SECTION 03 20 00 – ANCHORAGE IN CONCRETE

PART 1 - GENERAL

1.1 SUMMARY

A. This section includes the requirements for cast-in-place, mechanical, and adhesive anchors for concrete.

1.2 RELATED DOCUMENTS:

A. Drawings and general provisions of Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

B. Related work specified elsewhere includes:

1. Section 03 30 00 – Cast-in-Place Concrete
2. Division 26 – Electrical
3. Division 43 – Process Gas and Liquid Handling, Purification and Storage Equipment
4. Division 46 – Water and Wastewater Equipment

1.3 SUBMITTALS

A. Submit product information to the Engineer for approval in accordance with Section 013300.

PART 2 - PRODUCTS

2.1 WEDGE TYPE ANCHORS

A. Anchors shall feature a stainless-steel split expansion ring; a threaded stud body; and integral cone expander, nut and washer.

B. Anchor bodies smaller than 3/4 inch, excluding countersunk anchors, shall be made from AISI 316 and shall have the following minimum bolt fracture loads:

Anchor Diameter (in.)	Minimum Fracture Load (lb)
1/4	2,900
3/8	7,200
1/2	12,400
5/8	21,900

2.2 Anchor bodies 3/4 inch and larger, and all stainless-steel post nut anchor bodies, shall be made from AISI 316 stainless steel and shall have the following minimum mechanical properties:

Anchor Diameter (in.)	Min. Tensile Strength (ksi)	Min. Yield Strength (ksi)
≤5/8	90	76
≥3/4	76	64

A. All nuts shall meet the dimensional requirements of ASTM F 594.

B. Washers shall meet the dimensional requirements of ANSI B18.22.1, Type A, plain.

C. Expansion sleeve for anchors shall be made from AISI 316. All nuts and washers shall be made from AISI 316.

D. Anchor size and depth shall be as shown on drawings.

E. Manufacturers:

1. Trubolt as manufactured by ITW-Redhead, Inc.
2. Kwik Bolt 3 as manufactured by Hilti, Inc.
3. Or equal

2.3 ADHESIVE ANCHOR SYSTEM

A. Adhesive anchor system shall consist of an injectable two-part epoxy.

B. Application system shall be in accordance with manufacturer's recommendations. System shall keep the two components separated until application of product directly into drilled hole.

C. System shall thoroughly blend the two parts by means of a static mixer nozzle.

D. Injection adhesive shall be formulated to include resin and hardener to provide optimal curing speed as well as high strength and stiffness.

E. Anchor rods shall be as shown on drawings or as specified in other sections of these specifications.

1. Anchor rods shall be furnished with chamfered ends so that either end will accept a nut and washer.
2. Alternately, anchor rods shall be furnished with a 45° chisel point on one end to allow for easy insertion into the adhesive-filled hole.

F. Nuts and washers shall be provided for anchor rods in the same material as the anchor rod.

G. Manufactures

1. HIT RE 500 Epoxy Adhesive Anchor as manufactured by Hilti, Inc.

2. G5 Adhesive Anchoring System as manufactured by ITW-Redhead, Inc.
3. Or equal

2.4 CAST-IN-PLACE ANCHORS BOLTS

A. Cast-in-place anchors shall be made of corrosion resistant material in accordance with the dimensions shown on drawings.

1. As a minimum, provide A36 steel cast-in-place anchors.
2. If anchor bolt size is not shown on drawings, Contractor shall provide anchors capable of providing four (4) times the load applied to the bolt.

PART 3 - EXECUTION

3.1 INSTALLATION

A. Layout anchors before drilling into concrete to ensure proper placement. Following manufacturer's recommendation for spacing of anchors. Notify Engineer of conflicts between existing conditions and requirements by manufacturer.

B. Install anchors per manufacturer's recommendations.

C. Embedment length shall be per manufacturer's recommendations for load conditions.

D. Check all equipment anchors after equipment has operated. Retighten any loose anchors.

END OF SECTION 03 20 00

SECTION 03 30 00 - CAST-IN-PLACE CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section includes cast-in-place concrete, including formwork, reinforcement, concrete materials, mixture design, placement procedures, and finishes.

B. Related Requirements:

1. Section 03 39 00 – Concrete Curing
2. Division 31 – Earthwork

1.3 DEFINITIONS

A. Cementitious Materials: Portland cement alone or in combination with one or more of the following: blended hydraulic cement, fly ash, slag cement, other pozzolans, and silica fume; materials subject to compliance with requirements.

B. W/C Ratio: The ratio by weight of water to cementitious materials.

1.4 PREINSTALLATION MEETINGS

A. Preinstallation Conference: Conduct conference at Project site.

1. Before submitting design mixtures, review concrete design mixture and examine procedures for ensuring quality of concrete materials. Require representatives of each entity directly concerned with cast-in-place concrete to attend, including the following:

    a. Contractor's superintendent.
    b. Independent testing agency responsible for concrete design mixtures.
    c. Ready-mix concrete manufacturer.
    d. Concrete Subcontractor.
    e. Special concrete finish Subcontractor.

2. Review special inspection and testing and inspecting agency procedures for field quality control, concrete finishes and finishing, cold- and hot-weather concreting procedures, curing procedures, construction contraction and isolation joints, and joint-filler strips, vapor-retarder installation, steel reinforcement installation, methods for achieving

specified floor and slab flatness and levelness concrete repair procedures, and concrete protection.

1.5 ACTION SUBMITTALS

A. Product Data: For each type of product.

B. Design Mixtures: For each concrete mixture. Submit alternate design mixtures when characteristics of materials, Project conditions, weather, test results, or other circumstances warrant adjustments.

