

Document 3. Technical Specifications

Webb Chapel Bridge

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Technical Specifications

In every state of the United States of America, the bridge designs have to follow AASHTO specifications. Everything required for the design of a bridge from the foundation to the deck is considered in AASHTO.

For construction specifications every state in the US has its own specification, in Texas Standard Specification for Construction and Maintenance of Highways, Streets and Bridges. It is known as Maroon Book.

As this project is about the construction of a Bridge, we will focus on some of the articles. These chapters are:

- 416. Drilled Shaft Foundations
- 110. Excavation
- 420. Concrete Structures
- 422. Reinforced Concrete Slab
- 423. Retaining Walls
- 425. Precast Prestressed Concrete Structural

409.5 to 416.2

Test-loaded piling and associated anchor piling will be paid for as provided in Item 405, "Foundation Test Load" except that any test load ordered by the Engineer that is not provided for in the Contract will be paid for in accordance with Article 9.4, "Payment for Extra Work."

- A. Concrete Piling.** The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Prestressed Concrete Piling" or "Prestressed Concrete Test Piling" of the size specified.
- B. Buildups.** An additional payment for each completed authorized buildup splice for both regular and test piling, regardless of buildup length, will be made at a price equal to 10 times the unit price bid for "Prestressed Concrete Piling." Where piling is broken back for constructing buildups, payment for the breakback is included in the payment for buildups.
- C. Cutoffs.** Payment for cutoff lengths of both regular piling and test piling will be made at a price equal to 1/2 the unit price bid per foot for "Prestressed Concrete Piling."

ITEM 416

DRILLED SHAFT FOUNDATIONS

416.1. Description. Construct foundations consisting of reinforced or non-reinforced concrete drilled shafts with or without bell footings.

416.2. Materials. Use materials that meet the requirements of the following Items:

- Item 421, "Hydraulic Cement Concrete"
- Item 440, "Reinforcing Steel"
- Item 448, "Structural Field Welding."

Unless otherwise shown on the plans, use concrete for drilled shafts that meets the requirements of Table 1.

Table 1
Concrete for Drilled Shafts

Drilled Shaft Type	Concrete
Non-reinforced	Class A
Reinforced	Class C
Slurry and underwater concrete placement	Class SS

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Use coarse aggregate Grade 4, 5, or 6 for drilled shaft concrete in reinforced drilled shafts. Grade 2 or 3 may be used if the shaft is dry and reinforcing steel has a 5-in. minimum clear spacing.

Use a water-reducing, retarding admixture in accordance with DMS-4640, "Chemical Admixtures for Concrete," in all concrete when using casing that will be pulled or when placing shafts underwater or under slurry.

Use concrete with slump that meets the requirements of Table 2 as determined by Tex-415-A.

Table 2
Slump Requirements

Placement Type	Minimum Acceptable Placement Slump, in.	Recommended Design and Placement Slump, in.	Maximum Acceptable Placement Slump, in.
Dry	5-1/2	6-1/2	7-1/2
Underwater and under slurry	7	8	9

When casing is to be pulled or when concrete is to be placed underwater or under slurry, perform a slump loss test in accordance with Tex-430-A before beginning work. Provide concrete that will maintain a slump of at least 4 in. throughout the entire anticipated time of concrete placement. Time of concrete placement is described in Sections 416.3.F, "Concrete," and 416.3.G, "Additional Requirements for Slurry Displacement or Underwater Concrete Placement Methods." Note the temperature of the concrete mix at the beginning of the slump loss test. If concrete temperature at the time of placement into the drilled shaft is more than 10° higher than the slump loss test temperature, do not place the concrete. Use ice or other concrete cooling ingredients to lower concrete temperature, or run additional slump loss tests at the higher temperatures. Slump loss testing will be waived if anticipated time of concrete placement is less than 90 minutes.

Use drilling slurry that meets the requirements of Table 3, as determined by Tex-130-E.

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Table 3
Slurry Requirements

Before Introduction into the Excavation		Sampled from the Bottom of the Excavation before Concreting		
Specific Gravity	Sand Content	Specific Gravity	Viscosity (seconds)	Sand Content
≤ 1.10	≤ 1%	≤ 1.15	≤ 45	≤ 6%

Use mineral slurry consisting of processed bentonite or attapulgite clays mixed with clean fresh water. Do not use PHPA (partially hydrolized polyacrylamide) polymeric slurry or any other fluid composed primarily of a polymer solution.

Before placing concrete, sample slurry from the bottom of the hole, and test it in accordance with Tex-130-E. Use a pump or air lift to remove slurry that does not meet the requirements of Table 3 while adding fresh clean slurry to the top of the hole to maintain the slurry level. Continue this operation until the slurry sampled from the bottom of the hole meets the requirements.

416.3. Construction. Place the shaft to within the following tolerances.

- Vertical plumbness – 1 in. per 10 ft. of depth.
- Center of shaft located under column – 1 in. of horizontal plan position.
- Center of shaft located under footing – 3 in. of horizontal plan position.

Complete the embankment at bridge ends before installing drilled shafts that pass through the fill. Refer to Item 423, “Retaining Walls,” for provisions for drilled shafts passing through the structural volume of retaining walls.

A. Excavation. The plans indicate the expected depths and elevations for encountering satisfactory bearing material. Excavate as required for the shafts and bell footings through all materials encountered to the dimensions and elevations shown on the plans or required by the site conditions. Removal of man-made obstructions not shown on the plans will be paid for in accordance with Article 9.4, “Payment for Extra Work.” If satisfactory founding material is not encountered at plan elevation, adjust the bottom of the shaft or alter the foundation, as determined by the Engineer, to satisfactorily comply with design requirements. Blasting is not allowed for excavations.

If caving conditions are encountered, stop drilling and adopt a construction method that stabilizes the shaft walls.

Do not excavate a shaft within 2 shaft diameters (clear) of an open shaft excavation, or one in which concrete has been placed in the preceding 24 hours.

Dispose of material excavated from shafts and bells and not incorporated into the finished project. Dispose of excavated material in accordance with the plans and with federal, state, and local laws.

Provide suitable access, lighting, and equipment for proper inspection of the completed excavation and for checking the dimensions and alignment of shafts and bell excavation.

- B. Core Holes.** If directed, take cores to determine the character of the supporting materials. Use a method that will result in recovery of an intact sample adequate for judging the character of the founding material. Such cores should be at least 5 ft. deeper than the proposed founding grade or a depth equal to the diameter of the shaft, whichever is greater. Take these cores when the excavation is approximately complete.
- C. Casing.** Use casing when necessary to prevent caving of the material or to exclude ground water. Provide casing with an outside diameter not less than the specified diameter of the shaft. Use casing strong enough to withstand handling stresses and pressures of concrete and of the surrounding earth or water, and that is watertight, smooth, clean, and free of accumulations of hardened concrete.

Drill the portion of the shaft below the casing as close as possible to the specified shaft diameter. The portion of shaft below the casing may be as much as 2 in. smaller than the specified shaft diameter.

Use construction methods that result in a minimal amount of disturbed soil being trapped outside the casing. This does not apply to temporary undersized casings used to protect workers inside shafts or to drilled shafts designed for point bearing only.

Do not leave any casing in place unless authorized or shown on the plans. Do not extract casing until after placing the concrete to an appropriate level. Maintain sufficient concrete in the casing at all times to counteract soil and water pressure. Before and during concrete placement, rotate or move the casing up or down a few inches if necessary to facilitate extraction of the casing.
- D. Requirements for Slurry Displacement Method.** Unless otherwise shown on the plans, the slurry displacement method may be used to construct drilled shafts. Use this method to support the sides of the

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excavation with processed mineral slurry that is then displaced by concrete to form a continuous concrete shaft.

Do not use casing other than surface casing. Do not use surface casing longer than 20 ft. without approval. Do not extract the surface casing until after placing the concrete.

For slurry mixed at the project site, pre-mix it in a reservoir of sufficient capacity to fill the excavation and for recovery of the slurry during concrete placement. Do not mix slurry in the shaft excavation or other hole. Allow adequate time for hydration of the slurry prior to introduction into the excavation.

During and after drilling maintain a head of slurry in the shaft excavation at or near ground level or higher as necessary to counteract ground water pressure.

Just before placing reinforcing steel, use an air lift or proper size cleanout bucket to remove any material that may have fallen from the sides of the excavation or accumulated on the bottom after the completion of drilling. Use a cleanout bucket if material is too large to be picked up with an air lift.

If concrete placement is not started within 4 hours of the completion of the shaft excavation, reprocess the hole with the auger as directed. Then clean the bottom with an air lift or cleanout bucket, and check the slurry at the bottom of the hole for compliance with the slurry requirements of Article 416.2, "Materials."

If the slurry forms a gel before concrete placement, agitate the congealed slurry to liquefaction just before concrete placement and whenever directed.

Recover and dispose of all slurry as approved by the Engineer, and in accordance with all federal, state, and local laws. Do not discharge slurry into or in close proximity to streams or other bodies of water.

- E. Reinforcing Steel.** Completely assemble the cage of reinforcing steel, and place it as a unit immediately before concrete placement. The cage consists of longitudinal bars and lateral reinforcement (spiral reinforcement, lateral ties, or horizontal bands). If overhead obstacles prevent placement of the cage as a single unit, connect individual segments with couplers or by lapping steel as approved.

If the shaft is lengthened beyond plan length, extend the reinforcing steel cage as follows, unless directed otherwise:

- For shafts supporting structures other than bridges, extend the cage to the bottom.

- For bridge shafts with plan lengths of less than 25 ft., extend the cage to 25 ft. or to the bottom, whichever is shorter.
- For bridge shafts with plan lengths at least 25 ft. that are lengthened less than 33% of plan length, extending the cage is not necessary.
- For bridge shafts with plan lengths at least 25 ft. that are lengthened more than 33% of plan length, extend the cage as directed.

If the cage does not reach the bottom of the shaft, it may be suspended, or a portion of the longitudinal steel may be extended to support the cage on the bottom of the shaft. Bars used to extend or support the cage may be lap spliced or welded by a qualified welder. Place the extension at the bottom of the shaft.

If using spiral reinforcement, tie it to the longitudinal bars at a spacing of at most 24 in., or as required for a stable cage. Do not weld lateral reinforcement to longitudinal bars unless otherwise shown on the plans.

Center the reinforcing steel cage in the excavation using approved centering devices. Use enough devices to hold the cage in position along its entire length. Do not use square concrete spacer blocks in cased shafts.

Support or hold down the cage to control vertical displacement during concrete placement or extraction of the casing. Use support that is concentric with the cage to prevent racking and distortion of the steel.

Check the elevation of the top of the steel cage before and after concrete placement or after casing extraction when casing is used. Downward movement of the steel up to 6 in. per 20 ft. of shaft length and upward movement of the steel up to 6 in. total are acceptable.

Maintain the minimum length of steel required for lap with column steel. Use dowel bars if the proper lap length is provided both into the shaft and into the column. Locate and tie all dowel bars into the cage before placing concrete or insert dowel bars into fresh, workable concrete.

Locate and tie anchor bolts when required prior to placement of concrete. Use templates or other devices to assure accurate placement of anchor bolts.

- F. Concrete.** Perform all work in accordance with requirements of Item 420, "Concrete Structures." Mass concrete placement requirements do not apply to drilled shafts.

Form portions of drilled shaft that project above natural ground.

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Remove loose material and accumulated seep water from the bottom of the excavation before placing concrete. If water cannot be removed, place concrete using underwater placement methods.

Place concrete as soon as possible after all excavation is complete and reinforcing steel is placed. Provide workable concrete that does not require vibrating or rodding. Vibrate formed portions of drilled shafts.

Place concrete continuously for the entire length of the shaft. For dry shafts of 24 in. or smaller diameter, limit free fall of concrete to 25 ft. Use a suitable tube or tremie to prevent segregation of materials. Use a tube or tremie in sections to provide proper discharge and to permit raising as the placement progresses. For dry shafts over 24 in. diameter, concrete can be allowed to free fall an unlimited distance if it does not strike the reinforcing cage or sides of the hole during placement. When free fall is used, provide a hopper with a minimum 3-ft.-long drop tube at the top of the shaft to direct concrete vertically down the center of the shaft. Do not use a shovel or other means to simply deflect the concrete discharge from the truck.

For cased shafts, maintain a sufficient head of concrete at all times above the bottom of the casing to overcome hydrostatic pressure.

Extract casing at a slow, uniform rate with the pull in line with the axis of the shaft. Monitor the concrete level in the casing during extraction. Stop the extraction and add concrete to the casing as required to ensure a completely full hole upon casing removal. The elapsed time from the mixing of the first concrete placed into the cased portion of the shaft until the completion of extraction of the casing must not exceed the time for which the concrete maintains a slump of over 4 in. in accordance with Article 416.2, "Materials." If the elapsed time is exceeded, modify the concrete mix, the construction procedures, or both for subsequent shafts.

Cure the top surface and treat any construction joint area in accordance with Item 420, "Concrete Structures."

- G. Additional Requirements for Slurry Displacement or Underwater Concrete Placement Methods.** Place concrete on the same day that the shaft is excavated and as soon as possible after all excavation is complete and reinforcing steel is placed. Use an air lift or cleanout bucket of the proper size to clean the bottom of the excavation prior to placing the reinforcing steel cage and concrete. Place concrete through a closed tremie or pump it to the bottom of the excavation. Initially seal the tremie or pump line to positively separate the concrete from the slurry or water. Place concrete continuously from the beginning of

placement until the shaft is completed. If using a tremie, keep it full of concrete and well submerged in the previously placed concrete at all times. Raise the tremie as necessary to maintain the free flow of concrete and the stability of any casing used. If using a pump, keep the discharge tube submerged in the previously placed concrete at all times. Place additional concrete to ensure the removal of any contaminated concrete at the top of the shaft. At the completion of the pour, allow the top portion of concrete to flush completely from the hole until there is no evidence of slurry or water contamination. Do not attempt to remove this concrete with shovels, pumps or other means. Level the top of shaft with hand tools as necessary.

Use a sump or other approved method to channel displaced fluid and concrete away from the shaft excavation. Recover slurry and dispose of it as approved. Do not discharge displaced fluids into or in close proximity to streams or other bodies of water. For pours over water, provide a collar or other means of capturing slurry and the top portion of concrete flushed from the shaft.

If concrete placement is interrupted due to withdrawal of the submerged end of the tremie or pump discharge tube before completion, remove the tube, reseal it at the bottom, penetrate with the tube into the concrete already placed by at least 5 ft., and recharge it before continuing.

The elapsed time from the mixing of the first concrete placed until the completion of concrete placement, including extraction of the casing, must not exceed the time for which the concrete maintains a slump of over 4 in. in accordance with Article 416.2, "Materials." If the elapsed time is exceeded, modify the concrete mix, the construction procedures, or both for subsequent shafts.

- H. Test Load.** If required, test load shafts in accordance with Item 405, "Foundation Test Load."

