submit abrasion loss and soundness test results for limestone aggregate.

3. Testing of aggregates, including sieve analysis, shall be performed by a certified independent testing laboratory. Tests shall have been performed no earlier than 3 months before Notice to Proceed.

4. Provide standard deviation data for plant producing concrete. Data shall include copies of laboratory test results and standard deviation calculated in accordance with ACI 318, Item 5.3.1. Laboratory tests shall have been performed within past 12 months. When standard deviation data is not available, comply with ACI 318, Table 5.3.2.2.

5. Review and acceptance of mix design does not relieve Contractor of responsibility to provide concrete of quality and strength required by these Specifications.

D. Admixtures: Submit manufacturer's technical information, including following:

1. Air-Entraining Admixture: Give requirements to control air content under all conditions, including temperature variations and presence of other admixtures.

2. Chemical Admixtures: Give requirements for quantities and types to be used under various temperatures and job conditions to produce uniform, workable concrete mix. Submit evidence of compatibility with other admixtures and cementitious materials proposed for use in design mix.

E. High-Range Water Reducer (Superplasticizer): When proposed for use, submit manufacturer's technical information and instructions for use of superplasticizer. State whether superplasticizer will be added at ready-mix plant or job site. When superplasticizer will be added at job site, submit proposed plan for measuring and adding superplasticizer to concrete mix at job site, and establish dosing area on site with holding tanks and metering devices. When superplasticizer is to be added at ready-mix plant, submit contingency plans for adding additional superplasticizer at job site when required due to delay in placing concrete. Identify portions of Work on which superplasticizer is proposed for use.

F. Hot and Cold Weather Concreting: Submit, when applicable, proposed plans for hot and cold weather concreting. Review and acceptance of proposed procedure will not relieve Contractor of responsibility for quality of finished product.

G. Project Record Drawings: Accurately record actual locations of embedded utilities and components which are concealed from view.

1.6 QUALITY CONTROL

A. Provide necessary controls during evaluation of materials, mix designs, production and delivery of concrete, placement and compaction to assure that the Work will be accomplished in accordance with Contract Documents. Maintain records of concrete placement. Record dates, locations, quantities, air temperatures, and test samples taken.

B. Code Requirements: Concrete construction for buildings shall conform to ACI 318. Concrete construction for water and wastewater treatment and conveying structures shall conform to ACI 318 with modifications by ACI 350R, Item 2.6. Where this Specification conflicts with ACI 318 or ACI 350R, this Specification governs.

C. Testing and Other Quality Control Services:

1. Concrete testing required in this section, except concrete mix design, limestone aggregate test data, and testing of deficient concrete, will be performed by an independent commercial testing laboratory employed and paid by the Owner in accordance with Section 01410 - Testing Laboratory Services.

2. Provide material for and cooperate fully with Owner's testing laboratory technician in obtaining samples for required tests.

3. Standard Services: The following testing and quality control services will be provided by Owner in accordance with Section 01410, Testing Laboratory Services:

a. Verification that plant equipment and facilities conform to NRMCA "Certification of Ready-Mix Concrete Production Facilities".

b. Testing of proposed materials for compliance with this Specification.

c. Review of proposed mix design submitted by Contractor.

d. Obtaining production samples of materials at plants or stockpiles during work progress and testing for compliance with this Specification.

e. Strength testing of concrete according to following procedures:

(1) Obtaining samples for field test cylinders from every 100 cubic yards and any portion less than 100 cubic yards for each mix design placed each day, according to ASTM C172, with each sample obtained from a different batch of concrete on a representative, random basis. Selecting test batches by any means other than random numbers chosen before concrete placement begins is not allowed.

(2) Molding four specimens from each sample according to ASTM C31, and curing under standard moisture and temperature conditions as specified in Sections 7(a) and (b) of ASTM C31.

(3) Testing two specimens at 7 days and two specimens at 28 days according to ASTM C39, reporting test results averaging strengths of two specimens. However, when one specimen evidences improper sampling, molding or testing, it will be discarded and remaining cylinder considered test result. When high-early-strength concrete is used, specimens will be tested at 3 and 7 days.

f. Air content: For each strength test, determination of air content of normal weight concrete according to ASTM C231.

g. Slump: For each strength test, and whenever consistency of concrete appears to vary, conducting slump test in accordance with ASTM C143.

h. Temperature: For each strength test, checking concrete temperature in accordance with ASTM C1064.

i. Lightweight concrete: For each strength test, or more frequently when requested by Engineer, determination of air content by ASTM C567 and unit weight by ASTM C567.

j. Monitoring of current and forecasted climatic conditions to determine when rate of evaporation, as determined by Figure 2.1.5 of ACI 305R, will produce loss of 0.2 pounds of water, or more, per square foot per hour. Testing lab representative will advise Contractor to use hot weather precautions when such conditions will exist during concrete placement, and note on concrete test reports when Contractor has been advised that hot weather conditions will exist.

k. Class A and D Concrete Shrinkage Tests: Performance of drying shrinkage tests for trial batches as follows:

(1) Preparation and Testing of Specimens: Compression and drying shrinkage test specimens will be taken in each case from the same concrete sample; shrinkage tests will be considered a part of the normal compression tests for the project. 4-inch by 4-inch by 11-inch prisms with an effective gage length of 10 inches, fabricated, cured, dried and measured in accordance with ASTM C157, modified as follows:

(a) Wet curing: Remove specimens from molds at an age of 23 hours ☐1 hour after trial batching and immediately immerse in water at 70 degrees F ☐3 degrees F for at least 30 minute

(b) Measure within 30 minutes after first 30 minutes of immersion to determine original length (not to be confused with "base length");

(c) Then submerge in saturated limewater, at 73 degrees F ☐3 degrees for 7 days;

(d) Then measure at age 7 days to establish "base length" for drying shrinkage calculations ("zero" days drying age);

(e) Calculate expansion (base length expressed as a percentage of original length);

(f) Immediately store specimens in a temperature- and humidity-controlled room maintained at 73 degrees F, ±3 degrees F and 50 percent ±4 percent relative humidity, for the remainder of the test.

(g) Measure to determine shrinkage, expressed as percentage of base length. Compute the drying shrinkage deformation of each specimen as the difference between the base length (at zero (0) days drying age) and the length after drying at each test age. Compute the average drying shrinkage deformation of the specimens to the nearest 0.0001 inch at each test age. If the drying shrinkage of any specimen departs from the average of that test age by more than 0.0004 inch, disregard the results obtained from that specimen. Report results of shrinkage tests to the nearest 0.001 percent of shrinkage.

(h) Report shrinkage separately for 7, 14, 21, and 28 days of drying after 7 days of moist curing.

4. Additional Testing and Quality Control Services: The following will be performed by an independent commercial testing laboratory employed and paid by the Owner in

accordance with Section 01410, Testing Laboratory Services, when requested by Owner.

a. Checking of batching and mixing operations.

b. Review of manufacturer's report of each cement shipment and conducting laboratory tests of cement.

c. Molding and testing reserve 7-day cylinders or field cylinders.

d. Conducting additional field tests for slump, concrete temperature and ambient temperature.

e. Alkalinity Tests: For concrete used in sanitary structures, one test for each structure. Perform alkalinity tests on concrete covering reinforcing steel on the inside of the pipe or structure in accordance with "Encyclopedia of Industrial Chemical Analysis," Vol. 15, page 230.

5. Contractor shall provide the following testing and quality control services:

a. Employ an independent commercial testing laboratory, acceptable to Owner, to prepare and test design mix for each class of concrete for which material source has been changed.

b. Notify commercial testing laboratory employed by Owner 24 hours prior to placing concrete.

6. Testing of deficient concrete in place:

a. When averages of three consecutive strength test results fail to equal or exceed specified strength, or when any individual strength test result falls below specified strength by more than 500 psi, strength of concrete shall be considered potentially deficient and core testing, structural analysis or load testing may be required by Owner.

b. When concrete in place proves to be deficient, Contractor shall pay costs, including costs due to delays, incurred in providing additional testing and analysis services provided by the Owner, or the independent commercial testing laboratory selected by the Owner.

c. Replace concrete work judged inadequate by core tests, structural analysis or load tests at no additional cost to the Owner.

d. Core Tests:

(1) Obtain and test cores in accordance with ASTM C42. Where concrete in structure will be dry under service conditions, air dry cores (temperature 60 to 80 degrees F, relative humidity less than 60 percent) for 7 days before test; test dry. Where concrete in structure will be more than superficially wet under service conditions, test cores after moisture conditioning in accordance with ASTM C42.

(2) Take at least three representative cores from each member or area of concrete in place that is considered potentially deficient. Location of cores shall be determined by Owner so as to least impair strength of structure. When, before testing, one or more cores shows evidence of having been damaged during or after removal from structure, replace the damaged cores.

(3) Concrete in area represented by core test will be considered adequate when average strength of cores is equal to at least 85 percent of specified strength, and when no single core is less than 75 percent of specified strength.