1. Indicate amounts of mixing water to be withheld for later addition at Project site.

C. Steel Reinforcement Shop Drawings: Placing Drawings that detail fabrication, bending, and placement. Include bar sizes, lengths, material, grade, bar schedules, stirrup spacing, bent bar diagrams, bar arrangement, splices and laps, mechanical connections, tie spacing, hoop spacing, and supports for concrete reinforcement.

D. Construction Joint Layout: Indicate proposed construction joints required to construct the structure.

1. Location of construction joints is subject to approval of the Engineer.

E. Samples: For color finishes, normal weight aggregates, fiber reinforcement, reglets, waterstops, vapor retarder/barrier, and form liners.

1.6 INFORMATIONAL SUBMITTALS

A. Qualification Data: For Installer and testing agency.

B. Material Certificates: For each of the following, signed by manufacturers:

1. Cementitious materials.
2. Admixtures.
3. Form materials and form-release agents.
4. Steel reinforcement and accessories.
5. Waterstops.
6. Curing compounds.
7. Floor and slab treatments.
8. Bonding agents.
9. Adhesives.
10. Vapor retarders.
11. Semi-rigid joint filler.
12. Joint-filler strips.
13. Repair materials.

C. Material Test Reports: From a qualified testing agency.

D. Formwork Shop Drawings: Prepared by or under the supervision of a qualified professional engineer. Placing drawings indicating fabrication and erection of forms for specific finished concrete surfaces. Show form construction including jointing, special form joints or reveals, location and pattern of form tie placement, and other items that affect exposed concrete visually.

1. Shoring and Reshoring: Indicate proposed schedule and sequence of stripping formwork, shoring removal, and reshoring installation and removal.

E. Floor surface flatness and levelness measurements indicating compliance with specified tolerances.

F. Field quality-control reports.

G. Minutes of preinstallation conference.

1.7 QUALITY ASSURANCE

A. Installer Qualifications: A qualified installer who employs on Project personnel qualified as ACI-certified Flatwork Technician and Finisher and a supervisor who is an ACI-certified Concrete Flatwork Technician.

B. Manufacturer Qualifications: A firm experienced in manufacturing ready-mixed concrete products and that complies with ASTM C 94/C 94M requirements for production facilities and equipment.

1. Manufacturer certified according to NRMCA's "Certification of Ready Mixed Concrete Production Facilities."

C. Testing Agency Qualifications: Acceptable to authorities having jurisdiction**,** qualified according to ASTM C 1077 and ASTM E 329 for testing indicated.

1. Personnel conducting field tests shall be qualified as ACI Concrete Field Testing Technician, Grade 1, according to ACI CP-1 or an equivalent certification program.
2. Personnel performing laboratory tests shall be ACI-certified Concrete Strength Testing Technician and Concrete Laboratory Testing Technician, Grade I. Testing agency laboratory supervisor shall be an ACI-certified Concrete Laboratory Testing Technician, Grade II.

1.8 DELIVERY, STORAGE, AND HANDLING

A. Steel Reinforcement: Deliver, store, and handle steel reinforcement to prevent bending and damage. Avoid damaging coatings on steel reinforcement.

B. Waterstops: Store waterstops under cover to protect from moisture, sunlight, dirt, oil, and other contaminants.

1.9 FIELD CONDITIONS

A. Cold-Weather Placement: Comply with ACI 306.1 and as follows. Protect concrete work from physical damage or reduced strength that could be caused by frost, freezing actions, or low temperatures.

1. When average high and low temperature is expected to fall below 40 deg F for three successive days, maintain delivered concrete mixture temperature within the temperature range required by ACI 301.
2. Do not use frozen materials or materials containing ice or snow. Do not place concrete on frozen subgrade or on subgrade containing frozen materials.
3. Do not use calcium chloride, salt, or other materials containing antifreeze agents or chemical accelerators unless otherwise specified and approved in mixture designs.

B. Hot-Weather Placement: Comply with ACI 301 and as follows:
1. Maintain average concrete temperature below 90 deg F at time of placement. Maximum concrete temperature at time of placement shall be 95 deg F. Chilled mixing water or chopped ice may be used to control temperature, provided water equivalent of ice is calculated to total amount of mixing water. Using liquid nitrogen to cool concrete is Contractor's option.
2. Fog-spray forms, steel reinforcement, and subgrade just before placing concrete. Keep subgrade uniformly moist without standing water, soft spots, or dry areas.

PART 2 - PRODUCTS

2.1 CONCRETE, GENERAL

A. ACI Publications: Comply with the following unless modified by requirements in the Contract Documents:

1. ACI 301.
2. ACI 117.
3. ACI 350.
4. ACI 308.

2.2 FORM-FACING MATERIALS

A. Smooth-Formed Finished Concrete: Form-facing panels that provide continuous, true, and smooth concrete surfaces. Furnish in largest practicable sizes to minimize number of joints.

1. Plywood, metal, or other approved panel materials.
2. Exterior-grade plywood panels, suitable for concrete forms, complying with DOC PS 1, and as follows:

a. High-density overlay, Class 1 or better.
b. B-B (Concrete Form), Class 1 or better; mill oiled and edge sealed.

3. Overlaid Finnish birch plywood.

B. Rough-Formed Finished Concrete: Plywood, lumber, metal, or another approved material. Provide lumber dressed on at least two edges and one side for tight fit.

C. Forms for Cylindrical Columns, Pedestals, and Supports: Metal, glass-fiber-reinforced plastic, paper, or fiber tubes that produce surfaces with gradual or abrupt irregularities not exceeding specified formwork surface class. Provide units with sufficient wall thickness to resist plastic concrete loads without detrimental deformation.

D. Pan-Type Forms: Glass-fiber-reinforced plastic or formed steel, stiffened to resist plastic concrete loads without detrimental deformation.