416.4. Measurement.

- A. Drilled Shaft.** Drilled shaft foundations will be measured by the foot to the bottom of the shaft.

- 1. Interior Bents and Piers.** Shafts will be measured from a point approximately 6 in. below the finished earthwork elevation at the center of each shaft, unless specific elevations or dimensions are indicated on the plans or unless the Engineer directs otherwise to meet unusual conditions. The bent height shown on the plans is for

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estimating purposes only and does not control the top-of-shaft measurement.

2. **Abutment Bents and Retaining Walls.** Shafts will be measured from the bottom of footing or cap elevation.
3. **Other Non-Bridge Structures.** Shafts will be measured from the top of the shaft.

B. Bell Footing. Bell footings will be measured by the cubic yard of concrete outside of the plan dimensions of the shaft. Bell footings are a plans quantity measurement item. The quantity to be paid is the quantity shown in the proposal, unless modified by Article 9.2, "Plans Quantity Measurement." Additional measurements or calculations will be made if adjustments of quantities are required.

C. Core Hole. Core holes will be measured by each core hole drilled.

416.5. Payment. The unit prices bid for the various classifications of drilled shafts and bell footings will be full compensation for excavation; furnishing, placing, and removing casing; furnishing, processing, and recovering slurry; pumping; furnishing, and placing reinforcing steel; furnishing and placing concrete, including additional concrete required to fill an oversize casing or oversize excavation; conducting slump loss tests; backfilling; disposing of cuttings and slurry; and materials, tools, equipment, labor, and incidentals.

When the bottom of a drilled shaft is placed at an elevation below plan grade, no direct payment will be made for extra reinforcement placed to support the cage. The extra reinforcement will be considered subsidiary to the price bid per foot of shaft. No extra payment will be made for casings left in place.

No payment will be made for "Bell Footing" or "Drilled Shaft" until the concrete has been placed.

A. Drilled Shaft. The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Drilled Shaft" or "Drilled Shaft (Non-reinforced)" or "Drilled Shaft (Sign Mounts)" or "Drilled Shaft (High Mast Pole)" of the specified diameter, subject to the limitations for overruns authorized by the Engineer given in Section 416.5.A.1, "Overrun."

1. **Overrun.** Payment for individual completed shaft lengths up to and including 5 ft. in excess of the maximum plan length shaft, as

defined in Section 416.5.A.2, "Maximum Plan Length Shaft," will be made at the unit price bid per foot of the specified diameter.

Payment for the portion of individual completed shaft length in excess of 5 ft. and up to and including 15 ft. more than the maximum plan length shaft, as defined in this Item, will be made at a unit price equal to 115% of the unit price bid per foot of the specified diameter.

Payment for that portion of individual completed shaft length in excess of 15 ft. more than the maximum plan length shaft, as defined in Section 416.5.A.2, will be made at a unit price equal to 125% of the unit price bid per foot of the specified diameter.

2. **Maximum Plan Length Shaft.** Payment described above is subject to the following provisions for extra depth drilling:
 - For bridge structures, the maximum plan length shaft is the maximum length shaft, regardless of diameter, for any drilled shaft on that specific bridge.
 - For retaining walls, the maximum plan length shaft is the maximum length shaft, regardless of diameter, for any drilled shaft on that specific retaining wall.
 - For overhead sign structures, the maximum plan length shaft is the maximum length shaft, regardless of diameter, for any overhead sign structures included in the contract.
 - For high mast illumination poles, the maximum plan length shaft is the maximum length shaft, regardless of diameter, for any high mast illumination pole included in the contract.
- B. **Bell Footing.** Bell footings constructed to specified dimensions will be paid for at the unit price bid per cubic yard for "Bell Footings." The quantity to be paid for will be the quantity shown on the plans, unless revised by the Engineer in accordance with "Measurement."
- C. **Core Hole.** Core holes will be paid at \$125 each.

420.1 to 420.2

ITEM 420
CONCRETE STRUCTURES

420.1. Description. Construct concrete structures.

420.2. Materials.

- A. Concrete.** Provide concrete conforming to Item 421, “Hydraulic Cement Concrete.” For each type of structure or unit, provide the class of concrete shown on the plans or in pertinent governing specifications.
- B. Grout or Mortar.** Provide grout or mortar conforming to Section 421.2.F, “Mortar and Grout.”
- C. Latex.** Provide an acrylic-polymer latex admixture (acrylic resin emulsion per DMS-4640, “Chemical Admixtures for Concrete”) suitable for producing polymer-modified concrete or mortar. Do not allow latex to freeze.
- D. Reinforcing Steel.** Provide reinforcing steel conforming to Item 440, “Reinforcing Steel.”
- E. Expansion Joint Material.** Provide materials that conform to the requirements of DMS-6310, “Joint Sealants and Fillers”:
 - Provide preformed fiber expansion joint material that conforms to the dimensions shown on the plans. Provide preformed bituminous fiber material unless otherwise specified.
 - Provide a Class 4, 5, or 7 low-modulus silicone sealant unless otherwise directed.
 - Provide asphalt board that conforms to dimensions shown on the plans.
 - Provide re-bonded neoprene filler that conforms to the dimensions shown on the plans.
- F. Waterstop.** Provide rubber or polyvinyl chloride (PVC) waterstops that conform to DMS-6160, “Waterstops, Nylon Reinforced Neoprene Sheet, and Elastomeric Pads,” unless otherwise shown on the plans.
- G. Evaporation Retardants.** Provide evaporation retardants that conform to the requirements of DMS-4650, “Hydraulic Cement Concrete Curing Materials and Evaporation Retardants.”
- H. Curing Materials.** Provide membrane curing compounds that conform to the requirements of DMS-4650, “Hydraulic Cement Concrete Curing Materials and Evaporation Retardants.”

Provide cotton mats that consist of a filling material of cotton “bat” or “bats” (at least 12 oz. per square yard) completely covered with unsized cloth (at least 6 oz. per square yard) stitched longitudinally with continuous parallel rows of stitching spaced at less than 4 in., or tuft both longitudinally and transversely at intervals less than 3 in. Provide cotton mats that are free from tears and in good general condition. Provide a flap at least 6 in. wide consisting of 2 thicknesses of the covering and extending along 1 side of the mat.

Provide polyethylene sheeting that is at least 4 mils thick and free from visible defects. Provide only clear or opaque white sheeting when the ambient temperature during curing exceeds 60°F or when applicable to control temperature during mass pours.

Provide burlap-polyethylene mats made from burlap impregnated on 1 side with a film of opaque white pigmented polyethylene, free from visible defects. Provide laminated mats that have at least 1 layer of an impervious material such as polyethylene, vinyl plastic, or other acceptable material (either as a solid sheet or impregnated into another fabric) and are free of visible defects.

- I. **Epoxy.** Unless otherwise specified, provide epoxy materials that conform to DMS-6100, “Epoxy and Adhesives.”

420.3. Equipment.

- A. **Fogging Equipment.** Use fogging equipment that can apply water in a fine mist, not a spray. Produce the fog using equipment that pumps water or water and air under high pressure through a suitable atomizing nozzle. Use hand-held mechanical equipment portable enough to use in the direction of any prevailing wind and adaptable for intermittent use to prevent excessive wetting of the concrete.
- B. **Transporting and Placing Equipment.** Use appropriate transporting and placing equipment such as buckets, chutes, buggies, belt conveyors, pumps, or other equipment as necessary. Do not transport or convey concrete through equipment made of aluminum. Use carts with pneumatic tires for carting or wheeling concrete over newly placed slabs.

Use tremies to control the fall of concrete or for underwater placement. Use tremies that are watertight and of large enough diameter to allow the placement of the concrete but less than 14 in. in diameter. For underwater placements, construct the tremie so that the bottom can be sealed and opened once the tremie has been fully charged with concrete.

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Use pumps with lines at least 5 in. I.D. where Grade 2 or smaller coarse aggregate is used, and at least 8 in. I.D. for Grade 1 coarse aggregate.

- C. **Vibrators.** Use immersion-type vibrators for consolidation of concrete. Provide at least 1 standby vibrator for emergency use.
- D. **Screeds and Work Bridges for Bridge Slabs.** For bridge slabs use a self-propelled transverse screed or a mechanical longitudinal screed. Use transverse screeds that are able to follow the skew of the bridge for skews greater than 15° unless otherwise approved. Equip transverse screeds with a pan float. Manually operated screeding equipment may be used if approved for top slabs of culverts, small placements, or unusual conditions. Use screeds that are rigid and heavy enough to hold true to shape and have sufficient adjustments to provide for the required camber or section. Equip the screeds, except those of the roller drum type, with metal cutting edges.

For bridge slabs, use sufficient work bridges for finishing operations. Mount a carpet drag to a work bridge or a moveable support system that can vary the area of carpet in contact with the concrete. Use carpet pieces long enough to cover the entire width of the placement. Splice or overlap the carpet as necessary. Ensure that enough carpet is in contact longitudinally with the concrete being placed to provide the desired surface finish. Use artificial grass-type carpeting having a molded polyethylene pile face with a blade length between 5/8 and 1 in. and with a minimum weight of 70 oz. per square yard. Ensure that the carpet has a strong, durable backing not subject to rot and that the facing is adequately bonded to the backing to withstand the intended use. A burlap drag, attached to the pan float on a transverse screed, may be used instead of the carpet drag.

- E. **Temperature Recording Equipment.** For mass concrete operations or as otherwise specified, use strip chart temperature recording devices, recording maturity meters in accordance with Tex-426-A, or other approved devices that are accurate to within $\pm 2^{\circ}\text{F}$ within the range of 32 to 212°F.
- F. **Artificial Heating Equipment.** Use artificial heating equipment as necessary for maintaining the concrete temperatures as specified in Section 420.4.G.11, "Placing Concrete in Cold Weather."
- G. **Sawing Equipment.** Use sawing equipment capable of cutting grooves in completed bridge slabs and top slabs of direct-traffic culverts. Provide grooves that are 1/8 to 3/16 in. deep and nominally 1/8 in. wide. Groove spacing may range from 5/8 to 1 in. Use sawing

equipment capable of cutting grooves in hardened concrete to within 18 in. of the barrier rail or curb.

- H. Spraying Equipment.** Use mechanically powered pressure sprayers, either air or airless, with appropriate atomizing nozzles for the application of membrane curing. Mechanically driven spraying equipment, adaptable to the rail system used by the screeds, may be used for applying membrane curing to bridge slabs. If approved, use hand-pressurized spray equipment equipped with 2 or 3 fan-spray nozzles. Ensure that the spray from each nozzle overlaps the spray from adjacent nozzles by approximately 50%.
- I. Concrete Testing Equipment.** Provide testing equipment for use by the Engineer in accordance with Section 421.3.C, "Testing Equipment."

420.4. Construction. Before starting work, obtain approval for proposed construction methods. Approval of construction methods and equipment does not relieve the Contractor's responsibility for safety or correctness of methods, adequacy of equipment, or completion of work in full accordance with the Contract.

Unless otherwise shown on the plans, it is the Contractor's option to perform testing on structural concrete (structural classes of concrete are identified in Table 5 of Section 421.4.A, "Classification and Mix Design") to determine the in-situ strength to address the schedule restrictions in Section 420.4.A, "Schedule Restrictions." The Engineer may require the Contractor to perform this testing for concrete placed in cold weather. For Contractor-performed testing, make enough test specimens to ensure that strength requirements are met for the operations listed in Section 420.4.A. Make at least 1 set of test specimens for each element cast each day. Cure these specimens under the same conditions as the portion of the structure involved for all stages of construction. Ensure safe handling, curing, and storage of all test specimens. Provide testing personnel, and sample and test the hardened concrete in accordance with Section 421.4.G, "Sampling and Testing of Concrete." The maturity method, Tex-426-A, may be used for in-situ strength determination for schedule restrictions if approved. Coring will not be allowed for in-situ strength determination for schedule restrictions. Provide the Engineer the opportunity to witness all testing operations. Report all test results to the Engineer.

If the Contractor does not wish to perform schedule restriction testing, the Engineer's 7-day lab-cured tests, performed in accordance with Section 421.4.G.5, "Adequacy and Acceptance of Concrete," will be used

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for schedule restriction determinations. The Engineer may require additional time for strength gain to account for field curing conditions such as cold weather.

A. Schedule Restrictions. Unless otherwise shown on the plans, construct and open completed structures to traffic with the following limitations:

- 1. Setting Forms.** Attain at least 2,500 psi compressive strength before erecting forms on concrete footings supported by piling or drilled shafts, or on individual drilled shafts. Erect forms on spread footings and culvert footings after the footing concrete has aged at least 2 curing days as defined in Section 420.4.J, "Curing Concrete." Place concrete only after the forms and reinforcing steel have been inspected by the Engineer.

Support tie beam or cap forms by falsework on previously placed tie beams only if the tie beam concrete has attained a compressive strength of 2,500 psi and the member is properly supported to eliminate stresses not provided for in the design. Maintain curing as required until completion of the curing period.

Place superstructure forms or falsework on the substructure only if the substructure concrete has attained a compressive strength of 3,000 psi.

- 2. Removal of Forms and Falsework.** Keep in place weight-supporting forms and falsework for bridge components and culvert slabs until the concrete has attained a compressive strength of 2,500 psi in accordance with Section 420.4.K, "Removal of Forms and Falsework." Keep all forms for mass placements defined in Section 420.4.G.14, "Mass Placements," in place for 4 days following concrete placement.
- 3. Placement of Superstructure Members.** Do not place superstructure members before the substructure concrete has attained a compressive strength of 3,000 psi.
- 4. Longitudinal Screeding of Bridge Slabs.** Place a longitudinal screed directly on previously placed concrete slabs to check and grade an adjacent slab only after the previously placed slab has aged at least 24 hr. Place and screed the concrete after the previously placed slabs have aged at least 48 hr. Maintain curing of the previously placed slabs during placement.
- 5. Staged Placement of Bridge Slabs on Continuous Steel Units.** When staged placement of a slab is required, ensure that the previously placed concrete attains a compressive strength of

3,000 psi before placing the next stage placement. Multiple stages may be placed in a single day if approved.

6. **Storage of Materials on the Structure.** Obtain approval to store materials on completed portions of a structure once a compressive strength of 3,000 psi has been attained. Maintain proper curing if materials will be stored on structures before completion of curing.
7. **Placement of Equipment and Machinery.** Do not place erection equipment or machinery on the structure until the concrete has attained the design strength specified in Section 421.4.A, "Classification and Mix Design," unless otherwise approved.
8. **Carting of Concrete.** Once the concrete has attained a compressive strength of 3,000 psi, it may be carted, wheeled, or pumped over completed slabs. Maintain curing during these operations.
9. **Placing Bridge Rails.** Reinforcing steel and concrete for bridge rails may be placed on bridge slabs once the slab concrete has attained a compressive strength of 3,000 psi. If slipforming methods are used for railing concrete, ensure the slab concrete has attained its design strength specified in Section 421.4.A, "Classification and Mix Design," before placing railing concrete.
10. **Opening to Construction Traffic.** Bridges and direct-traffic culverts may be opened to all construction traffic when the design strength specified in Section 421.4.A, "Classification and Mix Design," has been attained if curing is maintained.
11. **Opening to Full Traffic.** Bridges and direct-traffic culverts may be opened to the traveling public when the design strength specified in Section 421.4.A, "Classification and Mix Design," has been attained for all structural elements including railing subject to impact from traffic, when curing has been completed for all slabs, and when the concrete surface treatment has been applied in accordance with Item 428, "Concrete Surface Treatment." Obtain approval before opening bridges and direct-traffic culverts to the traveling public. Other noncritical structural and nonstructural concrete may be opened for service upon the completion of curing unless otherwise specified or directed.
12. **Post-Tensioned Construction.** For structural elements designed to be post-tensioned ensure that strength requirements on the plans are met for stressing and staged loading of structural elements.