(4) Patch core holes in accordance with Section 03345 - Concrete Finishing.

e. Structural Analysis: When core tests are inconclusive or impractical to obtain, Owner may perform additional structural analysis at Contractor's expense to confirm safety of structure.

f. Load Tests: When core tests and structural analysis do not confirm safety of structure, load tests may be required, and their results evaluated, in accordance with ACI 318.

g. Testing by impact hammer, sonoscope, probe penetration tests (Windsor probe), or other nondestructive device may be permitted by Owner to determine relative strengths at various locations in structure, to evaluate concrete strength in place, or for selecting areas to be cored. However, such tests, unless properly calibrated and correlated with other test data, shall not be used as basis for acceptance or rejection of structure's safety.

1.7 STORAGE AND HANDLING OF MATERIALS

A. Cement: Store cement in weathertight buildings, bins or silos to provide protection from dampness and contamination and to minimize warehouse set. When there is any doubt as to expansive potential of shrinkage-compensating cements because of method or length of storage and exposure, laboratory test cement before use.

B. Aggregate: Arrange and use aggregate stockpiles to avoid excessive segregation or contamination with other materials or with other sizes of like aggregates. Build stockpiles in successive horizontal layers not exceeding 3 feet in thickness. Complete each layer before next is started.

C. Fine Aggregate: Before using, allow fine aggregate to drain until uniform moisture content is reached.

D. Admixtures: Store admixtures to avoid contamination, evaporation or damage. For those used in form of suspensions or nonstable solutions, provide suitable agitating equipment to assure uniform distribution of ingredients. Protect liquid admixtures from freezing and other temperature changes which would adversely affect their characteristics.

E. Lightweight Aggregates: Uniformly predampen lightweight aggregates as necessary to prevent excessive variations in moisture content. Allow predampened aggregates to remain in stockpiles, under continuous fog spray, for minimum of 24 hours before use. Provide adequate drainage in stockpile areas to eliminate excess water and accumulation of contaminated fines.

PART 2 –PRODUCTS

2.1 MATERIALS

A. Cement:

1. Use same brand of cement used in concrete mix design. Use only one brand of each type in each structure, unless otherwise indicated on Drawings.

2. Portland Cement: ASTM C150, Type I or Type II, gray in color. Use Type III only when specifically authorized by Owner in writing. Use Type II, including the requirements of

Table 2, in construction of liquid-containing structures and cooling towers, unless shown otherwise on Drawings.

B. Admixtures:

1. Do not use calcium chloride, thiocyanate or admixtures containing more than 0.05 percent chloride ions.

2. Air-Entraining Admixtures: ASTM C260, compatible with other admixtures used.

3. Chemical Admixtures: Polymer type, nonstaining, chloride-free admixtures conforming to ASTM C494, Type A, C, D or E.

4. High-Range Water Reducer (Superplasticizer): ASTM C494, Type F or G, compatible with and by the same manufacturer as other admixtures.

C. Mixing Water: Use clean, potable water, free from harmful amounts of oils, acids, alkalis or other deleterious substances, meeting requirements of ASTM C94.

D. Aggregates: Use coarse aggregate from only one source, and fine aggregate from only one source, for exposed concrete in any single structure.

1. Coarse Aggregate: Gravel, crushed gravel or crushed limestone conforming to ASTM C33. For wastewater treatment and conveying structures, provide only crushed limestone.

2. Fine Aggregate: Natural sand complying with ASTM C33, except provide only crushed limestone for wastewater treatment and conveying structures.

3. Limestone aggregate shall conform to ASTM C33 and the following additional requirements: Clean, hard, strong and durable particles free of chemicals and coatings of silt, clay, or other fine materials that may affect hydration and bond of cement paste. Select crushed limestone: High-calcium limestone (minimum 95 percent $CaCO_3$ and maximum 3.5 percent $MgCO_3$) with maximum Los Angeles Abrasion loss of 38 percent, when tested in accordance with ASTM C131 or ASTM C535. Test aggregate for soundness in accordance with ASTM C88; maximum loss shall not exceed 18 percent after 5 cycles of magnesium sulfate test.

4. Maximum size of coarse aggregate:

   a. Normal weight concrete, except as noted below: 1-1/2 inches.

   b. Formed members 6 inches or less in least dimension: 1/5 least dimension.

   c. Slabs: 1/3 depth of slab.

   d. Drilled shafts: 1/3 clearance between reinforcing steel, but not greater than 3/4 inch.

   e. Concrete fill, seal slabs and bonded concrete topping in clarifiers: 3/8 inch.

5. Coarse aggregate for lightweight concrete: ASTM C330. Grading limits: 3/4 inch to No. 4.

6. Abrasive Aggregate: Conform to requirements of Section 03345 - Concrete Finishing.

E. Calcium Chloride: Not permitted.

F. Evaporation Retardant: Masterbuilders "Confilm", Euclid "Eucobar", or equal.

G. Miscellaneous Materials:

1. Bonding Agent: Two-component modified epoxy resin.
2. Vapor barrier: 6 mil clear polyethylene film of type recommended for below-grade aplication.
3. Non-shrink grout: premixed compound consisting of non-metallic aggregate, cement and water-reducing and plasticizing agents; capable of developing minimum compressive strength of 2,400 psi in 48 hours and 7,000 psi in 28 days.

2.2 CONCRETE MIX

A. Objective: Select proportions of ingredients to produce concrete having proper placability, durability, strength, appearance and other specified properties.

B. Mix Design: Employ and pay an independent commercial testing laboratory, acceptable to Owner, to prepare and test mix designs for each type of concrete specified. Proportion mix design ingredients by weight. Submit mix designs and test results for approval.

1. During the trial batches, aggregate proportions may be adjusted by the testing laboratory using two coarse aggregate size ranges to obtain the required properties. If one size range produces an acceptable mix, a second size range need not be used. Such adjustments shall be considered refinements to the mix design and shall not be the basis for extra compensation to the Contractor. Concrete shall conform to the requirements of this Section, whether the aggregate proportions are from the Contractor's preliminary mix design, or whether the proportions have been adjusted during the trial batch process. Prepare trial batches using the aggregates, cement and admixtures proposed for the project. Make trial batches large enough to obtain 3 drying shrinkage test specimens and 6 compression test specimens from each batch. Shrinkage testing is required only for Class C and D concrete.

2. Determine compressive strength by testing 6-inch diameter by 12-inch high cylinders, made, cured and tested in accordance with ASTM C192 and ASTM C39. Test 3 compression test cylinders at 7 days and 3 at 28 days. Average compressive strength for the 3 cylinders tested at 28 days for any given trial batch shall be not less than 125 percent of the specified compressive strength.

3. Perform sieve analysis of the combined aggregate for each trial batch according to of ASTM C136. Report percentage passing each sieve.

4. In mix designs for Class C and D concrete, fine aggregate shall not exceed 41 percent of total aggregate by weight.

C. Shrinkage Limitations, Class A and D Concrete

1. Maximum concrete shrinkage for specimens cast in the laboratory from the trial batch: 0.036 percent as measured at 21-day drying age, or 0.042 percent at 28-day drying age. Use for construction only mix designs that meet trial batch shrinkage requirements. Shrinkage limitations apply only to Class A and D concrete.

2. Maximum concrete shrinkage for specimens cast in the field shall not exceed the trial batch maximum shrinkage requirement by more than 25 percent.

3. If the required shrinkage limitation is not met during construction, take any or all of the following actions, at no additional cost to the Owner, for securing the specified shrinkage requirements: Changing the source or aggregates, cement or admixtures; reducing water content; washing of aggregate to reduce fines; increasing the number of construction

joints; modifying the curing requirements; or other actions designed to minimize shrinkage or its effects.

D. Selecting Ingredient Proportions for Concrete:

1. Proportion concrete mix according to ACI 301, Chapter 3.

2. Establish concrete mix design by laboratory trial batches prepared by independent testing laboratory, or on basis of previous field experience in accordance with provisions of ACI 318, Item 5.3; however, minimum cement content for each class of concrete shall not be less than specified.

3. Concrete mix design data submitted for review shall have average 28-day compressive strength calculated in accordance with ACI 318, Item 5.3.2.1. When data is not available to determine standard deviation in accordance with ACI 318, Item 5.3.1, average 28-day strength of mix design shall conform to ACI 318, Table 5.3.2.2.

E. Water-Cement Ratios:

1. Maximum allowable water-cement ratios shall be as follows:

a. Concrete for liquid-containing structures: 0.45.

b. Concrete subjected to brackish water, salt spray or deicers: 0.40.

c. All other concrete: 0.55.

2. Superplasticizer may be added to maintain specified maximum water-cement ratios. Include free water in aggregate in water-cement ratio computations.

F. Adjustment of Mix Proportions: After sufficient data becomes available during construction, mix may be adjusted upon approval of Engineer, in accordance with ACI 318, Item 5.5; however, minimum cement content for each class of concrete shall not be less than specified.

G. Entrained Air: Air-entrain all concrete except drilled shafts. Total air content in accordance with ASTM C173: 4 to 6 percent.

H. Consistency, Workability, and Slump:

1. The quantity of water in a batch of concrete shall be just sufficient, with a normal mixing period, to produce concrete which can be worked properly into place without segregation, and which can be compacted by vibratory methods as specified, to give the desired strength, density, impermeability and smoothness of surface. Change the quantity of water as necessary, with variations in the nature or moisture content of the aggregates, to maintain uniform production of a desired consistency. Determine the consistency of the concrete in successive batches by slump tests in accordance with ASTM C 143. Slumps shall be as follows:

Concrete Type	Minimum Slump	Maximum Slump
Portland Cement Concrete:	2"	4"
Concrete to be dosed with superplasticizer:	1"	3"
Normal Weight Concrete after dosing with superplasticizer:	4"	9"
Lightweight Concrete after dosing with superplasticizer:	4"	7"
Drilled Shaft Concrete:	4"*	8"

* Minimum slump where drilled shafts are cast in temporary casings: 5 inches.