E. Void (Carton) Forms: Biodegradable paper surface, treated for moisture resistance, structurally sufficient to support weight of plastic concrete and other superimposed loads.

F. Chamfer Strips: Wood, metal, PVC, or rubber strips, 3/4 by 3/4 inch, minimum.

G. Rustication Strips: Wood, metal, PVC, or rubber strips, kerfed for ease of form removal.

H. Form-Release Agent: Commercially formulated (maximum VOC content of 350 mg/L) form-release agent that does not bond with, stain, or adversely affect concrete surfaces and does not impair subsequent treatments of concrete surfaces.

1. Formulate form-release agent with rust inhibitor for steel form-facing materials.

I. Form Ties: Factory-fabricated, removable or snap-off glass-fiber-reinforced plastic or metal form ties designed to resist lateral pressure of fresh concrete on forms and to prevent spalling of concrete on removal.

1. Furnish ties that, when removed, leave holes no larger than 1 inch in diameter in concrete surface.

2.3 STEEL REINFORCEMENT

A. Reinforcing Bars: ASTM A 615/A 615M, Grade 60, deformed.

B. Steel Bar Mats: ASTM A 184/A 184M, fabricated from ASTM A 615/A 615M, Grade 60, deformed bars, assembled with clips.

C. Plain-Steel Wire: ASTM A 1064/A 1064M, as drawn.

D. Deformed-Steel Wire: ASTM A 1064/A 1064M.

E. Plain-Steel Welded-Wire Reinforcement: ASTM A 1064/A 1064M, plain, fabricated from as-drawn steel wire into flat sheets.

F. Deformed-Steel Welded-Wire Reinforcement: ASTM A 1064/A 1064M, flat sheet.

G. Galvanized-Steel Welded-Wire Reinforcement: ASTM A 1064/A 1064M, plain, fabricated from galvanized-steel wire into flat sheets.

2.4 REINFORCEMENT ACCESSORIES

A. Joint Dowel Bars: ASTM A 615/A 615M, Grade 60, plain-steel bars, cut true to length with ends square and free of burrs.

B. Zinc Repair Material: ASTM A 780/A 780M.

C. Bar Supports: Bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded-wire reinforcement in place. Manufacture bar supports from steel wire, plastic, or precast concrete according to CRSI's "Manual of Standard Practice," of greater compressive strength than concrete and as follows:

1. For concrete surfaces exposed to view, where legs of wire bar supports contact forms, use CRSI Class 1 plastic-protected steel wire or CRSI Class 2 stainless-steel bar supports.
2. For slabs-on-grade, use supports with sand plates or horizontal runners where base material will not support chair legs.

2.5 CONCRETE MATERIALS

A. Source Limitations: Obtain each type or class of cementitious material of the same brand from the same manufacturer's plant, obtain aggregate from single source, and obtain admixtures from single source from single manufacturer.

B. Cementitious Materials:

1. Portland Cement: ASTM C 150/C 150M, Type I or Type II.

a. The cement shall be low alkali, less than 0.60 percent. All cement used in concrete that will be in contact with wastewater shall have a tricalcium aluminate ($Ca_3Al_2O_6$) content of less than 8 percent.
b. Use one brand of cement throughout the Project unless otherwise acceptable to the Engineer.

2. Fly Ash: ASTM C 618, Class F or C.

C. Normal-Weight Aggregates: ASTM C 33/C 33M, coarse aggregate or better, graded. Provide aggregates from a single source with documented service record data of at least 10 years' satisfactory service in similar applications and service conditions using similar aggregates and cementitious materials. Normal weight river gravel and natural sand are acceptable for use as aggregate materials in concrete. All normal weight aggregates shall conform to ASTM C33.

1. Maximum Coarse-Aggregate Size: 1-1/2 inches nominal.

D. Lightweight Aggregate: ASTM C 330/C 330M, 1-inch-nominal maximum aggregate size.

E. Air-Entraining Admixture: ASTM C 260/C 260M.

F. Chemical Admixtures: Certified by manufacturer to be compatible with other admixtures and that do not contribute water-soluble chloride ions exceeding those permitted in hardened concrete. Do not use calcium chloride or admixtures containing calcium chloride.

1. Water-Reducing Admixture: ASTM C 494/C 494M, Type A.
2. Retarding Admixture: ASTM C 494/C 494M, Type B.
3. Water-Reducing and Retarding Admixture: ASTM C 494/C 494M, Type D.
4. High-Range, Water-Reducing Admixture: ASTM C 494/C 494M, Type F.
5. High-Range, Water-Reducing and Retarding Admixture: ASTM C 494/C 494M, Type G.
6. Plasticizing and Retarding Admixture: ASTM C 1017/C 1017M, Type II.

G. Water: ASTM C 94/C 94M and potable.

2.6 FIBER REINFORCEMENT

A. Synthetic Micro-Fiber: Monofilament polypropylene micro-fibers engineered and designed for use in concrete, complying with ASTM C 1116/C 1116M, Type III, 1/2 to 1-1/2 inches long.

B. Synthetic Micro-Fiber: Fibrillated polypropylene micro-fibers engineered and designed for use in concrete, complying with ASTM C 1116/C 1116M, Type III, 1/2 to 1-1/2 inches long.

2.7 WATERSTOPS

A. Flexible Rubber Waterstops: CE CRD-C 513, for embedding in concrete to prevent passage of fluids through joints. Factory fabricated corners, intersections, and directional changes.

1. Manufacturers: Subject to compliance with requirements, provide products by the following:
   a. Sika Greenstreak
   b. Williams Products, Inc.
   c. JP Specialties, Inc.
   d. Or approved equal.