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13. Backfilling. Backfill in accordance with Section 400.3.C, “Backfill.”

- B. Plans for Falsework and Forms.** Submit 2 copies of plans for falsework and forms for piers, superstructure spans over 20 ft. long, bracing systems for girders when the overhang exceeds 3 ft. 6 in., and bridge widening details. Submit similar plans for other units of the structure as directed. Show all essential details of proposed forms, falsework, and bracing. Have a licensed professional engineer design, seal, and sign these plans. Department approval is not required, but the Department reserves the right to request modifications to the plans. The Contractor is responsible for the adequacy of these plans.
- C. Falsework.** Design and construct falsework to carry the maximum anticipated loads safely, including wind loads, and to provide the necessary rigidity. Submit details in accordance with Section 420.4.B, “Plans for Falsework and Forms.”

Design job-fabricated falsework assuming a weight of 150 pcf for concrete, and include a liveload allowance of 50 psf of horizontal surface of the form. Do not exceed 125% of the allowable stresses used by the Department for the design of structures.

For commercially produced structural units used in falsework, do not exceed the manufacturer’s maximum allowable working loads for moment and shear or end reaction. Include a liveload allowance of 35 psf of horizontal form surface in determining the maximum allowable working load for commercially produced structural units.

Provide timber that is sound, in good condition, and free from defects that would impair its strength. Provide timber that meets or exceeds the species, size, and grade requirements in the submitted falsework plans.

Provide wedges made of hardwood or metal in pairs to adjust falsework to desired elevations to ensure even bearing. Do not use wedges to compensate for incorrectly cut bearing surfaces.

Use sills or grillages that are large enough to support the superimposed load without settlement. Take precautions to prevent settling of the supporting material unless the sills or grillages are founded on solid rock, shale, or other hard materials.

Place falsework that cannot be founded on a satisfactory spread footing on piling or drilled shafts with enough bearing capacity to support the superimposed load without settlement. Drive falsework piling to the required resistance determined by the applicable formula in Item 404,

“Driving Piling.” Design drilled shafts for falsework to carry the superimposed load using both skin friction and point bearing.

Weld in conformance with Item 448, “Structural Field Welding.”

Securely brace each falsework bent to provide the stiffness required, and securely fasten the bracing to each pile or column it crosses.

Remove falsework when it is no longer required or as indicated on the submitted falsework plan. Pull or cut off foundations for falsework at least 2 ft. below finished ground level. Completely remove falsework, piling, or drilled shafts in a stream, lake, or bay to the approved limits to prevent obstruction to the waterway.

D. Forms. Submit formwork plans in accordance with Section 420.4.B, “Plans for Falsework and Forms.”

1. General. Except where otherwise specified or permitted, provide forms of either timber or metal.

Design forms for the pressure exerted by a liquid weighing 150 pcf. Take the rate of concrete placement into consideration in determining the depth of the equivalent liquid. Include a liveload allowance of 50 psf of horizontal surface for job-fabricated forms. Do not exceed 125% of the allowable stresses used by the Department for the design of structures.

For commercially produced structural units used for forms, do not exceed the manufacturer’s maximum allowable working loads for moment and shear or end reaction. Include a liveload allowance of 35 psf of horizontal form surface in determining the maximum allowable working load for commercially produced structural units.

Provide steel forms for round columns unless otherwise approved. Refer to Item 427, “Surface Finishes for Concrete,” for additional requirements for off-the-form finishes.

Provide commercial form liners for imprinting a pattern or texture on the concrete surface as shown on the plans and specified in Section 427.4.B.2.d, “Form Liner Finish.”

Provide forming systems that are practically mortar-tight, rigidly braced, and strong enough to prevent bulging between supports, and maintain them to the proper line and grade during concrete placement. Maintain forms in a manner that prevents warping and shrinkage. Do not allow offsets at form joints to exceed 1/16 in.

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For forms to be left in place, use only material that is inert, nonbiodegradable, and nonabsorptive.

Attachment of forms or screed supports for bridge slabs to steel I-beams or girders may be by welding subject to the following requirements:

- Do not weld to tension flanges or to areas indicated on the plans.
- Weld in accordance with Item 448, "Structural Field Welding."

Take into account:

- deflections due to cast-in-place slab concrete and railing shown in the dead load deflection diagram in the setting of slab forms,
- differential beam or girder deflections due to skew angles and the use of certain stay-in-place slab forming systems, and
- deflection of the forming system due to the wet concrete.

For bridge approach slabs, securely stake forms to line and grade and maintain in position. Rigidly attach inside forms for curbs to the outside forms.

Construct all forms to permit their removal without marring or damaging the concrete. Clean all forms and footing areas of any extraneous matter before placing concrete. Provide openings in forms if needed for the removal of laitance or foreign matter

Treat the facing of all forms with bond-breaking coating of composition that will not discolor or injuriously affect the concrete surface. Take care to prevent coating of the reinforcing steel.

Complete all preparatory work before requesting permission to place concrete.

If the forms show signs of bulging or sagging at any stage of the placement, cease placement and remove the portion of the concrete causing this condition immediately if necessary. Reset the forms and securely brace them against further movement before continuing the placement.

2. **Timber Forms.** Provide properly seasoned good-quality lumber that is free from imperfections that would affect its strength or impair the finished surface of the concrete. Provide timber or lumber that meets or exceeds the requirements for species and grade in the submitted formwork plans.

Maintain forms or form lumber that will be reused so that it stays clean and in good condition. Do not use any lumber that is split, warped, bulged, or marred or that has defects that will produce inferior work, and promptly remove such lumber from the work.

Provide form lining for all formed surfaces except:

- the inside of culvert barrels, inlets, manholes, and box girders;
- the bottom of bridge slabs between beams or girders;
- surfaces that are subsequently covered by backfill material or are completely enclosed; and
- any surface formed by a single finished board or by plywood.

Provide form lining of an approved type such as masonite or plywood. Do not provide thin membrane sheeting such as polyethylene sheets for form lining.

Use plywood at least 3/4 in. thick. Place the grain of the face plies on plywood forms parallel to the span between the supporting studs or joists unless otherwise indicated on the submitted form drawings.

Use plywood for forming surfaces that remain exposed that meets the requirements for B-B Plyform Class I or Class II Exterior of the U.S. Department of Commerce Voluntary Product Standard PS 1.

Space studs and joists so that the facing form material remains in true alignment under the imposed loads.

Space wales closely enough to hold forms securely to the designated lines, scabbed at least 4 ft. on each side of joints to provide continuity. Place a row of wales near the bottom of each placement.

Place facing material with parallel and square joints, securely fastened to supporting studs.

For surfaces exposed to view and receiving only an ordinary surface finish as defined in Section 420.4.M, "Ordinary Surface Finish," place forms with the form panels symmetrical (long dimensions set in the same direction). Make horizontal joints continuous.

Make molding for chamfer strips or other uses of materials of a grade that will not split when nailed and that can be maintained to a true line without warping. Dress wood molding on all faces. Unless otherwise shown on the plans, fill forms at all sharp corners

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and edges with triangular chamfer strips measuring 3/4 in. on the sides.

To hold forms in place, use metal form ties of an approved type or a satisfactory substitute of a type that permits ease of removal of the metal. Cut back wire ties at least 1/2 in. from the face of the concrete.

Use devices to hold metal ties in place that are able to develop the strength of the tie and adjust to allow for proper alignment.

Entirely remove metal and wooden spreaders that separate the forms as the concrete is being placed.

Provide adequate clean-out openings for narrow walls and other locations where access to the bottom of the forms is not readily attainable.

3. **Metal Forms.** Requirements for timber forms regarding design, mortar-tightness, filleted corners, beveled projections, bracing, alignment, removal, reuse, and wetting also apply to metal forms except that metal forms do not require lining unless specifically noted on the plans.

Use form metal thick enough to maintain the true shape without warping or bulging. Countersink all bolt and rivet heads on the facing sides. Design clamps, pins, or other connecting devices to hold the forms rigidly together and to allow removal without damage to the concrete. Use metal forms that present a smooth surface and that line up properly. Keep metal free from rust, grease, and other foreign materials.

4. **Form Supports for Overhang Slabs.** Form supports that transmit a horizontal force to a steel girder or beam or to a prestressed concrete beam are permitted provided a satisfactory structural analysis has been made of the effect on the girder or beam as indicated in the submitted formwork plans.

When overhang brackets are used on prestressed concrete beam spans with slab overhangs not exceeding 3 ft 6 in., use beam bracing as indicated in the plans. For spans with overhangs exceeding this amount, use additional support for the outside beams regardless of the type of beam used. Submit details of the proposed bracing system in accordance with Section 420.4.B, "Plans for Falsework and Forms."

Punch or drill holes full size in the webs of steel members for support of overhang brackets, or torch-cut them to 1/4 in. under

size and ream them full size. Do not burn the holes full size. Leave the holes open unless otherwise shown on the plans. Never fill the holes by welding.

- E. **Drains.** Install and construct weep holes and roadway drains as shown on the plans.

- F. **Placing Reinforcement.** Place reinforcement as provided in Item 440, "Reinforcing Steel." Do not weld reinforcing steel supports to I-beams or girders or to reinforcing steel except where shown on the plans.

Place post-tensioning ducts in accordance with the approved prestressing details and in accordance with Item 426, "Prestressing." Keep ducts free of obstructions until all post-tensioning operations are complete.

- G. **Placing Concrete.** Give the Engineer sufficient advance notice before placing concrete in any unit of the structure to permit the inspection of forms, reinforcing steel placement, and other preparations.

Follow the sequence of placing concrete shown on the plans or specified.

Do not place concrete when impending weather conditions would impair the quality of the finished work. If conditions of wind, humidity, and temperature are such that concrete cannot be placed without the potential for shrinkage cracking, place concrete in early morning or at night or adjust the placement schedule for more favorable weather. Consult the evaporation rate nomograph in the Portland Cement Association's *Design and Control of Concrete Mixtures* for shrinkage cracking potential. When mixing, placing, and finishing concrete in non-daylight hours, adequately illuminate the entire placement site as approved.

If changes in weather conditions require protective measures after work starts, furnish adequate shelter to protect the concrete against damage from rainfall or from freezing temperatures as outlined in this Item. Continue operations during rainfall only if approved. Use protective coverings for the material stockpiles. Cover aggregate stockpiles only to the extent necessary to control the moisture conditions in the aggregates.

Allow at least 1 curing day after the concrete has achieved initial set before placing strain on projecting reinforcement to prevent damage to the concrete.

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1. **Placing Temperature.** Place concrete according to the following temperature limits for the classes of concrete defined in Section 421.4.A, “Classification and Mix Design”:
 - Place Class C, F, H, K, or SS concrete only when its temperature at time of placement is between 50 and 95°F. Increase the minimum placement temperature to 60°F if ground-granulated blast furnace (GGBF) slag is used in the concrete.
 - When used in a bridge slab or in the top slab of a direct-traffic culvert, place Class CO, DC, or S concrete only when its temperature at the time of placement is between 50 and 85°F. Increase the minimum placement temperature to 60°F if GGBF slag is used in the concrete. The maximum temperature increases to 95°F if these classes are used for other applications.
 - Place Class A, B, and D concrete only when its temperature at the time of placement is greater than 50°F.
 - Place mass concrete, defined by Section 420.4.G.14, “Mass Placements,” only when its temperature at the time of placement is between 50 and 75°F.
2. **Transporting Time.** Place concrete delivered in agitating trucks within 60 min. after batching. Place concrete delivered in non-agitating equipment within 45 min. after batching. Revise the concrete mix design as necessary for hot weather or other conditions that contribute to quick setting of the concrete. Submit for approval a plan to demonstrate that these time limitations can be extended while ensuring the concrete can be properly placed, consolidated, and finished without the use of additional water.
3. **Workability of Concrete.** Place concrete with a slump as specified in Section 421.4.A.5, “Slump.” Concrete that exceeds the maximum slump will be rejected. Water may be added to the concrete before discharging any concrete from the truck to adjust for low slump provided that the maximum mix design water–cement ratio is not exceeded. After introduction of any additional water or chemical admixtures, mix concrete in accordance with Section 421.4.E, “Mixing and Delivering Concrete.” Do not add water or chemical admixtures after any concrete has been discharged.
4. **Transporting Concrete.** Use a method and equipment capable of maintaining the rate of placement shown on the plans or required by this Item to transport concrete to the forms. Transport concrete

by buckets, chutes, buggies, belt conveyors, pumps, or other methods.

Protect concrete transported by conveyors from sun and wind to prevent loss of slump and workability. Shade or wrap with wet burlap pipes through which concrete is pumped as necessary to prevent loss of slump and workability.

Arrange and use chutes, troughs, conveyors, or pipes so that the concrete ingredients will not be separated. When necessary to prevent segregation, terminate such equipment in vertical downspouts. Extend open troughs and chutes, if necessary, down inside the forms or through holes left in the forms.

Keep all transporting equipment clean and free from hardened concrete coatings. Discharge water used for cleaning clear of the concrete.

5. **Preparation of Surfaces.** Thoroughly wet all forms, prestressed concrete panels, T-beams, and concrete box beams on which concrete is to be placed before placing concrete on them. Remove any remaining puddles of excess water before placing concrete. Provide surfaces that are in a moist, saturated surface-dry condition when concrete is placed on them.

Ensure that the subgrade or foundation is moist before placing concrete for bridge approach slabs or other concrete placed on grade. Lightly sprinkle the subgrade if dry.

6. **Expansion Joints.** Construct joints and devices to provide for expansion and contraction in accordance with plan details and the requirements of this Section and Item 454, "Bridge Expansion Joints."

Prevent bridging of concrete or mortar around expansion joint material in bearings and expansion joints.

Use forms adaptable to loosening or early removal in construction of all open joints and joints to be filled with expansion joint material. To avoid expansion or contraction damage to the adjacent concrete, loosen these forms as soon as possible after final concrete set to permit free movement of the span without requiring full form removal.

When the plans show a Type A joint, provide preformed fiber joint material in the vertical joints of the roadway slab, curb, median, or sidewalk, and fill the top 1 in. with the specified joint sealing material unless noted otherwise. Install the sealer in accordance

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with Item 438, “Cleaning and Sealing Joints and Cracks (Rigid Pavement and Bridge Decks),” and the manufacturer’s recommendations.