2. Specified slump shall apply at time when concrete is discharged at job site. Perform slump tests to monitor uniformity and consistency of concrete delivered to job site; however, do not use as basis for mix design. Do not exceed water-cement ratios specified.

I. Admixtures: Proportion admixtures according to manufacturer's recommendations. Use of accelerator is permitted when air temperature is less than 40 degrees F. Use of retarder is permitted when temperature of placed concrete exceeds 65 degrees F.

J. High-Range Water Reducers (Superplasticizers): Use superplasticizer to improve workability of concrete or delay hydration of cement, in accordance with requirements and recommendations of product manufacturer and approved submittals.

K. Concrete Classification and Strength:

1. Strength: Conform to values for class of concrete indicated on Drawings for each portion of Work. Requirements are based on 28-day compressive strength. If high early-strength concrete is allowed, requirements are based on 7-day compressive strength.

2. Classification:

Class (Normal-weight)	Minimum 28-Day Compressive Strength (psi)	Minimum Cement Content Pounds per Cubic Yard
Concrete for Structures Containing Water or Wastewater		
A	4000	564 (6 Sacks)
B	1500	423 (3-1/2 Sacks)
C	3000	470 (5 Sacks)
D	5000	658 (7 Sacks)
H	3000	610 (6-1/2 Sacks)

Concrete for Buildings, Slabs on Grade and Miscellaneous Structures

Class (Light-weight)	Minimum 28-Day Compressive Strength (psi)	Minimum Cement Content Pounds per Cubic Yard
AB	4000	Not Applicable
BB	1500	Not Applicable
CB	3000	Not Applicable
DB	5000	Not Applicable
E	3000	Not Applicable
F	4000	Not Applicable
G	5000	Not Applicable

3. Maximum size aggregate for Class H concrete: 3/8 inch. Maximum size aggregate for all other normal-weight concrete: 1-1/2 inches, except as specified in Paragraph 2.1D.4.

4. When required strength is not obtained with minimum cement content as specified, add cement, lower water-cement ratio or provide other aggregates as necessary.

5. In addition to conforming to specified strength, lightweight concrete must be within specified unit weight limits. Maximum air-dry unit weight is 118 pounds per cubic foot; minimum is 110 pounds per cubic foot unless shown otherwise on Drawings. Determine air-dry unit weight in accordance with ASTM C567. Correlate air-dry unit weight with fresh unit weight of the same concrete as a basis for acceptance during construction.

L. Use of Classes of Concrete:

1. Use classes of concrete as indicated on the Drawings and in other specifications.

2. Liquid-containing structures: If not otherwise indicated, use the following classes for structures containing water or wastewater and for utility applications in the locations described:

a. Class A: All reinforced concrete and where not otherwise defined.

b. Class B: Unreinforced concrete used for plugging pipes, seal slabs, thrust blocks and trench dams, unless indicated otherwise.

c. Class H: Fill and topping. Where concrete fill thickness exceeds 3 inches in the majority of a placement and is not less than 1.5 inches thick, Class A concrete may be used.

3. All other structures: If not otherwise indicated, use the following classes in the locations described:

a. Class AB: All reinforced concrete and where not otherwise defined.

b. Class CB: Duct banks;

c. Class BB: Unreinforced concrete fill under structures.

2.3 MIXING NORMAL WEIGHT CONCRETE

A. Conform to ACI 301, Chapter 7.
B. Ready-Mixed Concrete:

1. Measure, batch, mix and transport ready-mixed concrete according to ASTM C94. Plant equipment and facilities shall conform to NRMCA "Certification of Ready Mixed Concrete Production Facilities".

2. Provide batch tickets with information specified in ASTM C94. Deliver batch ticket with concrete and give to Owner's on-site testing laboratory representative.

C. Batch Mixing at Site:

1. Mix concrete in batch mixer conforming to requirements of CPMB "Concrete Plant Mixer Standards". Use mixer equipped with suitable charging hopper, water storage tank and water measuring device. Batch mixer shall be capable of mixing aggregates, cement and water into uniform mass within specified mixing time, and of discharging mix without segregation. Operate mixer according to rated capacity and recommended revolutions per minute printed on manufacturer's rating plate.

2. Charge batch into mixer so some water will enter before cement and aggregates. Keep water running until one-fourth of specified mixing time has elapsed. Provide controls to prevent discharging until required mixing time has elapsed. When concrete of normal weight is specified, provide controls to prevent addition of water during mixing. Discharge entire batch before mixer is recharged.

3. Mix each batch of 2 cubic yards or less for not less than 1 minute and 30 seconds. Increase minimum mixing time 15 seconds for each additional cubic yard or fraction of cubic yard.

4. Keep mixer clean. Replace pick-up and throw-over blades in drum when they have lost 10 percent of original depth.

D. Admixtures:

1. Charge air-entraining and chemical admixtures into mixer as solution using automatic dispenser or similar metering device. Measure admixture to accuracy within $\pm$ 3 percent. Do not use admixtures in powdered form.

2. Two or more admixtures may be used in same concrete, provided that admixtures in combination retain full efficiency and have no deleterious effect on concrete or on properties of each other. Inject admixtures separately during batching sequence.

3. Add retarding admixtures as soon as practicable after addition of cement.

E. Temperature Control:

1. When ambient temperature falls below 40 degrees F, keep as-mixed temperature above 55 degrees F to maintain concrete above minimum placing temperature.

2. When water or aggregate has been heated, combine water with aggregate in mixer before cement is added. Do not add cement to mixtures of water and aggregate when temperature of mixture is greater than 100 degrees F.

3. In hot weather, maintain temperature of concrete below maximum placing temperature. When necessary, temperature may be lowered by cooling ingredients, cooling mixer drum by fog spray, using chilled water or well-crushed ice in whole or part for added water, or arranging delivery sequence so that time of transport and placement does not generate unacceptable temperatures.

4. Submit hot weather and cold weather concreting plans for approval.

2.4 MIXING LIGHTWEIGHT CONCRETE

A. Determining Absorption of Aggregates: Mixing procedures vary according to total absorption by weight of lightweight aggregates. Determine total absorption by weight before predamping in accordance with ASTM C127.

B. Ten Percent or Less Absorption: Follow same requirements as for mixing normal-weight concrete when preparing concrete made with low-absorptive lightweight aggregates having 10 percent or less total absorption by weight. To be low-absorptive, aggregates must absorb less than 2 percent additional water in first hour after mixing.

C. More Than 10 Percent Absorption: Batch and mix concrete made with lightweight aggregates having more than 10 percent total absorption by weight, as follows:

1. Place approximately 80 percent of mixing water in mixer.

2. If aggregates are pre-dampened, add air-entraining admixture and all aggregates. Mix for minimum of 30 seconds, or 5 to 10 revolutions of truck mixer.

3. When aggregates have not been predampened, mix aggregates and water for minimum of 1 minute and 30 seconds, or 15 to 30 revolutions of truck mixer. Then add air-entraining admixture and mix for additional 30 seconds.

4. Then, in the following sequence, add specified or permitted admixtures (other than air-entraining agent), all cement, and mixing water previously withheld.

5. Complete mixing using procedures for normal-weight concrete.

2.5 MASS CONCRETE

A. Do not use high early-strength cement (Type III) or accelerating admixtures.

B. Use high-range water-reducing admixture (superplasticizer) to minimize water content and cement content.

C. Specified water-reducing retarding admixture may be required to prevent cold joints when placing large quantities of concrete, to permit revibration of concrete, to offset effects of high temperature in concrete or weather, and to reduce maximum temperature or rapid temperature rise.

2.6 EQUIPMENT

A. Select equipment of size and design to ensure continuous flow of concrete at delivery end. Conform to following equipment and operations requirements.

B. Truck mixers, agitators and manner of operation: Conform to ASTM C94. Use of non-agitating equipment for transporting concrete is not permitted.

C. Belt conveyors: Configure horizontally, or at a slope causing no segregation or loss. Use approved arrangement at discharge end to prevent separation. Discharge long runs without separation into hopper.

D. Chutes: Metal or metal-lined (other than aluminum). Arrange for vertical-to-horizontal slopes not more than 1 to 2 nor less than 1 to 3. Chutes longer than 20 feet or not meeting slope requirements may be used if concrete is discharged into hopper before distribution.

E. Do not use aluminum or aluminum-alloy pipe or chutes for conveying concrete.

PART 3 –EXECUTION

3.1 SPECIAL CONSIDERATIONS

A. Concreting Under Water: Not permitted except where shown otherwise on Drawings or approved by Owner. When shown or permitted, deposit concrete under water by methods acceptable to the Owner so fresh concrete enters mass of previously-placed concrete from within, causing water to be displaced with minimum disturbance at surface of concrete.

B. Protection from Adverse Weather: Unless adequate protection is provided or Owner's approval is obtained, do not place concrete during rain, sleet, snow or freezing weather. Do not permit rainwater to increase mixing water or to damage surface finish. If rainfall occurs after placing operations begin, provide adequate covering to protect Work.