2. Profile: Ribbed with center bulb and/or Ribbed without center bulb.

3. Dimensions: 6 inches by 3/8 inch thick; nontapered.

B. Flexible PVC Waterstops: CE CRD-C 572, for embedding in concrete to prevent passage of fluids through joints. Factory fabricated corners, intersections, and directional changes.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

   a. BoMetals, Inc.
   b. Sika Greenstreak.
   c. JP Specialties, Inc.

d. Or approved equal.

2. Profile: Ribbed with center bulb and/or Ribbed without center bulb.

3. Dimensions: 6 inches by 3/8 inch thick; nontapered.

C. Self-Expanding Butyl Strip Waterstops: Manufactured rectangular or trapezoidal strip, butyl rubber with sodium bentonite or other hydrophilic polymers, for adhesive bonding to concrete, 3/4 by 1 inch.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. Barrier-Bac; Inteplast Group, Ltd.
b. JP Specialties, Inc.
c. Sika Greenstreak.
d. Or approved equal.

D. Self-Expanding Rubber Strip Waterstops: Manufactured rectangular or trapezoidal strip, bentonite-free hydrophilic polymer-modified chloroprene rubber, for adhesive bonding to concrete, 3/8 by 3/4 inch.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. Adeka Ultra Seal/OCM, Inc.
b. Sika Greenstreak.
c. Or approved equal.

2.8 VAPOR RETARDERS

A. Sheet Vapor Retarder: Polyethylene sheet, ASTM D 4397, not less than 10 mils thick.

2.9 FLOOR AND SLAB TREATMENTS

2.10 CURING MATERIALS

A. Evaporation Retarder: Waterborne, monomolecular film forming, manufactured for application to fresh concrete.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. BASF Corporation; Construction Systems.
b. Euclid Chemical Company (The); an RPM company.
c. Kaufman Products, Inc.
d. Sika Corporation.

e. SpecChem, LLC.
f. Or approved equal.

B. Absorptive Cover: AASHTO M 182, Class 2, burlap cloth made from jute or kenaf, weighing approximately 9 oz./sq. yd. when dry.

C. Moisture-Retaining Cover: ASTM C 171, polyethylene film or white burlap-polyethylene sheet.

D. Water: Potable.

E. Clear, Waterborne, Membrane-Forming Curing Compound: ASTM C 309, Type 1, Class B, dissipating.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. BASF Corporation; Construction Systems.
b. Euclid Chemical Company (The); an RPM company.
c. W. R. Meadows, Inc.
d. Or approved equal.

F. Clear, Waterborne, Membrane-Forming Curing Compound: ASTM C 309, Type 1, Class B, nondissipating, certified by curing compound manufacturer to not interfere with bonding of floor covering.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. BASF Corporation; Construction Systems.
b. Euclid Chemical Company (The); an RPM company.
c. L&M Construction Chemicals, Inc.
d. TK Products.
e. Or approved equal.

G. Clear, Waterborne, Membrane-Forming Curing Compound: ASTM C 309, Type 1, Class B, 18 to 25 percent solids, nondissipating, certified by curing compound manufacturer to not interfere with bonding of floor covering.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. BASF Corporation; Construction Systems.
b. Dayton Superior.
c. Euclid Chemical Company (The); an RPM company.
d. L&M Construction Chemicals, Inc.
e. W. R. Meadows, Inc.
f. Or approved equal.

H. Clear, Solvent-Borne, Membrane-Forming Curing and Sealing Compound: ASTM C 1315, Type 1, Class A.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

    a. BASF Corporation; Construction Systems.
    b. Dayton Superior.
    c. Euclid Chemical Company (The); an RPM company.
    d. L&M Construction Chemicals, Inc.
    e. W. R. Meadows, Inc.
    f. Or approved equal.

I. Clear, Waterborne, Membrane-Forming Curing and Sealing Compound: ASTM C 1315, Type 1, Class A.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

    a. Dayton Superior.
    b. Euclid Chemical Company (The); an RPM company.
    c. L&M Construction Chemicals, Inc.
    d. W. R. Meadows, Inc.
    e. Or approved equal.

2.11 RELATED MATERIALS

A. Expansion- and Isolation-Joint-Filler Strips: ASTM D 1751, asphalt-saturated cellulosic fiber.

B. Semirigid Joint Filler: Two-component, semirigid, 100 percent solids, epoxy resin with a Type A shore durometer hardness of 80 according to ASTM D 2240.

C. Bonding Agent: ASTM C 1059/C 1059M, Type II, nonredispersible, acrylic emulsion or styrene butadiene.

D. Epoxy Bonding Adhesive: ASTM C 881, two-component epoxy resin, capable of humid curing and bonding to damp surfaces, of class suitable for application temperature and of grade to suit requirements, and as follows:

1. Types I and II, nonload bearing or Types IV and V, load bearing, for bonding hardened or freshly mixed concrete to hardened concrete.

E. Reglets: Fabricate reglets of not less than 0.022-inch-thick, galvanized-steel sheet. Temporarily fill or cover face opening of reglet to prevent intrusion of concrete or debris.

F. Dovetail Anchor Slots: Hot-dip galvanized-steel sheet, not less than 0.034 inch thick, with bent tab anchors. Temporarily fill or cover face opening of slots to prevent intrusion of concrete or debris.

2.12 REPAIR MATERIALS

A. Repair Overlayment: Cement-based, polymer-modified, self-leveling product that can be applied in thicknesses from 1/4 inch and that can be filled in over a scarified surface to match adjacent floor elevations.

1. Cement Binder: ASTM C 150/C 150M, portland cement or hydraulic or blended hydraulic cement as defined in ASTM C 219.
2. Primer: Product of topping manufacturer recommended for substrate, conditions, and application.
3. Aggregate: Well-graded, washed gravel, 1/8 to 1/4 inch or coarse sand as recommended by topping manufacturer.
4. Compressive Strength: Not less than 5000 psi at 28 days when tested according to ASTM C 109/C 109M.