Use light wire or nails to anchor any preformed fiber joint material to the concrete on 1 side of the joint.

Ensure that finished joints conform to the plan details with the concrete sections completely separated by the specified opening or joint material.

Remove all concrete within the joint opening soon after form removal and again where necessary after surface finishing to ensure full effectiveness of the expansion joint.

7. **Construction Joints.** A construction joint is the joint formed by placing plastic concrete in direct contact with concrete that has attained its initial set. Monolithic placement means that the manner and sequence of concrete placing does not create a construction joint.

Make construction joints of the type and at the locations shown on the plans. Do not make joints in bridge slabs not shown on the plans unless approved. Additional joints in other members are not permitted without approval. Place authorized additional joints using details equivalent to those shown on the plans for joints in similar locations.

Unless otherwise required, make construction joints square and normal to the forms. Use bulkheads in the forms for all vertical joints.

Thoroughly roughen the top surface of a concrete placement terminating at a horizontal construction joint as soon as practical after initial set is attained.

Thoroughly clean the hardened concrete surface of all loose material, laitance, dirt, and foreign matter, and saturate it with water. Remove all free water and moisten the surface before concrete or bonding grout is placed against it.

Draw forms tight against the existing concrete to avoid mortar loss and offsets at joints.

Coat the joint surface with bonding mortar, grout, epoxy, or other material as indicated in the plans or other Items. Provide Type V epoxy per DMS-6100, “Epoxies and Adhesives,” for bonding fresh concrete to hardened concrete. Place the bonding epoxy on a clean,

dry surface, and place the fresh concrete while the epoxy is still tacky. Place bonding mortar or grout on a surface that is saturated surface-dry, and place the concrete before the bonding mortar or grout dries. Place other bonding agents in accordance with the manufacturer's recommendations.

8. **Handling and Placing.** Minimize segregation of the concrete and displacement of the reinforcement when handling and placing concrete. Produce a uniform dense compact mass.

Do not allow concrete to free-fall more than 5 ft. except in the case of drilled shafts, thin walls such as in culverts, or as allowed by other Items. Remove any hardened concrete splatter ahead of the plastic concrete.

Fill each part of the forms by depositing concrete as near its final position as possible. Do not deposit large quantities at 1 point and run or work the concrete along the forms.

Deposit concrete in the forms in layers of suitable depth but not more than 36 in. deep unless otherwise permitted.

Avoid cold joints in a monolithic placement. Sequence successive layers or adjacent portions of concrete so that they can be vibrated into a homogeneous mass with the previously placed concrete before it sets. When re-vibration of the concrete is shown on the plans, allow at most 1 hr. to elapse between adjacent or successive placements of concrete except as otherwise allowed by an approved placing procedure. This time limit may be extended by 1/2 hr. if the concrete contains at least a normal dosage of retarding admixture.

Use an approved retarding agent to control stress cracks and cold joints in placements where differential settlement and setting time may induce cracking.

9. **Consolidation.** Carefully consolidate concrete and flush mortar to the form surfaces with immersion type vibrators. Do not use vibrators that operate by attachment to forms or reinforcement except where approved on steel forms.

Vibrate the concrete immediately after deposit. Systematically space points of vibration to ensure complete consolidation and thorough working of the concrete around the reinforcement, embedded fixtures, and into the corners and angles of the forms. Insert the vibrator vertically where possible except for slabs where it may be inserted in a sloping or horizontal position. Vibrate the

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entire depth of each lift, allowing the vibrator to penetrate several inches into the preceding lift. Do not use the vibrator to move the concrete to other locations in the forms. Do not drag the vibrator through the concrete. Thoroughly consolidate concrete along construction joints by operating the vibrator along and close to but not against the joint surface. Continue the vibration until the concrete surrounding reinforcements and fixtures is completely consolidated. Hand-spade or rod the concrete if necessary to ensure flushing of mortar to the surface of all forms.

- 10. Installation of Dowels and Anchor Bolts.** Install dowels and anchor bolts by casting them in-place or by grouting with grout, epoxy, or epoxy mortar unless noted otherwise. Form or drill holes for grouting.

Drill holes for anchor bolts to accommodate the bolt embedment required by the plans. Make holes for dowels at least 12 in. deep unless otherwise shown on the plans. When using grout or epoxy mortar, make the diameter of the hole at least twice the dowel or bolt diameter, but the hole need not exceed the dowel or bolt diameter plus 1-1/2 in. When using epoxy, make the hole diameter 1/16 to 1/4 in. greater than the dowel or bolt diameter.

Thoroughly clean holes of all loose material, oil, grease, or other bond-breaking substance, and blow them clean with filtered compressed air. Ensure that holes are in a surface dry condition when epoxy type material is used and in a surface moist condition when hydraulic cement grout is used. Develop and demonstrate for approval a procedure for cleaning and preparing the holes for installation of the dowels and anchor bolts. Completely fill the void between the hole and dowel or bolt with grouting material. Follow exactly the requirements for cleaning outlined in the product specifications for prepackaged systems.

For cast-in-place or grouted systems, provide hydraulic cement grout in accordance with Section 421.2.F, "Mortar and Grout," epoxy, epoxy mortar, or other prepackaged grouts as approved. Provide a Type III epoxy per DMS-6100, "Epoxy and Adhesives," when neat epoxy is used for anchor bolts or dowels. Provide Type VIII epoxy per DMS-6100 when an epoxy grout is used. Provide grout, epoxy, or epoxy mortar as the binding agent unless otherwise indicated on the plans.

Provide other anchor systems as required in the plans.

- 11. Placing Concrete in Cold Weather.** Protect concrete placed under weather conditions where weather may adversely affect results. Permission given by the Engineer for placing during cold weather does not relieve the Contractor of responsibility for producing concrete equal in quality to that placed under normal conditions. If concrete placed under poor conditions is unsatisfactory, remove and replace it as directed at Contractor's expense.

Do not place concrete in contact with any material coated with frost or having a temperature of 32°F or lower. Do not place concrete when the ambient temperature in the shade is below 40°F and falling unless approved. Concrete may be placed when the ambient temperature in the shade is 35°F and rising or above 40°F.

Provide and install recording thermometers, maturity meters, or other suitable temperature measuring devices to verify that all concrete is effectively protected as follows:

- Maintain the temperature of the top surface of bridge slabs and top slabs of direct-traffic culverts at 50°F or above for 72 hr. from the time of placement and above 40°F for an additional 72 hr.
- Maintain the temperature at all surfaces of concrete in bents, piers, culvert walls, retaining walls, parapets, wingwalls, bottoms of bridge slab or culvert top slabs, and other similar formed concrete at 40°F or above for 72 hr. from the time of placement.
- Maintain the temperature of all other concrete, including the bottom slabs (footings) of culverts, placed on or in the ground above 32°F for 72 hr. from the time of placement.

Use additional covering, insulated forms, or other means and, if necessary, supplement the covering with artificial heating. Avoid applying heat directly to concrete surfaces. Cure as specified in Section 420.4.J, "Curing Concrete," during this period until all requirements for curing have been satisfied.

When impending weather conditions indicate the possible need for temperature protection, have on hand all necessary heating and covering material, ready for use, before permission is granted to begin placement.

- 12. Placing Concrete in Hot Weather.** Use an approved retarding agent in all concrete for superstructures and top slabs of direct-

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traffic culverts, except concrete containing GGBF slag, when the temperature of the air is above 85°F unless otherwise directed.

Keep the concrete at or below the maximum temperature at time of placement as specified in Section 420.4.G.1, "Placing Temperature." Sprinkle and shade aggregate stockpiles or use ice, liquid nitrogen systems, or other approved methods as necessary to control the concrete temperature.

- 13. Placing Concrete in Water.** Deposit concrete in water only when shown on the plans or with approval. Make forms or cofferdams tight enough to prevent any water current passing through the space in which the concrete is being deposited. Do not pump water during the concrete placing or until the concrete has set for at least 36 hr.

Place the concrete with a tremie or pump, or use another approved method, and do not allow it to fall freely through the water or disturb it after it is placed. Keep the concrete surface approximately level during placement.

Support the tremie or operate the pump so that it can be easily moved horizontally to cover all the work area and vertically to control the concrete flow. Submerge the lower end of the tremie or pump hose in the concrete at all times. Use continuous placing operations until the work is complete.

For concrete to be placed under water, design the concrete mix in accordance with Item 421, "Hydraulic Cement Concrete," with a minimum cement content of 650 lb. per cubic yard. Include an anti-washout admixture in the mix design as necessary to produce a satisfactory finished product.

- 14. Mass Placements.** Mass placements are defined as placements with a least dimension greater than or equal to 5 ft., or designated on the plans. For monolithic mass placements, develop and obtain approval for a plan to ensure the following during the heat dissipation period:

- the temperature differential between the central core of the placement and the exposed concrete surface does not exceed 35°F and
- the temperature at the central core of the placement does not exceed 160°F.

Base this plan on the equations given in the Portland Cement Association's *Design and Control of Concrete Mixtures*. Cease all

mass placement operations and revise the plan as necessary if either of the above limitations is exceeded.

Include a combination of the following elements in this plan:

- selection of concrete ingredients including aggregates, gradation, and cement types, to minimize heat of hydration;
- use of ice or other concrete cooling ingredients;
- use of liquid nitrogen dosing systems;
- controlling rate or time of concrete placement;
- use of insulation or supplemental external heat to control heat loss;
- use of supplementary cementing materials; or
- use of a cooling system to control the core temperature.

Furnish and install 2 sets of temperature recording devices, maturity meters, or other approved equivalent devices at designated locations. Use these devices to simultaneously measure the temperature of the concrete at the core and the surface.

Maintain temperature control methods for 4 days unless otherwise approved. Maturity meters may not be used to predict strength of mass concrete.

15. Placing Concrete in Foundation and Substructure. Do not place concrete in footings until the depth and character of the foundation has been inspected and permission has been given to proceed.

Placing of concrete footings upon seal concrete is permitted after the cofferdams are free from water and the seal concrete cleaned. Perform any necessary pumping or bailing during the concreting from a suitable sump located outside the forms.

Construct or adjust all temporary wales or braces inside cofferdams as the work proceeds to prevent unauthorized construction joints.

When footings can be placed in a dry excavation without the use of cofferdams, omit forms if approved, and fill the entire excavation with concrete to the elevation of the top of footing.

Place concrete in columns monolithically between construction joints unless otherwise directed. Columns and caps or tie beams supported on them may be placed in the same operation or separately. If placed in the same operation, allow for settlement and shrinkage of the column concrete by placing it to the lower level of the cap or tie beam, and delay placement between 1 and 2 hr. before proceeding with the cap or tie beam placement.

- 16. Placing Concrete in Box Culverts.** Where the top slab and walls are placed monolithically in culverts more than 4 ft. in clear height, allow between 1 and 2 hr. to elapse before placing the top slab to allow for settlement and shrinkage in the wall concrete.

Accurately finish the footing slab at the proper time to provide a smooth uniform surface. Finish top slabs that carry direct-traffic as specified in this Item. Give top slabs of fill type culverts a float finish.

- 17. Placing Concrete in Superstructure.** Unless otherwise shown on the plans, place simple span bridge slabs without transverse construction joints by using either a self-propelled transverse finishing machine or a mechanical longitudinal screed. For small placements or for unusual conditions such as narrow widening, variable cross-slopes, or transitions, use of manually operated screeding equipment may be permitted. Support the screed adequately on a header or rail system stable enough to withstand the longitudinal or lateral thrust of the equipment. Adjust the profile grade line as necessary to account for variations in beam camber and other factors to obtain the required slab thickness and concrete cover over the slab reinforcement. Set beams and verify their surface elevations in a sufficient number of spans so that when adjustment is necessary, the profile grade line can be adjusted over suitable increments to produce a smooth riding surface. Take dead load deflection into account in setting the grades of headers and rail systems. Use construction joints, when required or permitted for slab placements on steel or prestressed concrete beams, as shown on the plans. Before placing concrete on steel girder or truss spans, release falsework under the spans and swing the spans free on their permanent supports.

Make 1 or more passes with the screed over the bridge slab segment before placing concrete on it to ensure proper operation and maintenance of grades and clearances. Use an approved system of checking to detect any vertical movement of the forms or falsework. Maintain forms for the bottom surface of concrete slabs, girders, and overhangs to the required vertical alignment during concrete placing.

Fog unformed surfaces of slab concrete in bridge slabs and in top slabs of direct-traffic culverts from the time of initial strikeoff of the concrete until finishing is completed and required interim curing is in place. Do not use fogging as a means to add finishing

water, and do not work moisture from the fog spray into the fresh concrete.

For simple spans, retard the concrete only if necessary to complete finishing operations or as required by this Section. When filling curb forms, bring the top of curb and sidewalk section to the correct camber and alignment, and finish them as described in this Item.

- a. **Transverse Screeding.** Install rails for transverse finishing machines that are supported from the beams or girders so that the supports may be removed without damage to the slab. Prevent bonding between removable supports and the concrete in an acceptable manner. Do not allow rail support parts that remain embedded in the slab to project above the upper mat of reinforcing steel. Rail or screed supports attached to I-beams or girders are subject to the requirements of this Item. Unless otherwise shown on the plans, for transverse screeding the minimum rate of concrete placement is 30 linear feet of bridge slab per hour. Deposit concrete parallel to the skew of the bridge so that all girders are loaded uniformly along their length. Deposit slab concrete between the exterior beam and the adjacent beam before placing concrete in the overhang portion of the slab. Furnish personnel and equipment capable of placing, finishing, and curing the slab at an acceptable rate to ensure compliance with the specifications. Place concrete in transverse strips. On profile grades greater than 1-1/2%, start placement at the lowest end.
- b. **Longitudinal Screeding.** Unless otherwise shown on the plans, use of temporary intermediate headers will be permitted for placements over 50 ft. long if the rate of placement is rapid enough to prevent a cold joint and if these headers are designed for easy removal to permit satisfactory consolidation and finish of the concrete at their locations. Deposit slab concrete between the exterior beam and the adjacent beam before placing concrete in the overhang portion of the slab. Place concrete in longitudinal strips starting at a point in the center of the segment adjacent to 1 side except as this Section indicates, and complete the strip by placing uniformly in both directions toward the ends. For spans on a profile grade of 1-1/2% or more, start placing at the lowest end. Use strips wide enough that the concrete within each strip remains plastic until placement of the adjacent strip. Where monolithic curb

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construction is specified, place the concrete in proper sequence to be monolithic with the adjacent longitudinal strips of the slabs.