3.2 PREPARATION OF SURFACES FOR CONCRETING

A. Earth Surfaces:

1. Under interior slabs on grade, install vapor barrier. Lap joints at least 6 inches and seal watertight with tape, or sealant applied between overlapping edges and ends. repair vapor barrier damaged during placement of reinforcing and inserts with vapor barrier material; lap over damaged areas at least 6 inches and seal watertight.

2. Other Earth Surfaces: Thoroughly wet by sprinkling prior to placing concrete, and keep moist by frequent sprinkling up to time of placing concrete thereon. Remove standing water. Surfaces shall be free from standing water, mud and debris at the time of placing concrete.

B. Construction Joints:

1. Definition: Concrete surfaces upon or against which concrete is to be placed, where the placement of the concrete has been interrupted so that, in the judgement of the Owner, new concrete cannot be incorporated integrally with that previously placed.

2. Interruptions: When placing of concrete is to be interrupted long enough for the concrete to take a set, use forms or other means to shape the working face to secure proper union with subsequent work. Make construction joints only where acceptable to the Owner.

3. Preparation: Give horizontal joint surfaces a compacted, roughened surface for good bond. Except where the Drawings call for joint surfaces to be coated, clean joint surfaces of laitance, loose or defective concrete and foreign material by hydroblasting or sandblasting (exposing aggregate), roughen surface to expose aggregate to a depth of at least 1/4 inch and wash thoroughly. Remove standing water from the construction joint surface before new concrete is placed.

4. After surfaces have been prepared cover approximately horizontal construction joints with a 3-inch lift of a grout mix consisting of Class C concrete batched without coarse aggregate; place and spread grout uniformly. Place wall concrete on the grout mix immediately thereafter.

C. Set and secure reinforcement, anchor bolts, sleeves, inserts and similar embedded items in the forms where indicated on Contract Drawings, shop drawings and as otherwise required. Obtain Owner's acceptance before concrete is placed. Accuracy of placement is the sole responsibility of the Contractor.

D. Place no concrete until at least 4 hours after formwork, inserts, embedded items, reinforcement and surface preparation have been completed and accepted by the Owner. Clean surfaces of forms and embedded items that have become encrusted with grout or previously-placed concrete before placing adjacent concrete.

E. Casting New Concrete Against Old: Where concrete is to be cast against old concrete (any concrete which is greater than 60 days of age), thoroughly clean and roughen the surface of the old concrete by hydro-blasting or sandblasting (exposing aggregate). Coat joint surface with epoxy bonding agent following manufacturer's written instructions, unless indicated otherwise. Unless noted otherwise, this provision does not apply to vertical wall joints where waterstop is installed.

F. Protection from Water: Place no concrete in any structure until water entering the space to be filled with concrete has been properly cut off or diverted and carried out of the forms, clear of the work. Deposit no concrete underwater. Do not allow still water to rise on any concrete until concrete has attained its initial set. Do not allow water to flow over the surface of any concrete in a manner and at a velocity that will damage the surface finish of the concrete. Pumping, dewatering and other necessary operations for removing ground water, if required, are subject to Owner's review.

G. Corrosion Protection: Position and support pipe, conduit, dowels and other ferrous items to be embedded in concrete construction prior to placement of concrete so there is at least a 2 inch clearance between them and any part of the concrete reinforcement. Do not secure such items in position by wiring or welding them to the reinforcement.

H. Where practicable, provide for openings for pipes, inserts for pipe hangers and brackets, and setting of anchors during placing of concrete.

I. Accurately set anchor bolts and maintain in position with templates while they are being embedded in concrete.

J. Cleaning: Immediately before concrete is placed, thoroughly clean dirt, grease, grout, mortar, loose scale, rust and other foreign substances from surfaces of metalwork to be in contact with concrete.

3.3 HANDLING, TRANSPORTING AND PLACING CONCRETE

A. Conform to applicable requirements of Chapter 8 of ACI 301 and this Section. Use no aluminum materials in conveying concrete.

B. Rejected Work: Remove concrete found to be defective or non-conforming in materials or workmanship. Replace rejected concrete with concrete meeting requirements of Contract Documents, at no additional cost to the Owner.

C. Unauthorized Placement: Place no concrete except in the presence of the Owner. Notify the Owner in writing at least 24 hours before placement of concrete.

D. Placement in Wall Forms:

1. Do not drop concrete through reinforcing steel or into any deep form.

2. Do not place concrete in any form so as to leave an accumulation of mortar on form surfaces above the concrete.

3. Use hoppers and, if necessary, vertical ducts of canvas, rubber or metal (other than aluminum) for placing concrete in forms so it reaches the place of final deposit without

separation. Free fall of concrete shall not exceed 4 feet below the ends of ducts, chutes or buggies. Uniformly distribute concrete during depositing.

4. Do not displace concrete in forms more than 6 feet in horizontal direction from place where it was originally deposited.

5. Deposit in uniform horizontal layers not deeper than 2 feet; take care to avoid inclined layers or inclined construction joints except where required for sloping members.

6. Place each layer while the previous layer is still soft. Rate of placement shall not exceed 5 feet of vertical rise per hour.

7. Provide sufficient illumination in form interior so concrete at places of deposit is visible from the deck or runway.

E. Conveyors and Chutes: Design and arrange ends of chutes, hopper gates and other points of concrete discharge in the conveying, hoisting and placing system so concrete passing from them will not fall separated into whatever receptacle immediately receives it. Conveyors, if used, shall be of a type acceptable to the Owner. Do not use chutes longer than 50 feet. Slope chutes so concrete of specified consistency will readily flow. If a conveyor is used, it shall be wiped clean by a device operated in such a manner that none of the mortar adhering to the belt will be wasted. All conveyors and chutes shall be covered.

F. Placement of Slabs: In hot or windy weather, conducive to plastic shrinkage cracks, apply evaporation retardant to slab after screeding in accordance with manufacturer's instructions and recommendations. Do not use evaporation retardant to increase water content of the surface cement paste. Place concrete for sloping slabs uniformly from the bottom of the slab to the top, for the full width of the placement. As work progresses, vibrate and carefully work concrete around slab reinforcement. Screed the slab surface in an up-slope direction.

G. Concrete Temperature: When placed, not more than 90 degrees F nor less than 55 degrees F for sections less than 12 inches thick, nor less than 50 degrees for all other sections. Do not heat concrete ingredients to a temperature higher than that necessary to keep the temperature of the mixed concrete, as placed, from falling below the specified minimum temperature. When concrete temperature is 85 degrees F or above, do not exceed 60 minutes between introduction of cement to the aggregates and discharge. When the weather is such that the concrete temperature would exceed 90 degrees F, employ effective means, such as pre-cooling of aggregates and mixing water, using ice or placing at night, as necessary to maintain concrete temperature, as placed, below 90 degrees F.

H. Cold Weather Placement: Conform to ACI 306.1 - Standard Specification for Cold Weather Concreting, and the following.

1. Remove snow, ice and frost from surfaces, including reinforcement, against which concrete is to be placed. Before beginning concrete placement, thaw the subgrade to a minimum depth of 6 inches. Warm reinforcement and embedded items to above 32 degrees F prior to concrete placement.

2. Maintain concrete temperature above 50 degrees F for at least 3 days after placement.

3.4 PUMPING OF CONCRETE

A. If pumped concrete does not produce satisfactory results, in the judgement of the Owner, discontinue pumping operations and proceed with the placing of concrete using conventional methods.

B. Pumping Equipment: Use a 2-cylinder pump designed to operate with only one cylinder if one is

not functioning, or have a standby pump on site during pumping.

C. The minimum hose (conduit) diameter: Comply with ACI 304.2R.

D. Replace pumping equipment and hoses (conduits) that do not function properly.

E. Do not use aluminum conduits for conveying concrete.

F. Field Control: Take samples for slump, air content and test cylinders at the placement (discharge) end of the line.

3.5 CONCRETE PLACEMENT SEQUENCE

A. Place concrete in a sequence acceptable to the Owner. To minimize effects of shrinkage, place concrete in units bounded by construction joints shown. Place alternate units so each unit placed has cured at least 7 days for hydraulic structures, or 3 days for other structures, before contiguous unit or units are placed, except do not place corner sections of vertical walls until the 2 adjacent wall panels have cured at least 14 days for hydraulic structures and 7 days for other structures.

B. Level the concrete surface whenever a run of concrete is stopped. To ensure straight and level joints on the exposed surface of walls, tack a wood strip at least 3/4-inch thick to the forms on these surfaces. Carry concrete about 1/2 inch above the underside of the strip. About one hour after concrete is placed, remove the strip, level irregularities in the edge formed by the strip with a trowel and remove laitance.

3.6 TAMPING AND VIBRATING

A. Thoroughly settle and compact concrete throughout the entire depth of the layer being consolidated, into a dense, homogeneous mass; fill corners and angles, thoroughly embed reinforcement, eliminate rock pockets and bring only a slight excess of water to the exposed surface of concrete during placement. Use ACI 309R Group 3 immersion-type high-speed power vibrators (8,000 to 12,000 rpm) in sufficient number and with sufficient (at least one) standby units. Use Group 2 vibrators only when accepted by the Owner for specific locations.