2.13 CONCRETE MIXTURES, GENERAL

A. Prepare design mixtures for each type and strength of concrete, proportioned on the basis of laboratory trial mixture or field test data, or both, according to ACI 301.

1. Use a qualified independent testing agency for preparing and reporting proposed mixture designs based on laboratory trial mixtures.

B. Cementitious Materials: Limit percentage, by weight, of cementitious materials other than portland cement in concrete as follows:

1. Fly Ash: 25 percent.
2. Combined Fly Ash and Pozzolan: 25 percent.
3. Slag Cement: 50 percent.
4. Combined Fly Ash or Pozzolan and Slag Cement: 50 percent portland cement minimum, with fly ash or pozzolan not exceeding 25 percent.
5. Silica Fume: 10 percent.
6. Combined Fly Ash, Pozzolans, and Silica Fume: 35 percent with fly ash or pozzolans not exceeding 25 percent and silica fume not exceeding 10 percent.
7. Combined Fly Ash or Pozzolans, Slag Cement, and Silica Fume: 50 percent with fly ash or pozzolans not exceeding 25 percent and silica fume not exceeding 10 percent.

C. Limit water-soluble, chloride-ion content in hardened concrete to 0.10 percent by weight of cement.

D. Admixtures: Use admixtures according to manufacturer's written instructions.

1. Use water-reducing, high-range water-reducing or plasticizing admixture in concrete, as required, for placement and workability.
2. Use water-reducing and -retarding admixture when required by high temperatures, low humidity, or other adverse placement conditions.
3. Use water-reducing admixture in pumped concrete, concrete for heavy-use industrial slabs and parking structure slabs, concrete required to be watertight, and concrete with a w/c ratio below 0.50.

2.14 CONCRETE MIXTURES FOR BUILDING ELEMENTS

A. Footings: Normal-weight concrete.

1. Minimum Compressive Strength: -As indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.55.
3. Slump Limit: 3 inches. 8 inches for concrete with verified slump of 2 to 4 inches before adding high-range water-reducing admixture or plasticizing admixture, plus or minus 1 inch.
4. Air Content: 5.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.
5. Air Content: 6 percent, plus or minus 1.5 percent at point of delivery for 1-inch nominal maximum aggregate size.

B. Foundation Walls: Normal-weight concrete.

1. Minimum Compressive Strength: As indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.50
3. Slump Limit: 3 inches. 8 inches for concrete with verified slump of 2 to 4 inches before adding high-range water-reducing admixture or plasticizing admixture plus or minus 1 inch.
4. Air Content: 5.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.
5. Air Content: 6 percent, plus or minus 1.5 percent at point of delivery for 1-inch nominal maximum aggregate size.

C. Slabs-on-Grade: Normal-weight concrete.

1. Minimum Compressive Strength: As indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.50
3. Minimum Cementitious Materials Content: 470 lb/cu. yd.
4. Slump Limit: 3 inches, plus or minus 1 inch.
5. Air Content: 5.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.
6. Air Content: 6 percent, plus or minus 1.5 percent at point of delivery for 1-inch nominal maximum aggregate size.
7. Air Content: Do not allow air content of trowel-finished floors to exceed 3 percent.
8. Maximum W/C Ratio: 0.50.

D. Suspended Slabs: Normal-weight concrete.

1. Minimum Compressive Strength: A**s** indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.50.
3. Minimum Cementitious Materials Content: 470 lb/cu. yd.
4. Slump Limit: 3 inches, plus or minus 1 inch.
5. Air Content: 4 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.
6. Air Content: –4.5 percent, plus or minus 1.5 percent at point of delivery for 1-inch nominal maximum aggregate size.
7. Air Content: Do not allow air content of trowel-finished floors to exceed 3 percent.

8. Maximum W/C Ratio: 0.50.

E. Water Retaining Structures.

1. Minimum Compressive Strength: A**s** indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.45.
3. Minimum Cementitious Materials Content: 535 lb/cu. yd.
4. Slump Limit: 4 inches, plus or minus 1 inch.
5. Air Content: 4.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.
6. Air Content: 4.5 percent, plus or minus 1.5 percent at point of delivery for 1-inch nominal maximum aggregate size.

F. Concrete Toppings: Normal-weight concrete.

1. Minimum Compressive Strength: As indicated in Structural General Notes at 28 days.
2. Minimum Cementitious Materials Content: 600 lb/cu. yd.
3. Slump Limit: 3 inches, plus or minus 1 inch.
4. Air Content: 5.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.
5. Air Content: Do not allow air content of trowel-finished toppings to exceed 3 percent.
6. Steel-Fiber Reinforcement: Add to concrete mixture, according to manufacturer's written instructions, at a rate of 50 lb/cu. yd.
7. Synthetic Micro-Fiber: Uniformly disperse in concrete mixture at manufacturer's recommended rate, but not less than a rate of 1.5 lb/cu. yd.

G. Building Frame Members: Normal-weight concrete.

1. Minimum Compressive Strength: As indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.50.
3. Slump Limit: 4 inches. 8 inches for concrete with verified slump of 2 to 4 inches before adding high-range water-reducing admixture or plasticizing admixture, plus or minus 1 inch.
4. Air Content: 4.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.

H. Building Walls: Normal-weight concrete.

1. Minimum Compressive Strength: As indicated in Structural General Notes at 28 days.
2. Maximum W/C Ratio: 0.50.
3. Slump Limit: 4 inches. 8 inches for concrete with verified slump of 2 to 4 inches before adding high-range water-reducing admixture or plasticizing admixture, plus or minus 1 inch.
4. Air Content: 5.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.