- c. **Placements on Continuous Steel Units.** Unless otherwise shown on the plans, place slabs on continuous steel units in a single continuous operation without transverse construction joints using a self-propelled transverse finishing machine or a mechanical longitudinal screed. Retard the initial set of the concrete sufficiently to ensure that concrete remains plastic in at least 3 spans immediately preceding the slab being placed. Use construction joints, when required for slab placements on steel beams or girders, as shown on the plans. When staged placement of a slab is required in the plans, ensure that the previously placed concrete attains a compressive strength of 3,000 psi before placing the next stage concrete. Multiple stages may be placed in a single day if approved. Where plans permit staged placing without specifying a particular order of placement, use an approved placing sequence that will not overstress any of the supporting members.
- d. **Slab and Girder Units.** Unless otherwise shown on the plans, place girders, slab, and curbs of slab and girder spans monolithically. Fill concrete girder stems first, and place the slab concrete within the time limits specified in this Item. If using a transverse screed, place concrete in the stems for a short distance and then place the concrete in transverse strips. If using a longitudinal screed, fill the outside girder stem first, beginning at the low end or side, and continue placement in longitudinal strips.

H. **Treatment and Finishing of Horizontal Surfaces Other Than Bridge Slabs.** Strike off to grade and finish all unformed upper surfaces. Do not use mortar topping for surfaces constructed under this Section.

After the concrete has been struck off, float the surface with a suitable float. Give bridge sidewalks a wood float or broom finish, or stripe them with a brush.

Slightly slope the tops of caps and piers between bearing areas from the center toward the edge, and slope the tops of abutment and transition bent caps from the backwall to the edge, as directed, so that water drains from the surface. Give the concrete a smooth trowel finish. Construct bearing areas for steel units in accordance with

Section 441.3.K.5, "Bearing and Anchorage Devices." Give the bearing area under the expansion ends of concrete slabs and slab and girder spans a steel-trowel finish to the exact grades required. Give bearing areas under elastomeric bearing pads or nonreinforced bearing seat buildups a textured, wood float finish. Do not allow the bearing area to vary from a level plane more than 1/16 in. in all directions.

Cast bearing seat buildups or pedestals for concrete units integrally with the cap or with a construction joint. Provide a latex-based mortar, an epoxy mortar, or an approved proprietary bearing mortar for bearing seat buildups cast with a construction joint. Mix mortars in accordance with the manufacturer's recommendations. Construct pedestals of Class C concrete, reinforced as shown on the plans or as indicated in Figure 1 and Figure 2.

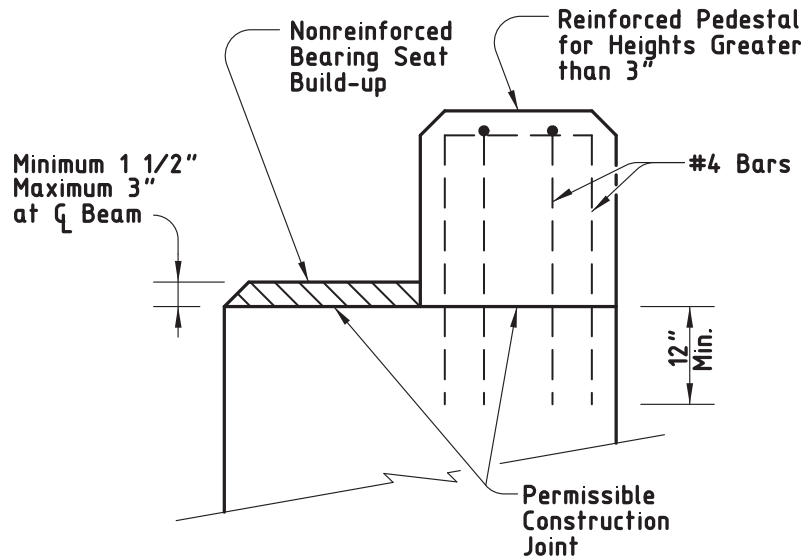


Figure 1
Section through bearing seat buildups.

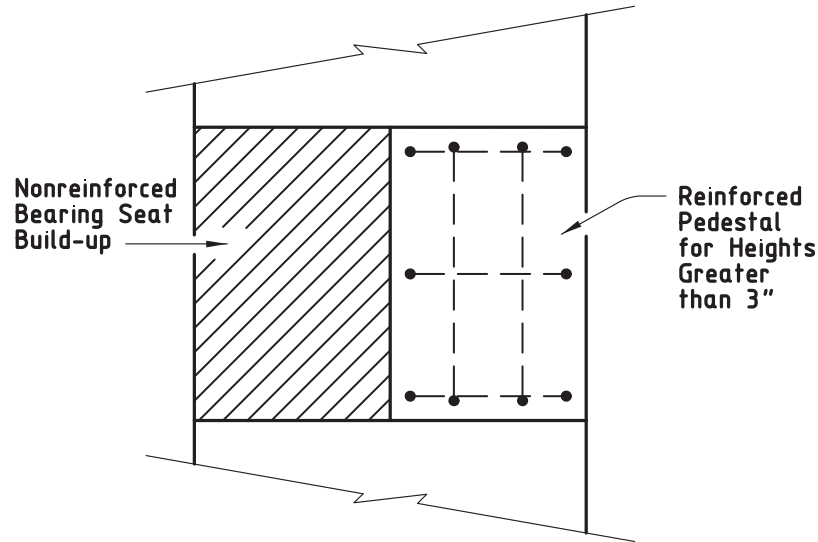


Figure 2
Plan view of bearing seat buildups.

I. Finish of Bridge Slabs. Provide camber for specified vertical curvature and transverse slopes.

For concrete flat slab and concrete slab and girder spans cast in place on falsework, provide additional camber to offset the initial and final deflections of the span as indicated in the plans. For concrete slab and girder spans using pan forms, provide camber of approximately 3/8 in. for 30-ft. spans and 1/2 in. for 40-ft. spans to offset initial and final deflections unless otherwise directed. For concrete flat slab and concrete slab and girder spans not using pan forms, when dead load deflection is not shown on the plans, provide a camber of 1/8 in. per 10 ft. of span length but no more than 1/2 in.

Provide a camber of 1/4 in. in addition to deflection for slabs without vertical curvature on steel or prestressed concrete beams.

Use work bridges or other suitable facilities to perform all finishing operations and to provide access, if necessary, for the Engineer to check measurements for slab thickness and reinforcement cover.

As soon as the concrete has been placed and vibrated in a section wide enough to permit working, level, strike off, and screed the surface, carrying a slight excess of concrete ahead of the screed to fill all low spots.

Move longitudinal screeds across the concrete with a saw-like motion while their ends rest on headers or templates set true to the roadway grade or on the adjacent finished slab. Move transverse screeds longitudinally approximately 1/5 of the drum length for each complete out-and-back pass of the carriage.

Screed the surface of the concrete enough times and at intervals to produce a uniform surface true to grade and free of voids.

Work the screeded surface to a smooth finish with a long-handled wood or metal float or hand-float it from work bridges over the slab. Floating may not be necessary if the pan float attached to a transverse screed produces an acceptable finish. Avoid overworking the surface of the concrete. Avoid overuse of finish water.

Perform sufficient checks, witnessed by the Engineer, with a long-handled 16-ft. straightedge on the plastic concrete to ensure that the final surface will be within specified tolerances. Make the check with the straightedge parallel to the centerline. Lap each pass half over the preceding pass. Remove all high spots, and fill and float all depressions over 1/16 in. deep with fresh concrete. Continue checking and floating until the surface is true to grade and free of depressions, high spots, voids, or rough spots. Fill screed-rail support holes with concrete, and finish them to match the top of the slab.

Finish the concrete surface to a uniform texture using a carpet drag, burlap drag, or broom finish. Finish the surface to a smooth sandy texture without blemishes, marks, or scratches deeper than 1/16 in. Apply the surface texturing using a work bridge or platform immediately after completing the straightedge checks. Draw the carpet or burlap drag longitudinally along the concrete surface, adjusting the surface contact area or pressure to provide a satisfactory coarsely textured surface. A broom finish may be performed using a fine bristle broom transversely.

Coat the concrete surface immediately after the carpet or burlap drag, or broom finish with a single application of evaporation retardant at a rate recommended by the manufacturer. Do not allow more than 10 min. to elapse between the texturing at any location and application of evaporation retardant. The evaporation retardant may be applied

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using the same work bridge used for surface texturing. Do not work the concrete surface once the evaporation retardant has been applied.

Apply interim and final curing in accordance with Section 420.4.J, "Curing Concrete."

The Contractor is responsible for the ride quality of the finished bridge slab. The Engineer will use a 10-ft. straightedge (1/8 in. in 10 ft.) to verify ride quality and to determine locations where corrections are needed. If the Engineer determines that the ride quality is unacceptable, submit a plan for approval to produce a ride of acceptable quality. Make all corrections for ride before saw-cutting grooves.

Saw-cut grooves in the hardened concrete of bridge slabs, bridge approach slabs, and direct-traffic culverts to produce the final texturing after completion of the required curing period. Cut grooves perpendicular to the structure centerline. Cut grooves continuously across the slab to within 18 in. of the barrier rail, curb, or median divider. At skewed metal expansion joints in bridge slabs, adjust groove cutting by using narrow-width cutting heads so that all grooves end within 6 in. of the joint, measured perpendicular to the centerline of the metal joint. Leave no ungrooved surface wider than 6 in. adjacent to either side of the joint. Ensure that the minimum distance to the first groove, measured perpendicular to the edge of the concrete joint or from the junction between the concrete and the metal leg of the joint, is 1 in. Cut grooves continuously across construction joints or other joints in the concrete that are less than 1/2 in. wide. Apply the same procedure described above where barrier rails, curbs, or median dividers are not parallel to the structure centerline to maintain the 18-in. maximum dimension from the end of the grooves to the gutter line. Cut grooves continuously across formed concrete joints.

When the plans call for a concrete overlay to be placed on the slab (new construction) or on prestressed concrete box beams or other precast elements, give a carpet drag, burlap drag, or broom finish to all concrete surfaces to be overlaid. Saw-grooving is not required in this case. Provide an average texture depth for the finish of approximately 0.035 in. with no individual test falling below 0.020 in., unless otherwise shown on the plans, when tested in accordance with Tex-436-A. If the texture depth falls below what is intended, revise finishing procedures to produce the desired texture.

When the plans require an asphalt seal, with or without overlay, on the slab (new construction), on prestressed concrete box beams, or on other precast elements, give all concrete surfaces to be covered a lightly

textured broom or carpet drag finish. Provide an average texture depth of approximately 0.025 in. when tested in accordance with Tex-436-A.

- J. Curing Concrete.** Obtain approval of the proposed curing methods, equipment, and materials before placing concrete. The Engineer may require the same curing methods for like portions of a single structure. Inadequate curing or facilities may delay all concrete placement on the job until remedial action is taken.

A curing day is a calendar day when the temperature, taken in the shade away from artificial heat, is above 50°F for at least 19 hr. or, on colder days if the temperature of all surfaces of the concrete is maintained above 40°F, for the entire 24 hr. The required curing period begins when all concrete has attained its initial set. Tex-440-A may be used to determine when the concrete has attained its initial set.

Cure all concrete for 4 consecutive days except as noted in Table 1.

Table 1
Exceptions to 4-Day Curing

Description	Type of Cement	Required Curing Days
Upper surfaces of bridge slabs, top slab of direct-traffic culverts, and concrete overlays	I or III	8
	II or I/II	10
	All types with supplementary cementing materials	10
Concrete piling buildups	All	6

For upper surfaces of bridge slabs, bridge approach slabs, median and sidewalk slabs, and culvert top slabs constructed using Class S concrete, apply interim curing using a Type 1-D curing compound as soon as possible after application of the evaporation retardant and after the water sheen has disappeared, but no more than 45 min. after application of the evaporation retardant. Apply membrane interim curing using a work bridge or other approved apparatus to ensure a uniform application. Water-cure for final curing in accordance with this Section, starting as soon as possible without damaging the surface finish. Maintain the water curing for the duration noted in Table 1. Place polyethylene sheeting, burlap-polyethylene blankets, laminated mats, or insulating curing mats in direct contact with the slab when the air temperature is expected to drop below 40°F during the first 72 hr. of the curing period. Weigh down these curing materials with dry mats to maintain direct contact with the concrete and to provide insulation

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against cold weather. Supplemental heating or insulation may be required in cold and wet weather if the insulating cotton mats become wet or if the concrete drops below the specified curing temperature. Avoid applying heat directly to concrete surfaces.

For the top surface of any concrete unit upon which concrete is to be placed and bonded at a later interval (stub walls, risers, etc.) and other superstructure concrete (curbs, wingwalls, parapet walls, etc.), use only water curing in accordance with this Section.

Cure all other concrete as specified in the pertinent Items. Use the following methods for curing concrete, subject to the requirements of this Item.

1. **Form Curing.** When forms are left in intimate contact with the concrete, other curing methods are not required except for exposed surfaces and for cold weather protection. If forms are removed before the 4-day required curing period, use another approved curing method.
2. **Water Curing.** Keep all exposed surfaces of the concrete wet continuously for the required curing time. Use water curing that meets the requirements for concrete mixing water in Section 421.2.D, "Water." Do not use seawater or water that stains or leaves an unsightly residue.
 - a. **Wet Mats.** Keep the concrete continuously wet by maintaining wet cotton mats in direct contact with the concrete for the required curing time. If needed, place damp burlap blankets made from 9-oz. stock on the damp concrete surface for temporary protection before applying cotton mats. Then place the dry mats and wet them immediately after they are placed. Weight the mats adequately to provide continuous contact with all concrete. Cover surfaces that cannot be cured by direct contact with mats, forming an enclosure well anchored to the forms or ground so that outside air cannot enter the enclosure. Provide sufficient moisture inside the enclosure to keep all surfaces of the concrete wet.
 - b. **Water Spray.** Overlap sprays or sprinklers to keep all unformed surfaces continuously wet.
 - c. **Ponding.** Cover the surfaces with at least 2 in. of clean granular material, kept wet at all times, or at least 1 in. deep water. Use a dam to retain the water or saturated granular material.

- 3. Membrane Curing.** Unless otherwise shown on the plans, choose either Type 1-D or Type 2 membrane-curing compound when membrane curing is permitted. Type 1-D (Resin Base Only) is required for interim curing bridge slabs and top slabs of direct-traffic culverts and all other surfaces that require a higher grade of surface finish. For substructure concrete provide only 1 type of curing compound on any 1 structure.

Apply membrane curing just after free moisture has disappeared at a rate of approximately 180 sq. ft. per gallon. Do not spray curing compound on projecting reinforcing steel or concrete that will later form a construction joint. Do not apply membrane curing to dry surfaces. Dampen formed surfaces and surfaces that have been given a first rub so that they are moist at the time of application of the membrane.

When membrane is used for complete curing, leave the film unbroken for the minimum curing period specified. Correct damaged membrane immediately by reapplication of membrane. Polyethylene sheeting, burlap-polyethylene mats, or laminated mats in close contact with the concrete surfaces are equivalent to membrane curing.