B. Use care in placing concrete around waterstops. Carefully work concrete by rodding and vibrating to make sure air and rock pockets have been eliminated. Where flat-strip type waterstops are placed horizontally, work concrete under waterstops by hand, making sure air and rock pockets have been eliminated. Give concrete surrounding the waterstops additional vibration beyond that used for adjacent concrete placement to assure complete embedment of waterstops in concrete.

C. Concrete in Walls: Internally vibrate, ram, stir, or work with suitable appliances, tamping bars, shovels or forked tools until concrete completely fills forms or excavations and closes snugly against all surfaces. Do not place subsequent layers of concrete until previously-placed layers have been so worked. Provide vibrators in sufficient numbers, with standby units as required, to accomplish the results specified within 15 minutes after concrete of specified consistency is placed in the forms. Keep vibrating heads from contact with form surfaces. Take care not to vibrate concrete excessively or to work it in any manner that causes segregation of its constituents.

3.7 PLACING MASS CONCRETE

A. Observe the following additional restrictions when placing mass concrete.

1. Use specified superplasticizer.

2. Maximum temperature of concrete when deposited: 70 degrees F.

3. Place in lifts approximately 18 inches thick. Extend vibrator heads into previously-placed layer.

3.8 REPAIRING SURFACE DEFECTS AND FINISHING

A. Conform to Section 03345 - Concrete Finishing.

3.9 CURING

A. Conform to Section 03370 - Concrete Curing.

3.10 PROTECTION

A. Protect concrete against damage until final acceptance by the Owner.

B. Protect fresh concrete from damage due to rain, hail, sleet or snow. Provide such protection while the concrete is still plastic and whenever such precipitation is imminent or occurring.

C. Do not backfill around concrete structures or subject them to design loadings until all components of the structure needed to resist the loading are complete and have reached the specified 28-day compressive strength, except as authorized otherwise by the Owner.

END OF SECTION

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SECTION 03345

CONCRETE FINISHING

PART 1 – G E N E R A L

1.1 SECTION INCLUDES

A. Repairing surface defects.

B. Finishing concrete surfaces including both formed and unformed surfaces.

C. Sealing concrete surfaces.

D. Installation of concrete fill and installation of concrete topping in bottoms of clarifiers and thickeners.

1.2 MEASUREMENT AND PAYMENT

A. Unit prices.

1. Refer to Section 01200 – Measurement and Payment, for unit price procedures.

B. Stipulated Price (Lump Sum). If the Contract is a Stipulated Price Contract, payment for work in this section is included in the total Stipulated Price.

1.3 REFERENCES

A. ASTM C144 - Standard Specification for Aggregate for Masonry Mortar.

B. ASTM C881 - Specification for Epoxy-Resin-Base Bonding Systems for Concrete.

C. ASTM C1059 - Standard Specification for Latex Agents for Bonding Fresh to Hardened Concrete.

D. ASTM D4587 - Conducting Tests on Paint and Related Coatings and Materials Using a Fluorescent UV-Condensation Light-and Water-Exposure Apparatus.

E. ASTM E1155 - Standard Test Method for Determining Floor Flatness and Levelness Using the F-Number System.

1.4 SUBMITTALS

A. Conform to Section 01300 - Submittals.

B. Submit manufacturer's technical literature on the following products proposed for use. Include manufacturer's installation and application instructions and, where specified, manufacturer's certification of conformance to requirements and suitability for use in the applications indicated.

1. Floor hardener.
2. Sealer.
3. Epoxy floor topping.
4. Epoxy penetrating sealer.
5. Latex bonding agent.

6. Epoxy adhesive.
7. Abrasive aggregate.
8. Evaporation retardant.

PART 2 –PRODUCTS

2.1 MATERIALS

A. Sealer/Dustproofer (VOC Compliant): Water-based acrylic sealer; non-yellowing under ultraviolet light after 200-hour test in accordance with ASTM D4587. Conform to local, state and federal solvent emission requirements.

B. Epoxy Floor Topping: Two-component epoxy resin meeting ASTM C881 Type III, resistant to wear, staining and chemical attack, blended with granite, sand, trap rock or quartz aggregate, trowel-applied over concrete floor. Topping thickness, 1/8 inch; color, gray.

C. Abrasive Aggregate for Non-slip Finish: Fused aluminum oxide grit, or crushed emery aggregate containing not less than 40 percent aluminum oxide and not less than 25 percent ferric oxide. Material shall be factory graded, packaged, rustproof and non-glazing, and unaffected by freezing, moisture and cleaning materials.

D. Epoxy Penetrating Sealer: Low-viscosity, two-component epoxy system designed to give maximum penetration into concrete surfaces. Sealer shall completely seal concrete surfaces from penetration of water, oil and chemicals; prevent dusting and deterioration of concrete surfaces caused by heavy traffic; and be capable of adhering to floor surfaces subject to hydrostatic pressure from below. Color, transparent amber or gray; surface, non-slip.

E. Latex Bonding Agent: Non-redispersable latex base liquid conforming to ASTM C1059. When used in water and wastewater treatment structures, bonding agent shall be suitable for use under continuously submerged conditions. Conformance and suitability certification by manufacturer is required.

F. Bonding Grout: Prepare bonding grout by mixing approximately one part cement to one part fine sand meeting ASTM C144 but with 100 percent passing No. 30 mesh sieve. Mix with water to consistency of thick cream. At Contractor's option, a commercially prepared bonding agent used in accordance with manufacturer's recommendations and instructions may be used. When used in water and wastewater treatment structures, bonding agent shall be suitable for use under continuously submerged conditions. Conformance and suitability certification by manufacturer is required. Submit manufacturer's technical information on proposed bonding agent.

G. Patching Mortar:

1. Make patching mortar of same materials and of approximately same proportions as concrete, except omit coarse aggregate. Substitute white Portland cement for part of gray Portland cement on exposed concrete in order to match color of surrounding concrete. Determine color by making trial patch. Use minimum amount of mixing water required for handling and placing. Mix patching mortar in advance and allow to stand. Mix frequently with trowel until it has reached stiffest consistency that will permit placing. Do not add water.

2. Proprietary compounds for adhesion or specially formulated cementitious repair mortars may be used in lieu of or in addition to foregoing patching materials provided that properties of bond and compressive strength meet or exceed the foregoing and color of surrounding concrete can be matched where required. Use such compounds according to manufacturer's recommendations. When used in water and wastewater treatment structures, material shall be suitable for use under continuously submerged conditions.

Conformance and suitability certification by manufacturer is required.

H. Epoxy Adhesive: Two-component, 100 percent solids, 100 percent reactive compound developing 100 percent of strength of concrete, suitable for use on dry or damp surfaces. Epoxy used to inject cracks and as a binder in epoxy mortar shall meet ASTM C881, Type VI. Epoxy used as a bonding agent for fresh concrete shall meet ASTM C881, Type V.

I. Non-shrink Grout: See Section 03600 - Structural Grout.

J. Spray-Applied Coating: Acceptable products are Thoro System Products "Thoroseal Plaster Mix" or equal. Color: Gray.

K. Concrete Topping: Class H concrete with 3/8-inch maximum coarse aggregate size, as specified in Section 03310 - Structural Concrete.

L. Concrete Fill: Class H concrete with 3/8-inch maximum coarse aggregate size, (Class C where fill thickness exceeds 3 inches throughout a placement), as specified in Section 03310 - Structural Concrete.

M. Evaporation Retardant: Confilm, manufactured by Master Builders; Eucobar, manufactured by Euclid Chemical Company; or equal.

PART 3 –EXECUTION

3.1 AGGREGATE CONCEALMENT

A. Unless indicated otherwise on Drawings or approved by Owner, all surfaces to be finished shall be free of exposed aggregate.

3.2 REPAIRING SURFACE DEFECTS

A. Defective Areas: Repair immediately after removal of forms. Remove honeycombed and other defective concrete down to sound concrete but in no case to a depth less than 1 inch. Make edges of cuts perpendicular to concrete surface. Thoroughly work bonding grout into the surface with a brush as that the entire surface is covered. Alternatively, a proprietary bonding agent may be used. Use bonding agent in accordance with manufacturer's instructions. While bonding coat is still tacky, apply premixed patching mortar. Thoroughly consolidate mortar into place and strike off to leave patch slightly higher than surrounding surface. To permit initial shrinkage, leave undisturbed for at least 1 hour before final finishing. Keep patched area damp for 7 days. Alternatively, a proprietary cementitious repair mortar may be used and placed in accordance with manufacturer's instructions. Do not use metal tools in finishing patches in formed walls which will be exposed.

B. Tie Holes: Patch holes immediately after removal of forms. After cleaning and roughening with a wire brush on a rotary drill, thoroughly dampen tie hole and fill solid with patching mortar. Taper tie holes shall have the plug, specified in 03100 - Concrete Formwork, driven into the hole to the center of the wall before grouting. Completely fill taper tie holes with patching mortar except that non-shrink grout shall be used for all walls in contact with soil or liquid. On wall faces exposed to view, fill the outer 2 inches of the taper tie hole with patching mortar blended to match adjacent concrete.

C. Cracks: Repair cracks in excess of 0.01 inch by pressure injection of moisture-insensitive epoxy-resin system. Submit proposed material and method of repair for approval prior to making repairs.