2.15 FABRICATING REINFORCEMENT

A. Fabricate steel reinforcement according to CRSI's "Manual of Standard Practice."

2.16 CONCRETE MIXING

A. Ready-Mixed Concrete: Measure, batch, mix, and deliver concrete according to ASTM C 94/C 94M and ASTM C 1116/C 1116M, and furnish batch ticket information.

1. When air temperature is between 85 and 90 deg F, reduce mixing and delivery time from 1-1/2 hours to 75 minutes; when air temperature is above 90 deg F, reduce mixing and delivery time to 60 minutes.

B. Project-Site Mixing: Measure, batch, and mix concrete materials and concrete according to ASTM C 94/C 94M. Mix concrete materials in appropriate drum-type batch machine mixer.

1. For mixer capacity of 1 cu. yd. or smaller, continue mixing at least 1-1/2 minutes, but not more than 5 minutes after ingredients are in mixer, before any part of batch is released.
2. For mixer capacity larger than 1 cu. yd., increase mixing time by 15 seconds for each additional 1 cu. yd.
3. Provide batch ticket for each batch discharged and used in the Work, indicating Project identification name and number, date, mixture type, mixture time, quantity, and amount of water added. Record approximate location of final deposit in structure.

PART 3 - EXECUTION

3.1 FORMWORK INSTALLATION

A. Design, erect, shore, brace, and maintain formwork, according to ACI 301, to support vertical, lateral, static, and dynamic loads, and construction loads that might be applied, until structure can support such loads.

B. Construct formwork so concrete members and structures are of size, shape, alignment, elevation, and position indicated, within tolerance limits of ACI 117.

C. Limit concrete surface irregularities, designated by ACI 347 as abrupt or gradual, as follows:

1. Class A, 1/8 inch for smooth-formed finished surfaces.
2. Class B, 1/4 inch for rough-formed finished surfaces.

D. Construct forms tight enough to prevent loss of concrete mortar.

E. Construct forms for easy removal without hammering or prying against concrete surfaces. Provide crush or wrecking plates where stripping may damage cast-concrete surfaces. Provide top forms for inclined surfaces steeper than 1.5 horizontal to 1 vertical.

1. Install keyways, reglets, recesses, and the like, for easy removal.
2. Do not use rust-stained steel form-facing material.

F. Set edge forms, bulkheads, and intermediate screed strips for slabs to achieve required elevations and slopes in finished concrete surfaces. Provide and secure units to support screed strips; use strike-off templates or compacting-type screeds.

G. Provide temporary openings for cleanouts and inspection ports where interior area of formwork is inaccessible. Close openings with panels tightly fitted to forms and securely braced to prevent loss of concrete mortar. Locate temporary openings in forms at inconspicuous locations.

H. Chamfer exterior corners and edges of permanently exposed concrete.

I. Form openings, chases, offsets, sinkages, keyways, reglets, blocking, screeds, and bulkheads required in the Work. Determine sizes and locations from trades providing such items.

J. Clean forms and adjacent surfaces to receive concrete. Remove chips, wood, sawdust, dirt, and other debris just before placing concrete.

K. Retighten forms and bracing before placing concrete, as required, to prevent mortar leaks and maintain proper alignment.

L. Coat contact surfaces of forms with form-release agent, according to manufacturer's written instructions, before placing reinforcement.

3.2 EMBEDDED ITEM INSTALLATION

A. Place and secure anchorage devices and other embedded items required for adjoining work that is attached to or supported by cast-in-place concrete. Use setting drawings, templates, diagrams, instructions, and directions furnished with items to be embedded.

1. Install anchor rods, accurately located, to elevations required and complying with tolerances in Section 7.5 of AISC 303.

3.3 REMOVING AND REUSING FORMS

A. General: Formwork for sides of beams, walls, columns, and similar parts of the Work that does not support weight of concrete may be removed after cumulatively curing at not less than 50 deg F for 48 hours after placing concrete with a 72 hour pour back for adjacent pours. Concrete has to be hard enough to not be damaged by form-removal operations, and curing and protection operations need to be maintained.

1. Leave formwork for beam soffits, joists, slabs, and other structural elements that support weight of concrete in place until concrete has achieved at least 70 percent of its 28-day design compressive strength.
2. Remove forms only if shores have been arranged to permit removal of forms without loosening or disturbing shores.

B. Clean and repair surfaces of forms to be reused in the Work. Split, frayed, delaminated, or otherwise damaged form-facing material are not acceptable for exposed surfaces. Apply new form-release agent.

C. When forms are reused, clean surfaces, remove fins and laitance, and tighten to close joints. Align and secure joints to avoid offsets. Do not use patched forms for exposed concrete surfaces unless approved by Engineer.

3.4 SHORING AND RESHORING INSTALLATION

A. Comply with ACI 318 and ACI 301 for design, installation, and removal of shoring and reshoring.

1. Do not remove shoring or reshoring until measurement of slab tolerances is complete.

B. In multistory construction, extend shoring or reshoring over a sufficient number of stories to distribute loads in such a manner that no floor or member will be excessively loaded or will induce tensile stress in concrete members without sufficient steel reinforcement.

C. Plan sequence of removal of shores and reshore to avoid damage to concrete. Locate and provide adequate reshoring to support construction without excessive stress or deflection.

3.5 VAPOR-RETARDER INSTALLATION

A. Sheet Vapor Retarders: Place, protect, and repair sheet vapor retarder according to ASTM E 1643 and manufacturer's written instructions.

1. Lap joints 6 inches and seal with manufacturer's recommended tape.

B. Bituminous Vapor Retarders: Place, protect, and repair bituminous vapor retarder according to manufacturer's written instructions.

3.6 STEEL REINFORCEMENT INSTALLATION

A. General: Comply with CRSI's "Manual of Standard Practice" for fabricating, placing, and supporting reinforcement.

1. Do not cut or puncture vapor retarder. Repair damage and reseal vapor retarder before placing concrete.

B. Clean reinforcement of loose rust and mill scale, earth, ice, and other foreign materials that reduce bond to concrete.