- K. Removal of Forms and Falsework.** Unless otherwise directed, forms for vertical surfaces may be removed after the concrete has aged 12 hr. after initial set provided the removal can be done without damage to the concrete. Keep forms for mass placements, defined in Section 420.4.G.14, "Mass Placements," in place for 4 days following concrete placement.

Remove forms for inside curb faces and for bridge rails whenever removal can be done without damage to the curb or railing.

Leave in place weight-supporting forms and falsework spanning more than 1 ft. for all bridge components and culvert slabs except as directed otherwise until the concrete has attained a compressive strength of 2,500 psi. Remove forms for other structural components as necessary.

Remove inside forms (walls and top slabs) for box culverts and sewers after concrete has attained a compressive strength of 1,800 psi if an approved overhead support system is used to transfer the weight of the top slab to the walls of the box culvert or sewer before removal of the support provided by the forms.

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Forms or parts of forms may be removed only if constructed to permit removal without disturbing forms or falsework required to be left in place for a longer period on other portions of the structure.

Remove all metal appliances used inside forms for alignment to a depth of at least 1/2 in. from the concrete surface. Make the appliances so that metal may be removed without undue chipping or spalling of the concrete, and so that it leaves a smooth opening in the concrete surface when removed. Do not burn off rods, bolts, or ties.

Remove all forms and falsework unless otherwise directed.

- L. Defective Work.** Repair defective work as soon as possible. Remove and replace at the expense of the Contractor any defect that cannot be repaired to the satisfaction of the Engineer.
- M. Ordinary Surface Finish.** Apply an ordinary surface finish to all concrete surfaces as follows:
- Chip away all loose or broken material to sound concrete where porous, spalled, or honeycombed areas are visible after form removal.
 - Repair spalls by saw-cutting and chipping at least 1/2 in. deep, perpendicular to the surface to eliminate feather edges. Repair shallow cavities using a latex adhesive grout, cement mortar, or epoxy mortar as approved. Repair large areas using concrete as directed or approved.
 - Clean and fill holes or spalls caused by the removal of form ties, etc., with latex grout, cement grout, or epoxy grout as approved. Fill only the holes. Do not blend the patch with the surrounding concrete. On surfaces to receive a rub finish in accordance with Item 427, "Surface Finishes for Concrete," chip out exposed parts of metal chairs to a depth of 1/2 in. and repair the surface.
 - Remove all fins, runs, drips, or mortar from surfaces that will be exposed. Smooth all form marks and chamfer edges by grinding or dry-rubbing.
 - Ensure that all repairs are dense, well bonded, and properly cured. Finish exposed large repairs to blend with the surrounding concrete where a higher class of finish is not specified.

Unless noted otherwise, apply an ordinary surface finish as the final finish to the following exposed surfaces:

- inside and top of inlets,
- inside and top of manholes,
- inside of sewer appurtenances,
- inside of culvert barrels,

- bottom of bridge slabs between girders or beams, and
- vertical and bottom surfaces of interior concrete beams or girders.

Form marks and chamfer edges do not need to be smoothed for the inside of culvert barrels and the bottom of bridge slabs between girders or beams.

420.5. Measurement. This Item will be measured by the cubic yard, square yard, foot, square foot, or by each structure.

- A. General.** Concrete quantities will be based on the dimensions shown on the plans or those established in writing by the Engineer.

In determining quantities, no deductions will be made for chamfers less than 2 in. or for embedded portions of steel or prestressed concrete beams, piling, anchor bolts, reinforcing steel, drains, weep holes, junction boxes, electrical or telephone conduit, ducts and voids for prestressed tendons, or embedded portions of light fixtures.

For slab and girder spans using pan forms, a quantity will be included for the screed setting required to provide proper camber in the roadway surface after form removal.

For slabs on steel or prestressed concrete beams, an estimated quantity for the haunch between the slab and beams will be included. No measurement will be made during construction for variation in the amount of haunch concrete due to variations in camber of the beams.

For cast-in-place slabs on slab beams, double-T beams, or box beams, the combination of span length, theoretical camber in beams, computed deflections, and plan vertical curve will be taken into account in determining the quantity for the slab.

Additional concrete that may be required by an adjustment of the profile grade line during construction, to insure proper slab thickness, will not be measured for payment.

Variation in concrete headwall quantity incurred when an alternate bid for pipe is permitted will not be cause for payment adjustment.

Mass placements may be either a plans quantity item or measured in place as indicated.

Quantities revised by a change in design, measured as specified, will be increased or decreased and included for payment.

- B. Plans Quantity.** Structure elements designated in Table 2 and measured by the cubic yard are plans quantity measurement items. The quantity to be paid for plans quantity items is the quantity shown in the

420.6 to 420.6

proposal unless modified by Article 9.2, “Plans Quantity Measurement.” Additional measurements or calculations will be made if adjustments of quantities are required.

No adjustment will be made for footings or other in-ground elements where the Contractor has been allowed to place concrete in an excavation without forms.

Table 2
Plans Quantity Payment
(Cubic Yard Measurement Only)

Culverts and culvert wing walls	Abutments
Headwalls for pipe	Slab and girder spans (pan form)
Retaining walls	Footings
Inlets and manholes	Pile bent caps
Shear key concrete for box and slab beams	Concrete wearing surface on pre-cast box beams, slab beams or double-T beams
Bridge approach slabs	Cast-in-place concrete slab spans

Note: Other structure elements, including pier and bent concrete, may be paid for as “plans quantity” when shown on the plans.

C. Measured in Place. Items not paid for as “plans quantity” will be measured in place.

420.6. Payment. The work performed and materials furnished in accordance with this Item and measured as provided under “Measurement” will be paid for at the unit price bid for the various structure elements specified of the various classes of concrete. Mass placements, as defined in Section 420.4.G.14, “Mass Placements,” will be paid for separately for the various classes of concrete. This price is full compensation for furnishing, hauling, and mixing concrete materials; furnishing, bending, fabricating, splicing, welding and placing the required reinforcement; clips, blocks, metal spacers, ties, wire, or other materials used for fastening reinforcement in place; placing, finishing, curing, and grooving concrete; applying ordinary surface finish; furnishing and placing drains, metal flashing strips, and expansion-joint material; excavation, subgrade preparation, and disposal of excavated material for bridge approach slabs; and forms and falsework, equipment, labor, tools, and incidentals.

Diaphragm concrete will not be paid for directly but is subsidiary to the slab unless otherwise shown on the plans.

Design and installation of foundations for falsework is at the Contractor's expense.

The following procedure will be used to evaluate concrete where 1 or more project acceptance test specimens fail to meet the required design strength specified in Item 421, "Hydraulic Cement Concrete," or in the plans:

- The concrete for a given placement will be considered structurally adequate and accepted at full price if the average of all test results for specimens made at the time of placement meets the required design strength provided that no single test result is less than 85% of the required design strength.
- The Engineer will perform a structural review of the concrete to determine its adequacy to remain in service if the average of all test results for specimens made at the time of placement is less than the required design strength or if any test results are less than 85% of the required design strength. If cores are required to determine the strength of the in-situ concrete, take cores at locations designated by the Engineer in accordance with Tex-424-A. The coring and testing of the cores will be at the Contractor's expense. The Engineer will test the cores.
- If all of the tested cores meet the required design strength, the concrete will be paid for at the full price.
- If any of the tested cores do not meet the required design strength but the average strength attained is determined to be structurally adequate, the Engineer will determine the limits of the pay adjustment. The average strength of the cores tested will be used in the pay adjustment formula.
- Remove concrete that is not structurally adequate.
- Concrete that has been determined to be structurally adequate may be accepted at an adjusted price based on the following formula:

$$A = 0.10Bp + 0.75(Sa/Ss)^2 Bp$$

where:

A = Amount to be paid per unit of measure for the entire placement in question

Sa = Actual strength from cylinders or cores. Use values from cores, if taken.

Ss = Minimum required strength (specified)

Bp = Unit bid price.

- The decision to reject structurally inadequate concrete or to apply the pay adjustment will be made no later than 56 days after placement.

- 5. Adequacy and Acceptance of Concrete.** The Engineer will sample and test the fresh and hardened concrete for acceptance. The test results will be reported to the Contractor and the concrete supplier. For any concrete that fails to meet the required strengths as outlined below, investigate the quality of the materials, the concrete production operations, and other possible problem areas to determine the cause. Take necessary actions to correct the problem including redesign of the concrete mix. The Engineer may suspend all concrete operations under the pertinent Items if the Contractor is unable to identify, document, and correct the cause of the low strengths in a timely manner. Resume concrete operations only after obtaining approval for any proposed corrective actions.
- a. Structural Concrete.** For concrete classes identified as structural concrete in Table 5, the Engineer will make and test 7-day and 28-day specimens. Acceptance will be based on the design strength given in Table 5.
- The Engineer will evaluate the adequacy of the concrete by comparing 7-day test results to the target value established in accordance with Section 421.4.B, "Trial Batches."
- b. All Other Concrete.** For concrete classes not identified as structural concrete in Table 5, the Engineer will make and test 7-day specimens. The Engineer will base acceptance on the 7-day target value established in accordance with Section 421.4.B, "Trial Batches."
- 6. Test Sample Handling.** Unless otherwise shown on the plans or directed, remove forms and deliver department test specimens to curing facilities, in accordance with pertinent test procedures. Clean and prepare forms for reuse.

421.5. Measurement and Payment. The work performed, materials furnished, equipment, labor, tools, and incidentals will not be measured or paid for directly but will be subsidiary to pertinent Items.

ITEM 422

REINFORCED CONCRETE SLAB

422.1. Description. Form and construct reinforced concrete bridge slab.

422.2. Materials. Furnish materials in accordance with:

- Item 420, "Concrete Structures"

422.3 to 422.4

- Item 421, “Hydraulic Cement Concrete”
- Item 426, “Prestressing”
- Item 440, “Reinforcing Steel.”

Use Class S for all cast-in-place concrete unless otherwise shown on the plans.

422.3. Construction.

- A. Cast-in-Place Slab.** Use conventional forms, permanent metal deck forms, or prestressed concrete panels. Use permanent metal deck forms or conventional forms for thickened slabs, diaphragms, or other regions as shown on the plans where prestressed concrete panels are not used. Construct the slab as shown on the plans and in accordance with the pertinent requirements of:
- Item 420, “Concrete Structures”
 - Item 424, “Precast Concrete Structures (Fabrication)”
 - Item 426, “Prestressing”
 - Item 440, “Reinforcing Steel.”
- B. Extending Existing Slabs.** Extend existing slabs in accordance with Item 430, “Extending Concrete Structures.”
- C. Prestressed Concrete Panels.** Profile each beam to determine the actual camber or sag of the beams before placing panels. Adjust the profile grade line, panel elevation, and bearing seat elevations as needed to obtain the required cover over the slab reinforcement and the required slab thickness. When a profile grade line adjustment is necessary, make adjustments over suitable increments, depending on span lengths, so that the revised grade line will produce a uniform profile and good riding qualities. Obtain approval for the grade adjustments prior to placement. Consider actual beam camber in adjacent spans or slab placements when adjusting the grade line. Place the top portion of abutment backwalls and wings after adjustment to the profile grade line.

422.4. Measurement. Reinforced concrete slab placed under this Item will be measured by the square foot of slab surface area using the nominal dimensions and configuration shown on the plans. Transverse measurement will be made from outer edge of slab to outer edge of slab (including raised median and sidewalk sections). Longitudinal measurement will be made between ends of units or spans. Diaphragms, haunch concrete, reinforcement, and optional steel diaphragms will be considered as a portion of the slab.

422.5 to 423.2

This is a plans quantity measurement Item. The quantity to be paid is the quantity shown in the proposal unless modified by Article 9.2, "Plans Quantity Measurement." Additional measurements or calculations will be made if adjustment of quantities is required.

The quantities of concrete and reinforcing steel shown on the plans are based on a conventionally formed slab. These quantities include amounts for concrete diaphragms, brackets and other required attachments, and haunch concrete when required, based on the profile grade, theoretical camber, and dead load deflection of the beams. No additional measurement will be made for concrete or reinforcing steel due to a variation in camber of the beams from theoretical camber, or for additional quantities required by optional methods of forming.

422.5. Payment. The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Reinforced Concrete Slab" and "Reinforced Concrete Slab (Extend Slab)." This price is full compensation for furnishing, hauling, mixing, placing, curing, and finishing concrete; furnishing and placing reinforcing steel; grouting and pointing; furnishing and placing drains and expansion joint material (except where specifically furnished under another Item); furnishing and placing metal flashing strips; forms (removable and permanent) and falsework; prestressed concrete panels; furnishing and placing concrete and reinforcement for raised medians, sidewalks, sign mounts, luminaire brackets, and other concrete appurtenances; removing designated portions of existing slab; cleaning, bending, and cutting exposed existing reinforcing steel; welding reinforcing steel; doweling; cleaning and preparing concrete surfaces; and equipment, labor, tools, and incidentals.

Structural steel, anchor bolts, armor joints, sealed expansion joints, rail (including the concrete parapet portion), and concrete median barrier will be measured and paid for in accordance with pertinent bid items.

ITEM 423

RETAINING WALLS

423.1. Description. Furnish, construct, and install retaining walls.

423.2. Materials.

- A. General.** Furnish materials in accordance with the following:
- Item 420, "Concrete Structures"

424.4 to 425.2

1. **Prestressed Members.** Store and handle prestressed members in accordance with Item 425, "Precast Prestressed Concrete Structural Members."
2. **Nonstressed Members.** Store and handle nonstressed members in a manner to avoid excessive bending stresses and damage.

The storage area must be clean and well drained. Prevent excessive or differential settlement of members by storing them on stable ground and on dunnage of sufficient size, shape, and strength, to prevent crushing.

When members are stacked, separate them with blocking, arranged in vertical planes, that does not crush under load. Stack members so that lifting devices are accessible and undamaged.

Rearrange improperly stored members and inspect them for damage. Members that are improperly stored and become cracked, warped, or otherwise damaged in storage may be cause for rejection.

Dunnage and blocking material must not cause damage or stains that are unacceptable for the required finish.

424.4. Measurement and Payment. The work performed, materials furnished, equipment, labor, tools, and incidentals will not be measured or paid for directly but will be subsidiary to bid items of the Contract.

ITEM 425

PRECAST PRESTRESSED CONCRETE STRUCTURAL MEMBERS

425.1. Description. Furnish and erect precast prestressed concrete members fabricated by pretensioning, post-tensioning, or a combination of the two.

425.2. Materials. Use materials that meet requirements of the following Items:

- Item 421, "Hydraulic Cement Concrete"
- Item 426, "Prestressing"
- Item 434, "Elastomeric Bridge Bearings"
- Item 440, "Reinforcing Steel"
- Item 442, "Metal For Structures"

- DMS-4650, “Hydraulic Cement Concrete Curing Materials and Evaporation Retardants”
- DMS-6100, “Epoxies and Adhesives.”