D. Structural Repair: When required, make structural repairs after prior approval of Owner as to method and procedure, using specified epoxy adhesive or approved epoxy mortar.

3.3 FINISHING OF FORMED SURFACES

A. Unfinished Surfaces: Finish is not required on surfaces concealed from view in completed structure by earth, ceilings or similar cover, unless indicated otherwise on Drawings.

B. Rough Form Finish:

1. No form facing material is required on rough form finish surfaces.

2. Patch tie holes and defects. Chip off fins exceeding 1/4 inch in height.

3. Rough form finish may be used on concrete surfaces which will be concealed from view by earth in completed structure, except concealed surfaces required to have smooth form finish, as shown on Drawings.

C. Smooth Form Finish:

1. Form facing shall produce smooth, hard, uniform texture on concrete. Use plywood or fiberboard linings or forms in as large sheets as practicable, and with smooth, even edges and close joints.

2. Patch tie holes and defects. Rub fins and joint marks with wooden blocks to leave smooth, unmarred finished surface.

3. Provide smooth form finish on the wet face of formed surfaces of water-holding structures, and of other formed surfaces not concealed from view by earth in completed structure, except where otherwise indicated on Drawings. Walls that will be exposed after future construction, at locations indicated on Drawings, shall have smooth form finish. Smooth form finish on exterior face of exterior walls shall extend 2 feet below final top of ground elevation. Exterior face of all perimeter grade beams shall have smooth form finish for full depth of grade beam.

D. Rubbed Finish:

1. Use plywood or fiberboard linings or forms in as large sheets as practicable, and with smooth, even edges and close joints.

2. Remove forms as soon as practicable, repair defects, wet surfaces, and rub with No. 16 carborundum stone or similar abrasive. Continue rubbing sufficiently to bring surface paste, remove form marks and fins, and produce smooth, dense surface of uniform color and texture. Do not use cement paste other than that drawn from concrete itself. Spread paste uniformly over surface with brush. Allow paste to reset, then wash surface with clean water.

3. Use rubbed finish at locations indicated on Drawings, except where rubbed finish is indicated for a wall which will be containing a liquid, use spray-applied coating.

E. Spray-applied Coating: At Contractor's option, in lieu of rubbed finish, spray-applied coating may be applied after defects have been repaired and fins removed. Remove form oil, curing compound and other foreign matter that would prevent bonding of coating. Apply coating in uniform texture and color in accordance with coating manufacturer's instructions.

F. Related Unformed Surfaces: Tops of piers, walls, bent caps, and similar unformed surfaces occurring adjacent to formed surfaces shall be struck smooth after concrete is placed. Float unformed surfaces to texture reasonably consistent with that of formed surfaces. Continue final treatment on formed surfaces uniformly across unformed surfaces.

3.4 HOT WEATHER FINISHING

A. When hot weather conditions exist, as defined by Section 03310 - Structural Concrete and as judged by the Owner, apply evaporation retardant to the surfaces of slabs, topping and concrete fill placements immediately after each step in the finishing process has been completed.

3.5 FINISHING SLABS AND SIMILAR FLAT SURFACES TO CLASS A, B AND C TOLERANCES

A. Apply Class A, B and C finishes at locations indicated on Drawings.

B. Shaping to Contour: Use strike-off templates or approved compacting-type screeds riding on screed strips or edge forms to bring concrete surface to proper contour. See Section 03100 - Concrete Formwork for edge forms and screeds.

C. Consolidation and Leveling: Concrete to be consolidated shall be as stiff as practicable Thoroughly consolidate concrete in slabs and use internal vibration in beams and girders of framed slabs and along bulkheads of slabs on grade. Consolidate and level slabs and floors with vibrating bridge screeds, roller pipe screeds or other approved means. After consolidation and leveling, do not permit manipulation of surfaces prior to finishing operations.

D. Tolerances for Finished Surfaces: Check tolerances by placing straightedge of specified length anywhere on slab. Gap between slab and straightedge shall not exceed tolerance listed for specified class.

Straightedge Class	Length in Feet	Tolerance in Inches
A	10	1/8
B	10	1/4
C	2	1/4

E. Raked Finish: After concrete has been placed, struck off, consolidated and leveled to Class C tolerance, roughen surface before final set. Roughen with stiff brushes or rakes to depth of approximately 1/4 inch. Notify Engineer prior to placing concrete requiring initial raked surface finish so that acceptable raked finish standard may be established for project. Protect raked, base-slab finish from contamination until time of topping. Provide raked finish for following:

1. Surfaces to receive bonded concrete topping or fill.

2. Steep ramps, as noted on Drawings.

3. Additional locations as noted on Drawings.

F. Float Finish:

1. After concrete has been placed, struck off, consolidated and leveled, do not work further until ready for floating. Begin floating when water sheen has disappeared, or when mix has stiffened sufficiently to permit proper operation of power-driven float. Consolidate surface with power-driven floats. Use hand floating with wood or cork-faced floats in locations inaccessible to power-driven machine and on small, isolated slabs.

2. After initial floating, re-check tolerance of surface with 10-foot straightedge applied at not less than two different angles. Cut down high spots and fill low spots to Class B tolerance. Immediately re-float slab to a uniform, smooth, granular texture.

3. Provide float finish at locations not otherwise specified and not otherwise indicated on

Drawings.

G. Trowel Finish:

1. Apply float finish as previously specified. After power floating, use power trowel to produce smooth surface which is relatively free of defects but which may still contain some trowel marks. Do additional trowelings by hand after surface has hardened sufficiently. Do final troweling when ringing sound is produced as trowel is moved over surface. Thoroughly consolidate surface by hand troweling operations.

2. Produce finished surface free of trowel marks, uniform in texture and appearance and conforming to Class A tolerance. On surfaces intended to support floor coverings, remove defects which might show through covering by grinding.

3. Provide trowel finish for floors which will receive floor covering and additional locations indicated on Drawings.

H. Broom or Belt Finish:

1. Apply float finish as previously specified. Immediately after completing floated finish, draw broom or burlap belt across surface to give coarse transverse scored texture.

2. Provide broom or belt finish at locations indicated on Drawings.

3.6 FINISHING SLABS AND SIMILAR FLAT SURFACES TO "F-NUMBER SYSTEM" FINISH

A. Shaping to Contour: Use strike-off templates or approved compacting-type screeds riding on screed strips or edge forms to bring concrete surface to proper contour. Edge forms and screeds: Conform to Section 03100 - Concrete Formwork.

B. Consolidation and Leveling: Concrete to be consolidated shall be as dry as practicable. Thoroughly consolidate concrete in slabs and use internal vibration in beams and girders of framed slabs and along bulkheads of slabs on grade. Consolidate and level slabs and floors with vibrating bridge screeds, roller pipe screeds or other approved means. After consolidation and leveling, do not manipulate surfaces prior to finishing operations.

C. Tolerances for Finished Surfaces: Independent testing laboratory will check floor flatness and levelness in accordance with Paragraph 3.12, Field Quality Control.

D. Float Finish:

1. After concrete has been placed, struck off, consolidated and leveled, do not work further until ready for floating. Begin floating when water sheen has disappeared, or when mix has stiffened sufficiently to permit proper operation of power-driven float. Consolidate surface with power-driven floats. Use hand floating with wood or cork-faced floats in locations inaccessible to power-driven machine and on small, isolated slabs.

2. Check tolerance of surface after initial floating with a 10-foot straightedge applied at not less than two different angles. Cut down high spots and fill low spots. Immediately re-float slab to uniform, smooth, granular texture to F_F20/F_L17 tolerance, unless shown otherwise on Drawings.

3. Provide "F-Number System" float finish at locations indicated on Drawings.

E. Trowel Finish:

1. Apply float finish as previously specified. After power floating, use power trowel to produce smooth surface which is relatively free of defects but which may still contain some trowel marks. Do additional trowelings by hand after surface has hardened sufficiently. Do final troweling when ringing sound is produced as trowel is moved over surface. Thoroughly consolidate surface by hand troweling operations.

2. Produce finished surface free of trowel marks, uniform in texture and appearance and conforming to an F_F25/F_L20 tolerance for slabs on grade and F_F25/F_L17 for elevated slabs, unless shown otherwise on Drawings. On surfaces intended to support floor coverings, remove defects, which might show through covering, by grinding.

3. Provide "F-Number System" trowel finish at locations indicated on Drawings.

3.7 BONDED CONCRETE TOPPING AND FILL

A. Surface Preparation:

1. Protect raked, base-slab finish from contamination until time of topping. Mechanically remove oil, grease, asphalt, paint, clay stains or other contaminants, leaving clean surface.

2. Prior to placement of topping or fill, thoroughly dampen roughened slab surface and leave free of standing water. Immediately before topping or fill is placed, scrub coat of bonding grout into surface. Do not allow grout to set or dry before topping or fill is placed.

B. Concrete Fill:

1. Where concrete fill intersects a wall surface at an angle steeper than 45 degrees from vertical, provide a 1.5-inch deep keyway in the wall at the point of intersection; size keyway so that no portion of the concrete fill is less than 1.5 inches thick. Form keyway in new walls; create by sawcutting the top and bottom lines and chipping in existing walls.