C. Accurately position, support, and secure reinforcement against displacement. Locate and support reinforcement with bar supports to maintain minimum concrete cover. Do not tack weld crossing reinforcing bars.

D. Set wire ties with ends directed into concrete, not toward exposed concrete surfaces.

E. Install welded-wire reinforcement in longest practicable lengths on bar supports spaced to minimize sagging. Lap edges and ends of adjoining sheets at least one mesh spacing. Offset laps of adjoining sheet widths to prevent continuous laps in either direction. Lace overlaps with wire.

3.7 JOINTS

A. General: Construct joints true to line with faces perpendicular to surface plane of concrete.

B. Construction Joints: Install so strength and appearance of concrete are not impaired, at locations indicated or as approved by Engineer.

1. Place joints perpendicular to main reinforcement. Continue reinforcement across construction joints unless otherwise indicated. Do not continue reinforcement through sides of strip placements of floors and slabs.
2. Form keyed joints as indicated. Embed keys at least 1-1/2 inches into concrete.
3. Locate joints for beams, slabs, joists, and girders in the middle third of spans. Offset joints in girders a minimum distance of twice the beam width from a beam-girder intersection.
4. Locate horizontal joints in walls and columns at underside of floors, slabs, beams, and girders and at the top of footings or floor slabs.
5. Space vertical joints in walls as indicated on Contractor's submitted and approved construction joint layout. Locate joints beside piers integral with walls, near corners, and in concealed locations where possible.
6. Use a bonding agent at locations where fresh concrete is placed against hardened or partially hardened concrete surfaces.

C. Contraction Joints in Slabs-on-Grade: Form weakened-plane contraction joints, sectioning concrete into areas as indicated. Construct contraction joints for a depth equal to at least one-fourth of concrete thickness as follows:

1. Grooved Joints: Form contraction joints after initial floating by grooving and finishing each edge of joint to a radius of 1/8 inch. Repeat grooving of contraction joints after applying surface finishes. Eliminate groover tool marks on concrete surfaces.
2. Sawed Joints: Form contraction joints with power saws equipped with shatterproof abrasive or diamond-rimmed blades. Cut 1/8-inch-wide joints into concrete as soon as cutting action does not tear, abrade, or otherwise damage surface and before concrete develops random contraction cracks.

D. Isolation Joints in Slabs-on-Grade: After removing formwork, install joint-filler strips at slab junctions with vertical surfaces, such as column pedestals, foundation walls, grade beams, and other locations, as indicated.

1. Extend joint-filler strips full width and depth of joint, terminating flush with finished concrete surface unless otherwise indicated.
2. Install joint-filler strips in lengths as long as practicable. Where more than one length is required, lace or clip sections together.

E. Doweled Joints: Install dowel bars and support assemblies at joints where indicated. Lubricate or asphalt coat one-half of dowel length to prevent concrete bonding to one side of joint.

3.8 WATERSTOP INSTALLATION

A. Flexible Waterstops: Install in construction joints and at other joints indicated to form a continuous diaphragm. Install in longest lengths practicable. Support and protect exposed waterstops during progress of the Work. Field fabricated joints in waterstops according to manufacturer's written instructions.

3.9 CONCRETE PLACEMENT

A. Before placing concrete, verify that installation of formwork, reinforcement, and embedded items is complete and that required inspections are completed.

B. Do not add water to concrete during delivery, at Project site, or during placement unless approved by Engineer.

C. Before test sampling and placing concrete, water may be added at Project site, subject to limitations of ACI 301.

1. Do not add water to concrete after adding high-range water-reducing admixtures to mixture.

D. Deposit concrete continuously in one layer or in horizontal layers of such thickness that no new concrete is placed on concrete that has hardened enough to cause seams or planes of weakness. If a section cannot be placed continuously, provide construction joints as indicated. Deposit concrete to avoid segregation.

1. Deposit concrete in horizontal layers of depth not to exceed formwork design pressures and in a manner to avoid inclined construction joints.
2. Consolidate placed concrete with mechanical vibrating equipment according to ACI 301.
3. Do not use vibrators to transport concrete inside forms. Insert and withdraw vibrators vertically at uniformly spaced locations to rapidly penetrate placed layer and at least 6 inches into preceding layer. Do not insert vibrators into lower layers of concrete that have begun to lose plasticity. At each insertion, limit duration of vibration to time necessary to consolidate concrete and complete embedment of reinforcement and other embedded items without causing mixture constituents to segregate.

E. Deposit and consolidate concrete for floors and slabs in a continuous operation, within limits of construction joints, until placement of a panel or section is complete.

1. Consolidate concrete during placement operations, so concrete is thoroughly worked around reinforcement and other embedded items and into corners.
2. Maintain reinforcement in position on chairs during concrete placement.
3. Screed slab surfaces with a straightedge and strike off to correct elevations.
4. Slope surfaces uniformly to drains where required.
5. Begin initial floating using bull floats or darbies to form a uniform and open-textured surface plane, before excess bleedwater appears on the surface. Do not further disturb slab surfaces before starting finishing operations.

3.10 FINISHING FORMED SURFACES

A. Rough-Formed Finish: As-cast concrete texture imparted by form-facing material with tie holes and defects repaired and patched. Remove fins and other projections that exceed specified limits on formed-surface irregularities.

1. N/A.

B. Smooth-Formed Finish: As-cast concrete texture imparted by form-facing material, arranged in an orderly and symmetrical manner with a minimum of seams. Repair and patch tie holes and defects. Remove fins and other projections that exceed specified limits on formed-surface irregularities.