The bedding strip for precast prestressed concrete bridge deck panels must be extruded polystyrene conforming to ASTM C 578, Type VI, with:

- maximum water absorption of 0.1% by volume tested in accordance with ASTM C 272 and
- minimum compressive strength of 40 psi tested in accordance with ASTM D 1621 by loading the bedding strip sample perpendicular to the skin (bearing) face.

Provide a manufacturer’s certification stating that the bedding strip meets the requirements of this Item. Use adhesive or bonding agents for polystyrene as recommended by the polystyrene manufacturer.

Use other materials as panel bedding strips only after submitting suitable data for structural review and approval.

The dimensions for panel bedding strips must conform to those shown on the plans.

425.3. Construction. Fabricate precast prestressed concrete members in accordance with Item 424, “Precast Concrete Structures (Fabrication).”

A. Handling, Storing, Hauling, and Erection. Properly handle, store, haul, and erect all members so that they are placed in the structure without damage.

Unless approved on shop or erection drawings, maintain members in an upright position at all times, and raise and support them near the ends to prevent torsion. Lift members with approved lifting devices as shown on the shop drawings or as approved.

Do not move members from the casting yard until all requirements of the pertinent items have been met. Do not haul beams to the project site until at least 7 days have elapsed since casting unless otherwise approved.

The storage area must be clean and well drained. Prevent excessive or differential settlement of members by storing them on:

- stable ground and
- dunnage of sufficient size, shape, and strength to prevent crushing.

Place dunnage a distance not greater than 3% of the beam length from the beam ends. When approved, cantilever beams may be supported at locations other than near the ends. Support concrete box beams and

425.4 to 425.5

U-beams under the solid end block area during handling, storage, hauling, and erection.

When members are stacked, separate them with blocking arranged in vertical planes that will not crush under load. Stack members so that lifting devices are not damaged.

Rearrange improperly stored members and inspect them for damage. Members that are improperly stored and become cracked, warped, or otherwise damaged in storage may be rejected.

Securely tie or brace all beams during erection in accordance with minimum erection and bracing standards. When railroad or roadway traffic must be maintained beneath beams already placed, protect traffic against falling objects during the erection of diaphragms and other structural members, during the placing of cast-in-place concrete, and during the erection and dismantling of forms. Protect traffic with nets or flooring with openings not larger than 1 in., or as approved.

When erecting precast prestressed concrete bridge deck panels, fit mating surfaces to prevent excessive grout leakage. If such fit is not provided, fill the joint with grout or seal it with an acceptable caulking compound before placing the cast-in-place portion of the slab.

After slab placement, finish surfaces of beams or other members in accordance with Section 420.4.M, "Ordinary Surface Finish," and Item 427, "Surface Finishes for Concrete."

Correct beam discrepancies including but not limited to horizontal misalignment or variations in vertical camber, to achieve a satisfactory completed structure, at no additional expense to the Department. Correction may require replacement of the member.

425.4. Measurement. This Item will be measured by the foot, square foot, square yard, cubic yard, or each member.

This is a plans quantity measurement Item. The quantity to be paid is the quantity shown in the proposal, unless modified by Article 9.2, "Plans Quantity Measurement." Additional measurement or calculations will be made if adjustments of quantities are required.

425.5. Payment. The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Prestressed Concrete" of the specified structural component and type or size. This price is full compensation for fabricating, hauling, and erection of the members; furnishing and tensioning of prestressing steel; furnishing and placing

reinforcing steel and duct; furnishing and placing bearing plates, elastomeric bearings, bars, anchorage plates, and appurtenances; grouting holes; repairs; special treatment of end anchorages and shoes as required; erection bracing; and equipment, labor, tools, and incidentals.

Precast prestressed concrete bridge deck panels will not be paid for directly but will be subsidiary to pertinent Items.

Precast prestressed concrete piling will be paid for as specified in Item 409, "Prestressed Concrete Piling."

ITEM 426 PRESTRESSING

426.1. Description. Furnish, store, and handle prestressing materials and perform prestressing of precast members and cast-in-place structural units. For this Item, the following definitions apply:

- **Prestressing.** The introduction of internal stresses (pretensioning or post-tensioning) into a structural member by tensioning and anchoring strands, bars, or wires to counteract the stresses resulting from the applied load.
- **Pretensioning.** The application of prestressing force to the tensioning devices before casting concrete.
- **Post-Tensioning.** The application of prestressing force to the tensioning devices after concrete has hardened.
- **Tendon.** Any single unit used to apply prestressing force to the member. For post-tensioned units, a tendon is a bar, group of wires, or group of strands having common end anchorage.
- **Post-Tensioning System.** A complete tendon with couplers, end anchorage, and all other necessary hardware.

426.2. Materials. Furnish materials that meet requirements of the following Items:

- Item 420, "Concrete Structures"
- Item 421, "Hydraulic Cement Concrete"
- Item 434, "Elastomeric Bridge Bearings"
- Item 440, "Reinforcing Steel"
- Item 442, "Metal For Structures"
- DMS-4670, "Grouts for Post-Tensioning"
- DMS-6310, "Joint Sealants and Fillers."

A. Prestressing Hardware. Furnish prestressing hardware that meets the manufacturer's specifications.

106.1 to 110.2

ITEM 106

OBLITERATING ABANDONED ROAD

106.1. Description. Obliterate designated sections of abandoned road.

106.2. Construction. Strip and windrow existing topsoil before shaping operations. Remove asphaltic pavement in accordance with applicable item. Remove material designated as salvageable in accordance with applicable items. Remove abandoned structures unless otherwise shown on the plans. Scarify and mix the abandoned roadbed with soil and blade to produce a smooth, uniform appearance. Fill, cut, and shape the designated sections of the abandoned road to blend into the surrounding terrain. Eliminate ditches except where needed to facilitate drainage. Cover disturbed areas with topsoil after shaping operations to facilitate establishment of vegetation.

106.3. Measurement. This Item will be measured by the 100-ft. station along the baseline of the abandoned roadway.

106.4. Payment. The work performed in accordance with this Item and measured as provided under “Measurement” will be paid for at the unit price bid for “Obliterating Abandoned Road.” This price is full compensation for salvaging and replacing topsoil; stockpiling or disposal of materials; removal of abandoned structures; scarifying, mixing, and shaping abandoned road; furnishing and operating equipment, and labor, tools, and incidentals.

ITEM 110

EXCAVATION

110.1. Description. Excavate areas as shown on the plans or as directed. Remove materials encountered to the lines, grades, and typical sections shown on the plans and cross-sections.

110.2. Construction. Accept ownership of unsuitable or excess material and dispose of material in accordance with local, state, and federal regulations at locations outside the right of way.

Maintain drainage in the excavated area to avoid damage to the roadway section. Correct any damage to the subgrade caused by weather, at no additional cost to the Department.

Shape slopes to avoid loosening material below or outside the proposed grades. Remove and dispose of slides as directed.

110.3 to 110.4

A. Rock Cuts. Excavate to finish subgrade. Manipulate and compact subgrade in accordance with Article 132.3.D, "Compaction Methods," unless excavation is to clean homogenous rock at finish subgrade elevation. If excavation extends below finish subgrade, use approved embankment material compacted in accordance with Article 132.3.D to replace undercut material at no additional cost.

B. Earth Cuts. Excavate to finish subgrade. In areas where base or pavement structure will be placed on subgrade, scarify subgrade to a uniform depth at least 6 in. below finish subgrade elevation. Manipulate and compact subgrade in accordance with Article 132.3.D, "Compaction Methods."

If unsuitable material is encountered below subgrade elevations, take corrective measures as directed. Drying required deeper than 6 in. below subgrade elevation will be paid for in accordance with Article 9.4, "Payment for Extra Work." Excavation and replacement of unsuitable material below subgrade elevations will be performed and paid for in accordance with the applicable bid items. However, if Item 132, "Embankment," is not included in the Contract, payment for replacement of unsuitable material will be paid for in accordance with Article 9.4.

C. Subgrade Tolerances. For turnkey construction, excavate to within 1/2 in. in cross-section and 1/2 in. in 16 ft. measured longitudinally. For staged construction, excavate to within 0.1 ft. in cross-section and 0.1 ft. in 16 ft. measured longitudinally.

110.3. Measurement. This Item will be measured by the cubic yard in its original position as computed by the method of average end areas.

This is a plans quantity measurement Item. The quantity to be paid is the quantity shown in the proposal unless modified by Article 9.2, "Plans Quantity Measurement." Additional measurements or calculations will be made if adjustments of quantities are required.

Limits of measurement for excavation in retaining wall areas will be as shown on the plans.

Shrinkage or swelling factors will not be considered in determining the calculated quantities.

110.4. Payment. The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Excavation (Roadway)," "Excavation (Channel)," "Excavation (Special)," or "Excavation (Roadway

110.4 to 112.3

and Channel).” This price is full compensation for authorized excavation; drying; undercutting subgrade and reworking or replacing the undercut material in rock cuts; hauling; disposal of material not used elsewhere on the project; scarification and compaction; and equipment, labor, materials, tools, and incidentals.

When a slide not due to the Contractor’s negligence or operation occurs, payments for removal and disposal of the slide material will be in accordance with Article 9.4, “Payment for Extra Work.” Excavation in backfill areas of retaining walls will not be measured or paid for directly but will be subsidiary to pertinent Items.

ITEM 112 SUBGRADE WIDENING

112.1. Description. Widen the existing subgrade in accordance with the typical sections.

112.2. Materials. Furnish water in accordance with Article 204.2, “Materials.”

112.3. Construction.

- A. Preparation of Embankment.** Scarify to a depth of at least 6 in. into existing adjacent embankment slopes before fill is placed.
- B. Pavement Structure Removal.** Remove material along the edge of the existing pavement. Provide a smooth vertical cut unless otherwise shown on the plans. Conform to the typical sections for the limits of removal unless directed otherwise. Accept ownership of excess material not used in the construction of the subgrade widening. Dispose of excess material in accordance with federal, state, and local regulations.
- C. Widening.** In cut sections, remove material and move to fill sections within the project. Use material from cut sections for embankment. In fill sections, place the material in successive lifts to the line and grades shown on the typical sections. Provide additional embankment in accordance with the applicable bid item or Article 9.4, “Payment for Extra Work,” if all excavation has been performed and additional embankment is required to complete the work.
- D. Compaction.** Compact the widened subgrade in accordance with Article 132.3, “Construction.”

This is a plans quantity measurement Item. The quantity to be paid is the quantity shown in the proposal unless modified by Article 9.2, "Plans Quantity Measurement." Additional measurements or calculations will be made if adjustment of quantities is required.

The quantities of concrete and reinforcing steel shown on the plans are based on a conventionally formed slab. These quantities include amounts for concrete diaphragms, brackets and other required attachments, and haunch concrete when required, based on the profile grade, theoretical camber, and dead load deflection of the beams. No additional measurement will be made for concrete or reinforcing steel due to a variation in camber of the beams from theoretical camber, or for additional quantities required by optional methods of forming.

422.5. Payment. The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Reinforced Concrete Slab" and "Reinforced Concrete Slab (Extend Slab)." This price is full compensation for furnishing, hauling, mixing, placing, curing, and finishing concrete; furnishing and placing reinforcing steel; grouting and pointing; furnishing and placing drains and expansion joint material (except where specifically furnished under another Item); furnishing and placing metal flashing strips; forms (removable and permanent) and falsework; prestressed concrete panels; furnishing and placing concrete and reinforcement for raised medians, sidewalks, sign mounts, luminaire brackets, and other concrete appurtenances; removing designated portions of existing slab; cleaning, bending, and cutting exposed existing reinforcing steel; welding reinforcing steel; doweling; cleaning and preparing concrete surfaces; and equipment, labor, tools, and incidentals.

Structural steel, anchor bolts, armor joints, sealed expansion joints, rail (including the concrete parapet portion), and concrete median barrier will be measured and paid for in accordance with pertinent bid items.

ITEM 423

RETAINING WALLS

423.1. Description. Furnish, construct, and install retaining walls.

423.2. Materials.

- A. General.** Furnish materials in accordance with the following:
- Item 420, "Concrete Structures"

423.2 to 423.2

- Item 421, “Hydraulic Cement Concrete”
- Item 440, “Reinforcing Steel”
- Item 445, “Galvanizing”
- Item 458, “Waterproofing Membranes for Structures”
- Item 556, “Pipe Underdrains.”

Unless otherwise shown on the plans, use concrete for retaining walls that conforms to the requirements of Table 1.

Table 1
Concrete for Retaining Walls

Application	Concrete
Cast-in-place, non-reinforced	Class A
Cast-in-place, reinforced	Class C
Precast	Class H, $f'_c = 4,000$ psi

Furnish concrete for machine-made concrete block units in accordance with ASTM C 90, Class 1, Type II, except that the minimum 28-day compressive strength must be 4,000 psi with maximum moisture absorption of 7%.

Provide Type 1 filter fabric in accordance with DMS-6200, “Filter Fabric.” Provide filter fabric rated as UV-resistant when used as part of the exposed facing for a temporary wall.

Joint fillers, pads, waterstops, and other incidental materials must be as shown on the plans or approved by the Engineer.

When the plans call for epoxy coating of steel earth reinforcements, epoxy coat all steel used in concrete panels and coping including connectors, dowels, stirrups, and reinforcing steel.

B. Fabrication.

1. **Cast-in-Place.** Meet Item 420, “Concrete Structures.”
2. **Formed Precast.** Meet Item 424, “Precast Concrete Structures (Fabrication).”
3. **Machine-Made Precast.** Furnish machine-made concrete block units in accordance with ASTM C 90, sampled and tested in accordance with ASTM C 140. Furnish units with molded dimensions within 1/8 in. of specified dimensions, except height must be within 1/16 in.

C. Backfill.

1. **Non-Select.** Furnish backfill meeting Item 132, “Embankment,” of the type specified in the plans. If no type is specified, provide material with a maximum plasticity index of 30 as determined by Tex-106-E.
2. **Select.** Select backfill is required in specific areas of permanent and temporary MSE and concrete block-type retaining walls. Provide select backfill that is free from organic or otherwise deleterious materials and that conforms to the gradation limits in Table 2 as determined by Tex-110-E.

Provide backfill that does not contain shale, caliche, or other soft, poor-durability coarse aggregate particles. Backfill appearing to contain such particles will be tested for soundness. Backfill with 5-cycle magnesium sulfate soundness of more than 30% when tested in accordance with Tex-411-A will be rejected.

Type A, B, and D particles larger than 1/4 in. must be angular or crushed. Rounded rock or gravel is not allowed.

Table 2
Select Backfill Gradation Limits

Type	Sieve Size	Percent Retained
A	3 in.	0
	1/2 in.	50–100
	No. 4	See Note
	No. 40	85–100
B	3 in.	0
	No. 4	See Note
	No. 40	40–100
	No. 200	85–100
C	3 in.	0
	No. 4	See Note
	No. 200	70–100
D	3 in.	0
	3/8 in.	85–100

Note: Use No. 4 sieve for determination of rock backfill as described in Section 423.C, “Backfill.”