2. Apply wood float finish to surfaces of concrete fill.

3. Provide concrete fill at locations shown on Drawings.

C. Bonded Concrete Topping in Bottom of Clarifiers and Thickeners:

1. Minimum thickness of concrete topping: 1 inch. Maximum thickness when swept in by clarifier and thickener equipment: 3 inches.

2. Compact topping and fill by rolling or tamping, bring to established grade, and float. Topping grout placed on sloping slabs shall proceed uniformly from the bottom of the slab to the top, for the full width of the placement. Coat surface with evaporation retardant as needed between finishing operations to prevent plastic shrinkage cracks.

3. Screed topping to true surface using installed equipment. Protect equipment from damage during sweeping-in process. Perform sweeping-in process under supervision of equipment manufacturer's factory representative. After topping has been screeded, apply wood float finish. During finishing, do not apply water, dry cement or mixture of dry cement and sand to the surface.

4. As soon as topping or fill finishing is completed, coat surface with curing compound. After the topping is set and sufficiently hard in clarifiers and where required by the Owner, fill the tank with sufficient water to cover the entire floor for 14 days.

5. Provide bonded concrete topping in bottom of all clarifiers and thickeners.

3.8 EPOXY PENETRATING SEALER

A. Surfaces to receive epoxy penetrating sealer: Apply wood float finish. Clean surface and apply sealer in compliance with manufacturer's instructions.

B. Rooms with concrete curbs or bases: Continue application of floor coating on curb or base to its juncture with masonry wall. Rooms with solid concrete walls or wainscots: Apply minimum 2-inch-high coverage of floor coating on vertical surface.

C. Mask walls, doors, frames and similar surface to prevent floor coating contact.

D. When coving floor coating up vertical concrete walls, curbs, bases or wainscots, use masking tape or other suitable material to keep a neat level edge at top of cove.

E. Provide epoxy penetrating sealer at locations indicated on Drawings.

3.9 EPOXY FLOOR TOPPING

A. Surfaces to receive epoxy floor topping: Apply wood float finish unless recommended otherwise by epoxy floor topping manufacturer. Clean surface and apply epoxy floor topping in compliance with manufacturer's recommendations and instructions. Thickness of topping: 1/8 inch.

B. Rooms with concrete curbs or bases: Continue application of floor coating on curb or base to its juncture with masonry wall. Rooms with solid concrete walls or wainscots: apply 2-inch-high coverage of floor coating on vertical surface.

C. Mask walls, doors, frames and similar surfaces to prevent floor coating contact.

D. When coving floor coating up vertical concrete walls, curbs, bases or wainscots, use masking tape or other suitable material to keep a neat level edge at top of cove.

E. Finished surface shall be free of trowel marks and dimples.

F. Provide epoxy floor topping at locations indicated on Drawings.

3.10 SEALER/DUSTPROOFER

A. Where sealer or sealer/dustproofer is indicated on Drawings, just prior to completion of construction, apply coat of specified clear sealer/dustproofing compound to exposed interior concrete floors in accordance with manufacturer's instructions.

3.11 NONSLIP FINISH

A. Apply float finish as specified. Apply two-thirds of required abrasive aggregate by method that ensures even coverage without segregation and re-float. Apply remainder of abrasive aggregate at right angles to first application, using heavier application of aggregate in areas not sufficiently covered by first application. Re-float after second application of aggregate and complete operations with troweled finish. Perform finishing operations in a manner that will allow the abrasive aggregate to be exposed and not covered with cement paste.

B. Provide non-slip finish at locations indicated on Drawings.

3.12 FIELD QUALITY CONTROL

A. Flatness and levelness of slabs and similar flat surfaces that are indicated on Drawings to receive "F-Number System" finish will be checked by independent testing laboratory employed by Owner in accordance with Section 01410 - Testing Laboratory Services.

B. Tolerances for "F-Number System" finished surfaces:

1. Floor tolerance shall be determined in accordance with ASTM E1155.

2. Floor flatness and levelness tolerances:

a. F_F defines maximum floor curvature allowed over 24 inches. Computed on the basis of successive 12-inch elevation differentials, F_F is commonly referred to as the "flatness F-Number."

F_F = 4.57
Maximum difference in elevation, in decimal inches, between successive 12" elevation differences.

b. F_L defines relative conformity of floor surface to horizontal plane as measured over 10-foot distance. F_L is commonly referred to as "levelness F-number."

F_L = 12.5
Maximum difference in elevation, in inches,
between two points separated by 10 feet.

3. Achieve specified overall slab tolerance. Minimum local tolerance (1/2 bay, unless otherwise designated by Engineer): 2/3 of specified tolerance.

4. Tolerance for floated finish: F_F20/F_L17, unless otherwise shown on Drawings.

5. Tolerance for troweled finish: F_F25/F_L20 for slabs on grade, and F_F25/F_L17 for elevated slabs, unless otherwise shown on Drawings.

3.13 CURING

A. Conform to requirements of Section 03370 - Curing Concrete.

END OF SECTION

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SECTION 03370

CONCRETE CURING

PART 1 – G E N E R A L

1.1 SECTION INCLUDES

A. Curing of structural concrete.

1.2 MEASURMENT AND PAYMENT

A. Unit prices.

1. Refer to Section 01200 – Measurement and Payment, for unit price procedures.

B. Stipulated Price (Lump Sum). If the Contract is a Stipulated Price Contract, payment for work in this section is included in the total Stipulated Price.

1.3 REFERENCES

A. ACI 308 - Standard Practice for Curing Concrete.

B. ASTM C171 - Standard Specifications for Sheet Materials for Curing Concrete.

C. ASTM C309 - Standard Specification for Liquid Membrane-Forming Compounds for Curing Concrete.

D. ASTM D44587 - Conducting Tests on Paint and Related Coatings and Materials Using a Fluorescent UV-Condensation Light-and Water-Exposure Apparatus.

1.4 DEFINITIONS

A. Mass Concrete: Concrete sections 4 feet or more in least dimension.

1.5 SUBMITTALS

A. Conform to Section 01300 - Submittals.

B. Product Data: Submit description of proposed curing method for concrete. When use of membrane-forming compound is proposed, submit manufacturer's technical information including material specifications, installation instructions and recommendations, and evidence that compound is satisfactory for intended application. State locations where curing compound will be used.

C. When membrane-forming compounds are to be used, submit certification by the manufacturer of compliance with specified requirements and compatibility with toppings, coatings, finishes, and adhesives to be applied.

PART 2 –PRODUCTS

2.1 MATERIALS

A. Membrane-forming Curing Compound: Conform to ASTM C309, Type 1D, and following requirements.

1. Minimum solids content: 30 percent.

2. Compound shall not permanently discolor concrete. When used for liquid- containing structures, curing compound shall be white-pigmented.

3. When used in areas that are to be coated, or that will receive topping or floor covering, material shall not reduce bond of coating, topping, or floor covering to concrete. Curing compound manufacturer's technical information shall state conditions under which compound will not prevent bond.

4. Conform to local, state and federal solvent emission requirements.

B. Clear Curing and Sealing Compound (VOC Compliant): Conform to ASTM C309, Type 1, Class B, and the following requirements: 30 percent solids content minimum; non-yellowing under ultraviolet light after 500-hour test in accordance with ASTM D4587. Sodium silicate compounds are not permitted. Conform to local, state and federal solvent emission requirements.

C. Sheet Material for Curing Concrete: ASTM C171; waterproof paper, polyethylene film or white burlap-polyethylene sheeting.

D. Curing Mats (for use in Curing Method 2): Heavy shag rugs or carpets, or cotton mats quilted at 4 inches on center; 12 ounce per square yard minimum weight when dry.

E. Water for curing: Clean and potable.

PART 3 –EXECUTION

3.1 CURING PROCEDURES

A. Comply with ACI 308 and the requirements specified herein. Protect freshly-deposited concrete from premature drying and excessively hot or cold temperatures. Maintain minimal moisture loss and relatively constant temperature during time necessary for hydration of cement and proper hardening of concrete.

B. Unformed Surfaces: For concrete surfaces not in contact with forms, use one of following procedures immediately after completion of placement and finishing.

1. Ponding or continuous sprinkling.

2. Absorptive mat or fabric kept continuously wet.

3. Sand or other covering kept continuously wet.

4. Continuous steam bath (not exceeding 150 degrees F at surface of concrete).

5. Vapor mist bath.

6. Membrane-forming curing compound applied according to manufacturer's recommendations. After the curing compound has dried, wet slab surfaces and cover with waterproof paper, polyethylene film, or white burlap-polyethylene sheeting after the application of the curing compound. Tape sheet seams together and provide sufficient weights to keep the sheeting in place. Rewet the slab surface if the sheeting becomes dislodged, and replace the sheeting.

7. Other moisture-retaining coverings as approved by Owner.

C. Restrictions on Use of Curing Compounds: Unless curing compound manufacturer certifies that curing compound will not prevent bond to cured surface, do not use curing compound on

surfaces that will be rubbed or receive additional concrete, mortar, topping, terrazzo or other cementitious finishing materials, on slabs under resilient floors or built-up roofing, or on surfaces to be waterproofed, sealed, hardened or painted.

D. Curing and Sealing Compounds: At locations indicated, cure exposed interior slabs and troweled slabs receiving mastic-applied adhesives with specified clear curing and sealing compound in accordance with manufacturer's recommendations. Do not store materials directly on curing membranes. Use plywood to protect curing membrane from damage. Immediately repair membranes damaged by foot traffic or other operations.

E. Duration of Curing: Continue curing until cumulative number of days or fractions of days during which ambient temperature is above 50 degrees F has totaled 7. Continue curing of water-retaining structures for a total of 14 days. When high-early-strength concrete has been used, continue curing for total of 3 days. Prevent rapid drying at end of curing period.

F. Formed Surfaces: During the curing period keep wet steel forms heated by sun and wood forms in contact with concrete. When forms are to be removed during curing period, employ curing materials or methods immediately. Continue such curing for remainder of curing period.

G. Temperature:

1. Cold Weather: When mean daily temperature of atmosphere is less than 40 degrees F, maintain temperature of concrete between 50 and 70 degrees F for required curing period. When necessary, make arrangements for heating, covering, insulating or housing concrete work in advance of placement to maintain required temperature and moisture conditions. Prevent damage or injury due to concentration of heat. When combustion heaters are necessary in enclosed or protected area where concrete slabs are being placed, vent heaters.

2. Hot Weather: In advance of placement make arrangements for shading, fog spraying, sprinkling, ponding or installation of windbreaks or wet covering of light color. Take such protective measures as quickly as concrete hardening and finishing operations will allow.

3. Temperature Changes: Control so rate of change in temperature of concrete is as uniform as possible. Do not permit temperature change to exceed 5 degrees F in any one hour or 50 degrees F in any 24-hour period.

H. Protection from Mechanical Injury: During curing period, protect concrete from damaging mechanical disturbances, particularly load stresses, heavy shock, and excessive vibration. Protect finished concrete surfaces from damage caused by construction equipment, materials or methods, and by rain or running water. Do not load self-supporting structures in a way that overstresses concrete.

3.2 CURING MASS CONCRETE

A. Observe the following additional restrictions when curing mass concrete.

1. Minimum curing period: 2 weeks.

2. When ambient air temperature falls below 32 degrees F, protect surface of concrete against freezing.

3. Do not use steam or other curing methods that will add heat to concrete.

4. Keep forms and exposed concrete continuously wet for at least the first 48 hours after placing, and whenever surrounding air temperature is above 90 degrees F during final curing period.

5. During 2-week curing period, provide necessary controls to prevent ambient air temperature immediately adjacent to concrete from falling more than 30 degrees F in 24 hours.

END OF SECTION

SECTION 03600

STRUCTURAL GROUT

PART 1 – G E N E R A L

1.1 SECTION INCLUDES

A. Non-shrink grout used wherever grout is shown in the Documents, unless another type is specifically referenced. Two classes of non-shrink grout (Class I and II) and areas of application are specified.

1.2 MEASUREMENT AND PAYMENT

A. Unit prices.

1. Refer to Section 01200 – Measurement and Payment, for unit price procedures.

B. Stipulated Price (Lump Sum). If the Contract is a Stipulated Price Contract, payment for work in this section is included in the total Stipulated Price.

1.3 REFERENCES

A. CRD-C621 - Corps of Engineers Specification for Non-shrink Grout

B. ASTM C109 - Test Method for Compressive Strength of Hydraulic Cement Mortars (Using 2-in or 50-mm Cube Specimens)

C. ASTM C230 - Specifications for Flow Table for use in Tests of Hydraulic Cement

D. ASTM C1107 - Standard Specification for Packaged Dry, Hydraulic-Cement Grout (Non-shrink)

1.4 SUBMITTALS

A. Conform to Section 01300 - Submittals.

B. Quality Control:

1. The Contractor shall submit manufacturer's literature certifying compliance with the specified properties for Class I and II grouts.

2. The Contractor shall submit manufacturer's literature containing instructions and recommendations on the mixing, handling, placement and appropriate uses for each type of grout used in the work.

C. The Contractor shall submit manufacturer's written warranty as specified.

1.5 QUALITY CONTROL

A. Field Tests:

1. Compression test specimens will be taken during construction from the first placement of each type of grout, and at intervals thereafter as selected by the Owner to ensure continued compliance with these Specifications. The specimens will be made by the Owner or its representative.

2. Compression tests and fabrication of specimens for non-shrink grout will be performed as specified in ASTM C109 at intervals during construction as selected by the Owner. A set of three specimens will be made for testing at 7 days, 28 days, and each additional time period as appropriate.

3. Grout already placed which fails to meet the requirements of these Specifications is subject to removal and replacement no additional cost to the Owner.

4. The cost of laboratory tests on grout will be borne by the Owner, but the Contractor shall assist the Owner in obtaining specimens for testing. However, the Contractor shall be charged for the cost of any additional tests and investigation on work performed which does not meet the Specifications. The Contractor shall supply materials necessary for fabricating the test specimens.

B. Warranty:

1. Provide 1-year warranty for work provided under this Section.

2. Manufacturer's warranty shall not contain a disclaimer limiting responsibility to only the purchase price of products or materials furnished.

3. Manufacturer shall warrant participation with Contractor in replacing or repairing grout found to be defective due to faulty materials, as determined by industry standard test methods.

PART 2 –PRODUCTS

2.1 APPLICATION

The following is a listing of typical applications and the corresponding type of grout which is to be used. Unless indicated otherwise, grouts shall be provided as listed below whether or not called for on the Drawings.

Application:	Type of Grout
Structural member base plates	Non-shrink Class II
Storage tanks and other equipment	Non-shrink Class I
Filling blockout spaces for embedded items such as railing posts, gate guide frames, etc.	Non-shrink Class II (Class I where placement time exceeds 15 minutes)
Under precast concrete elements	Non-shrink Class I
Toppings and concrete fill less than 3 inches thick	Concrete Topping per Section 03310 and Section 03345
Application:	Type of Grout
Toppings and concrete fill greater than 3 inches thick	Concrete Fill per Section 03310 and Section 03345
Any application not listed above, where grout is called for on the Drawings	Non-shrink Class I, unless noted otherwise

2.2 PREPACKAGED GROUTS

A. Basic Requirements for Cementitious Non-Shrink Grout

1. Provide prepackaged non-shrink grout that is inorganic, flowable, non-gas-liberating, non-metallic, and cement-based, requiring only the addition of water.

2. Deliver grout in original packaging with manufacturer's instructions printed on each container.

3. Select the specific formulation for each class of non-shrink grout specified to conform to that recommended by the manufacturer for the particular application.

4. Compressive strength at 28 days: 7000 psi minimum.

5. Do not use a grout for which the non-shrink property is based on a chemically generated gas or gypsum expansion.

B. Class I Non-Shrink Grout:

1. Supply Class I Grout conforming to these specifications and to CRD-C621 and ASTM C1107 Grade C and B (as modified below) when tested using the amount of water needed to achieve the following properties:

   a. Fluid consistency (20 to 30 seconds) per CRD-C611 at initial testing.

   b. Fluid consistency (45 seconds) per CRD-C611 at 30 minutes after mixing.

   c. At temperatures of 45, 73.4, and 95 degrees F.

2. To satisfy non-shrink requirements, the length change from placement to time of final set shall not have a shrinkage greater than the amount of expansion measured after final set at 3 and 14 days. The expansion at 3 and 14 days shall not exceed the 28-day expansion.

3. Fluid grout shall pass through the flow cone, with a continuous flow, 1 hour after mixing.

4. Demonstrate in tests that grout maintains contact with the baseplate to provide an minimum effective bearing area of 95 percent of the gross contact area after final set.

5. The grout packaging shall list weight, maximum amount of mixing water to be used, maximum usable working time (pot life) at flowable consistency, and temperature restrictions for preparation and placement within which grout will meet specified requirements.

C. Class II Non-Shrink Grout:

1. Supply Class II Grout confirming to ASTM C1107 and the following requirements when tested using the amount of water needed to achieve the following properties:

   a. Flowable consistency: 140 percent flow on ASTM C 230, five drops in 30 seconds.

   b. Fluid working time: 15 minutes, minimum.

   c. Flowable duration: 30 minutes, minimum.

2. When tested, the grout shall not bleed at maximum allowed water.

2.3 CURING MATERIALS

A. Curing materials: As specified in Section 03370 - Concrete Curing and as recommended by the manufacturer of prepackaged grouts.

2.4 CONSISTENCY

A. Mix grouts to the consistency necessary to completely fill the space to be grouted. Dry pack consistency is such that the grout is plastic and moldable but will not flow. Where "dry pack" is called for in the Contract Documents, it shall mean a grout of that consistency; the type of grout to be used shall be as specified herein for the particular application.

PART 3 –EXECUTION

3.1 PREPARATION

A. Verify that base concrete or masonry has attained design strength before grout is placed.

B. When cementitious grouts are used on concrete surfaces, saturate the concrete surface with water for 24 hours prior to placement of cement-based grout. Upon completion of saturation period remove excess water prior to grouting.

3.2 GROUTING PROCEDURES

A. Prepackaged Grouts: Perform mixing, surface preparation, handling, placing, consolidation, curing, and other means of execution for prepackaged grouts according to the written instructions of the manufacturer. Use prepackaged materials in the quantities and proportions as directed by the manufacturer unless there is certified test data verifying that the specified properties are attained by modified mix.

3.3 CONSOLIDATION

A. Place grout in such a manner, for the consistency necessary for each application, so as to assure that the space to be grouted is completely filled.

END OF SECTION