When the backfill gradation results in 85% or more material retained on the No. 4 sieve, the backfill will be considered rock backfill. All Type D backfill is considered rock backfill.

423.2 to 423.2

Unless otherwise shown on the plans, furnish Type B backfill for permanent walls. Furnish Type C backfill for temporary walls. Furnish Type D backfill for areas of walls subject to inundation or below the 100-year flood elevation as noted in the plans.

When nonmetallic or epoxy-coated earth reinforcements are used, furnish backfill meeting the requirements of this Section but with a maximum particle size of 3/4 in.

3. **Drainage Aggregate.** Use drainage aggregate to fill the void within concrete block units and in the zone 1 ft. behind the units. Provide drainage aggregate that is free from organic or otherwise deleterious materials and that conforms to the gradation limits in Table 3 as determined by Tex-110-E.

Table 3
Drainage Aggregate Gradation Limits

Sieve Size	Percent Retained
1 in.	0
3/4 in.	25–50
1/2 in.	50–100
No. 4	75–100

4. **Cement-Stabilized Backfill.** Use cement-stabilized backfill when required or as approved. Stabilize Type C backfill with 5% hydraulic cement by dry weight of the backfill material. Use a stationary plant to thoroughly mix the backfill material, cement, and water. Place and compact the backfill within 2 hours of mixing. When cement-stabilized backfill is used, provide special drainage provisions as shown on the plans.
5. **Electrochemical.** Provide backfill meeting the following additional requirements for permanent retaining wall systems using galvanized metallic earth reinforcements:
 - The pH is between 5.5 and 10.0 as determined by Tex-128-E.
 - Resistivity is more than 3,000 ohm-cm as determined by Tex-129-E.
 - Material with resistivity between 1,500 and 3,000 ohm-cm may be used if the chloride content is less than 100 ppm and the sulfate content is less than 200 ppm as determined by Tex-620-J.

When cement-stabilized backfill is used, perform electrochemical testing on the raw, unstabilized backfill material.

- D. Earth Reinforcements.** Furnish earth reinforcements that meet the design requirements. For permanent walls, galvanize or epoxy coat all steel elements in contact with soil. Epoxy coat in accordance with Item 440, "Reinforcing Steel," except provide a minimum 18-mil coating thickness. Epoxy coat the reinforcing only when shown in the plans or as approved. When using nonmetallic or epoxy coated earth reinforcements, use connection hardware that is likewise nonmetallic or epoxy coated.

423.3. Construction.

- A. General.** Construct retaining walls in accordance with details shown on the plans, on the approved working drawings, and to the pertinent requirements of the following Items:

- Item 110, "Excavation"
- Item 132, "Embankment"
- Item 400, "Excavation and Backfill for Structures"
- Item 420, "Concrete Structures"
- Item 458, "Waterproofing Membranes for Structures"
- Item 556, "Pipe Underdrains."

Construct required piling or drilled shafts in accordance with the pertinent specification.

- B. Definitions.** This Item uses the following terms:

- Permanent Wall – A retaining wall with a design service life of 75 years. All walls are presumed to be permanent walls unless otherwise specified in the plans.
- Temporary Wall – A retaining wall so designated by description, with a design service life of 3 years.
- Mechanically Stabilized Earth (MSE) Wall – A wall consisting of a volume of select backfill with tensile earth reinforcement elements distributed throughout. Permanent MSE walls use a precast concrete panel as a facing element. Temporary MSE walls use welded wire fabric with filter fabric backing as a facing element.
- Concrete Block Wall – A retaining wall that uses machine-made, precast concrete block units as facing elements. The walls may use a volume of select fill with tensile earth reinforcements distributed throughout, or may use only the facing unit and unit fill weight for support.

423.3 to 423.3

- C. Options.** When optional design details are shown on the plans, the Contractor is required to use the same facing design within an area of continuous retaining walls.

When proposing the use of 2 or more systems, provide drawings for review indicating the proposed design arrangement.

- D. Working Drawings.** When proprietary wall systems are used, submit casting drawings, construction drawings, and design calculations bearing the seal of a licensed professional engineer for review and approval. For permanent walls, submit 7 sets of casting and construction drawings and 2 sets of design calculations. Upon completion of construction, submit 1 set of reproducible as-built drawings to the Engineer. For temporary walls, submit 5 sets of construction drawings, and 2 sets of design calculations.
- 1. Casting Drawings.** Include all information necessary for casting wall elements, including railing and coping when prefabricated. Show shape and dimensions of panels; size, quantity, and details of the reinforcing steel; quantity, type, size, and details of connection and lifting hardware; and additional necessary details.
 - 2. Construction Drawings.** Include a numbered panel layout showing horizontal and vertical alignment of the walls as well as the existing and proposed groundlines. Include all information needed to erect the walls, including the proposed leveling pad elevations; the type and details of the soil reinforcing system (if applicable); the details and manufacturer of all pads, fillers, and filter fabric; the limits and dimensions of structural backfill; details necessary to incorporate coping, railing, inlets, drainage, and electrical conduit; and additional necessary details.

Leveling pad elevations may vary from the elevations shown on the plans. Unless a different minimum cover or a specified minimum leveling pad elevation is shown, provide at least 1 ft. of cover from the top of the leveling pad to finish grade.
 - 3. Design Calculations.** Include calculations covering the range of heights and loading conditions on the project. Calculations for both internal and external stability as described in the plans will be required. Include a summary of all design parameters used; material types, strength values, and assumed allowables; loads and loading combinations; and factor-of-safety parameters.
- E. Permanent MSE Walls.** Grade the foundation for the structure level for a width equal to or exceeding the length of the reinforcing system.

Compact the foundation with a smooth-wheel vibratory roller or other approved roller. Remove and replace unsuitable foundation soils.

Place drilled shafts and piling located within the MSE volume prior to construction of the wall. Place any required pipe underdrain before construction of the wall.

Place the concrete leveling pad as shown on the construction drawings. Provide a wood float finish, and wait a minimum of 24 hours before beginning panel erection. No curing or strength testing of the leveling pad concrete is required.

Shim the first row of panels as necessary to achieve correct alignment. Use plastic shims or other material that will not deteriorate. If the required shim height exceeds 1 in., remove and replace the leveling pad or provide a grout level-up as directed.

Place filter fabric behind the wall along the joint between the leveling pad and the panels. At leveling pad steps, grout areas where filter fabric spans more than 6 in.

After backfilling the first row of panels, place and compact fill material over the leveling pad to an elevation even with or above the surrounding ground. Do not allow water to accumulate and stand at the base of the wall.

Place filter fabric behind all wall joints and at the intersection of retaining walls with other structures, including riprap. Cover joints at least 6 in. on each side and use adhesive to hold the filter fabric in place.

Exercise care while lifting, setting, and aligning panels to prevent damage to the panels. Discontinue any operation that results in chipping, spalling, or cracking of panels. Remove and replace damaged panels, or repair as approved by the Engineer.

Provide external bracing for the initial row of panels. Use wooden wedges, clamps or other means necessary to maintain position and stability of panels during placement and compaction of backfill. Remove wooden wedges as soon as the panel or coping above the wedged element is erected and backfilled. Remove all wedges after completing the wall.

Review plumbness and position of each row of panels before placing the subsequent row. Remove and rebuild any portion of the wall that is out of tolerance. Modify panel batter and bracing, and backfill material, placement, and compaction methods as required to maintain wall tolerances.

423.3 to 423.3

Construct walls to a vertical and horizontal alignment tolerance of 3/4 in. when measured along a 10-ft. straightedge. Construct walls to an overall vertical tolerance (plumbness from top to bottom) of 1/2 in. per 10 ft. of wall height. Construct walls so that the maximum out-of-plane offset at any panel joint is less than 3/4 in.; no joint is open to the extent that the filter fabric is visible from the front of the wall; and no joint is closed to the extent that there is concrete-to-concrete contact.

Place backfill to closely follow the erection of each row of panels. Place the select and embankment backfill to the same elevation where possible, and operate the compaction equipment over the interface. Do not create a continuous, distinct, vertical joint between the select and embankment backfill. Do not complete the embankment prior to construction of the retaining wall.

When building a wall against existing ground, maintain the stability of the interface area between the existing ground and the select fill. Remove and recompact any material that loosens, caves, or fails.

Compact backfill to provide not less than 95% of density determined in accordance with Tex-114-E. Field density determination will be made in accordance with Tex-115-E.

Sprinkle backfill as required to ensure adequate uniformly distributed moisture in each lift prior to and during compaction. Place fill in lifts of 8 in. or less (loose measurement). Place fill in a manner that avoids segregation of the fill. Decrease the lift thickness if necessary to obtain the required compaction. Use hand-operated or walk-behind compaction equipment in the 3-ft. wide strip adjacent to the wall panels. Do not displace panels or distort or damage the reinforcement system during compaction. Modify backfill material, placement, and compaction methods as necessary to meet density requirements while maintaining wall tolerances.

Place rock backfill or material that the Engineer determines too coarse for density testing by the "Ordinary Compaction" method of Item 132, "Embankment."

At each earth reinforcement level, place and compact the backfill to the reinforcement level before placing the reinforcement. Place earth reinforcements perpendicular to the face of the wall. Remove slack in connections prior to placing backfill. For systems using nonmetallic earth reinforcements, pretension each layer of reinforcement to remove slack before placing backfill. Use devices capable of mechanically applying and holding the required force. Do not operate tracked equipment directly on any reinforcement.

When rock backfill is used, cover the rock backfill with filter fabric before placing the 2 ft. of backfill immediately below the pavement structure or top of wall. Overlap the fabric at least 18 in. at splices, and extend it past the edge of the rock backfill at least 18 in. Above the filter fabric, use backfill that contains sufficient fines to fill the voids in a compacted state. Place a horizontal layer of filter fabric as noted above when transitioning from rock backfill to finer grained backfill anywhere within the wall volume.

Prevent surface water or rainwater from damaging the retaining walls during construction. Shape the backfill to prevent water from ponding or flowing on the backfill or against the wall face. Remove and replace any portion of the retaining wall damaged or moved out of tolerance by erosion, sloughing, or saturation of the retaining wall or embankment backfill.

- F. Temporary MSE Walls.** Provide a facing system rigid enough to maintain a smooth and straight wall face both during and after construction.

Grade and compact the foundation for the structure as described in Section 423.3.E, “Permanent MSE Walls.”

Place earth reinforcement and facing system in accordance with the approved working drawings. Backfill the 2-ft. zone immediately behind the facing with clean coarse rock meeting the requirements of Coarse Aggregate Grade 1, 2, or 3 of Item 421, “Hydraulic Cement Concrete,” or of Type D backfill as described in Section 423.2.C.2, “Select.” Cement-stabilized backfill as described in Section 423.2.C.4, “Cement-Stabilized Backfill,” may be used in place of the coarse rock.

Place and compact backfill in accordance with the requirements of Section 423.3.E.

Construct walls to a vertical and horizontal alignment tolerance of 3 in. when measured along a 10 ft. straight edge. Construct walls to an overall vertical tolerance (plumbness from top to bottom) of 2 in. per 10 ft. of wall height. Place adjacent facing elements so that the maximum out-of-plane offset at any facing element joint is less than 1 in. Place facing elements and filter fabric with no gaps in the facing or fabric.

Prevent surface water or rainwater from damaging the retaining walls during and after construction. Place temporary berms or curbs, shape the backfill, or use other approved methods to prevent water from flowing against or over the wall face. Remove and replace any portion

423.4 to 423.4

of the wall damaged or moved out of tolerance by erosion, sloughing, or saturation of the retaining wall or embankment backfill.

- G. Concrete Block Retaining Walls.** The concrete block units may be sampled and tested by the Engineer prior to shipment or upon delivery to the construction site. Display for approval samples of block units indicating the color, texture, and finish. Store, transport, and handle all block units carefully to prevent cracking or damage.

Grade and compact the foundation for the structure, and place the leveling pad as described in Section 423.3.E, “Permanent MSE Walls.”

Place the concrete block facing units in accordance with the approved working drawings. Fill the voids within the units and fill the 1-ft. zone immediately behind the facing with drainage aggregate as described in Section 423.2.C.3, “Drainage Aggregate.” Systems tested without unit fill may omit the fill as indicated on the approved drawings. Systems with approved filter fabric details may omit the drainage aggregate in the 1-ft. zone immediately behind the facing.

For walls using earth reinforcements, place reinforcements and backfill in accordance with the requirements of Section 423.3.E. Pay particular attention to the connection details of the earth reinforcements to the concrete block units.

Construct walls to a vertical and horizontal alignment tolerance of 1-1/2 in. when measured along a 10-ft. straightedge. Construct walls to an overall vertical tolerance (deviation from the vertical or battered control line, top to bottom) of 1 in. per 10 ft. of wall height. Place adjacent facing elements so that the maximum out-of-plane offset at any facing element joint is less than 1 in. Place facing elements with maximum 1/4-in. gaps between block units.

Prevent surface water or rainwater from damaging the retaining walls during construction. Shape the backfill to prevent water from ponding or flowing on the backfill or against the wall face. Remove and replace all portions of the retaining wall damaged or moved out of tolerance by erosion, sloughing, or saturation of the retaining wall or embankment backfill.

423.4. Measurement. This Item will be measured by the square foot of the front surface area of the wall. Unless otherwise shown on the plans, the area will be measured from 1 ft. below finished grade of the ground line on the face of the exterior wall to the top of the wall including any coping required (not including railing).

This is a plans quantity measurement Item. The quantity to be paid is the quantity shown in the proposal unless modified by Article 9.2, "Plans Quantity Measurement." Additional measurements or calculations will be made if adjustments of quantities are required.

423.5. Payment. The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Retaining Walls" of the type or special surface finish specified. This price is full compensation for excavation in back of retaining walls and for footings; furnishing and placing footings, leveling pads, copings, and traffic railing foundations; furnishing, placing, and compacting backfill (except in embankment areas), including cement for stabilization; furnishing and placing concrete, reinforcing steel, waterproofing material, filter material and drain pipe, joint material, water stop, and filter fabric when required; fabricating, curing, and finishing all panels; furnishing and placing earth reinforcement, anchorage systems, and fasteners; wall erection; and equipment, labor, tools, and incidentals.

Retaining wall backfill areas that are also in embankment areas will be considered part of the quantities measured and paid for under Item 132, "Embankment."

When drilled shafts are required, they will be measured and paid for as specified in Item 416, "Drilled Shaft Foundations." When piling is required, it will be measured and paid for as specified in the plans for piling of the appropriate type.

ITEM 424

PRECAST CONCRETE STRUCTURES (FABRICATION)

424.1. Description. Fabricate precast prestressed and precast nonstressed concrete members. This Item, in conjunction with DMS-7300, "Precast Concrete Fabrication Plants," applies to both multi-project and project-specific fabrication plants. For this Item, the following definitions apply:

- **Prestressed Members.** Precast concrete members fabricated by the process of pretensioning or post-tensioning or a combination of both methods.
- **Nonstressed Members.** Precast concrete members that have not been pretensioned or post-tensioned.