1. Apply to concrete surfaces exposed not exposed to public view.

C. Rubbed Finish: Apply the following to smooth-formed-finished as-cast concrete where indicated:

1. Smooth-Rubbed Finish: Apply to the top of exposed concrete walls and the outside exposed face to 1' below grade on all new concrete structures and new concrete additions.

D. Related Unformed Surfaces: At tops of walls, horizontal offsets, and similar unformed surfaces adjacent to formed surfaces, strike off smooth and finish with a texture matching adjacent formed surfaces. Continue final surface treatment of formed surfaces uniformly across adjacent unformed surfaces unless otherwise indicated.

3.11 FINISHING FLOORS AND SLABS

A. General: Comply with ACI 302.1R recommendations for screeding, restraightening, and finishing operations for concrete surfaces. Do not wet concrete surfaces.

B. Trowel Finish: After applying float finish, apply first troweling and consolidate concrete by hand or power-driven trowel. Continue troweling passes and restraighten until surface is free of trowel marks and uniform in texture and appearance. Grind smooth any surface defects that would telegraph through applied coatings or floor coverings.

1. Apply a trowel finish to surfaces-exposed to view or to be covered with resilient flooring, carpet, ceramic or quarry tile set over a cleavage membrane, paint, or another thin-film-finish coating system.
2. Finish surfaces to the following tolerances, according to ASTM E 1155, for a randomly trafficked floor surface:

    a. Specified overall values of flatness, F(F) 35; and of levelness, F(L) 25; with minimum local values of flatness, F(F) 24; and of levelness, F(L) 17; for slabs-on-grade.
    b. Specified overall values of flatness, F(F) 30; and of levelness, F(L) 20; with minimum local values of flatness, F(F) 24; and of levelness, F(L) 15; for suspended slabs.

C. Trowel and Fine-Broom Finish: Apply a first trowel finish to surfaces-where ceramic or quarry tile is to be installed by either thickset or thinset method. While concrete is still plastic, slightly scarify surface with a fine broom.

1. Comply with flatness and levelness tolerances for trowel-finished floor surfaces.

D. Broom Finish: Apply a broom finish to exterior concrete platforms, steps, ramps, and elsewhere as indicated.

1. Immediately after float finishing, slightly roughen trafficked surface by brooming with fiber-bristle broom perpendicular to main traffic route. Coordinate required final finish with Engineer before application.

3.12 MISCELLANEOUS CONCRETE ITEM INSTALLATION

A. Filling In: Fill in holes and openings left in concrete structures after work of other trades is in place unless otherwise indicated. Mix, place, and cure concrete, as specified, to blend with in-place construction. Provide other miscellaneous concrete filling indicated or required to complete the Work.

B. Curbs: Provide monolithic finish to interior curbs by stripping forms while concrete is still green and by steel-troweling surfaces to a hard, dense finish with corners, intersections, and terminations slightly rounded.

C. Equipment Bases and Foundations:

1. Coordinate sizes and locations of concrete bases with actual equipment provided.
2. Construct concrete bases 6 inches high unless otherwise indicated, and extend base not less than 6 inches in each direction beyond the maximum dimensions of supported equipment unless otherwise indicated or unless required for seismic anchor support.
3. Minimum Compressive Strength: -4000 psi at 28 days.
4. Install dowel rods to connect concrete base to concrete floor. Unless otherwise indicated, install dowel rods on 18-inch centers around the full perimeter of concrete base.
5. For supported equipment, install epoxy-coated anchor bolts that extend through concrete base and anchor into structural concrete substrate.
6. Prior to pouring concrete, place and secure anchorage devices. Use setting drawings, templates, diagrams, instructions, and directions furnished with items to be embedded.
7. Cast anchor-bolt insert into bases. Install anchor bolts to elevations required for proper attachment to supported equipment.

D. Steel Pan Stairs: Provide concrete fill for steel pan stair treads, landings, and associated items. Cast-in inserts and accessories as shown on Drawings. Screed, tamp, and trowel finish concrete surfaces.

3.13 CONCRETE PROTECTING AND CURING

A. General: Protect freshly placed concrete from premature drying and excessive cold or hot temperatures. Comply with ACI 306.1 for cold-weather protection and ACI 301 for hot-weather protection during curing.

B. Evaporation Retarder: Apply evaporation retarder to unformed concrete surfaces if hot, dry, or windy conditions cause moisture loss approaching 0.2 lb/sq. ft. x h before and during finishing operations. Apply according to manufacturer's written instructions after placing, screeding, and bull floating or darbying concrete, but before float finishing.

C. Formed Surfaces: Cure formed concrete surfaces, including underside of beams, supported slabs, and other similar surfaces. If forms remain during curing period, moist cure after

loosening forms. If removing forms before end of curing period, continue curing for remainder of curing period.

D. Unformed Surfaces: Begin curing immediately after finishing concrete. Cure unformed surfaces, including floors and slabs, concrete floor toppings, and other surfaces.

E. Cure concrete according to ACI 308.1, by one or a combination of the following methods:

1. Moisture Curing: Required for all water retaining structures. Keep surfaces continuously moist for not less than seven days with the following materials:

    a. Water.
    b. Continuous water-fog spray.
    c. Absorptive cover, water saturated, and kept continuously wet. Cover concrete surfaces and edges with 12-inch lap over adjacent absorptive covers.

2. Moisture-Retaining-Cover Curing: Cover concrete surfaces with moisture-retaining cover for curing concrete, placed in widest practicable width, with sides and ends lapped at least 12 inches, and sealed by waterproof tape or adhesive. Cure for not less than seven days. Immediately repair any holes or tears during curing period, using cover material and waterproof tape.

    a. Moisture cure or use moisture-retaining covers to cure concrete surfaces to receive floor coverings.
    b. Moisture cure or use moisture-retaining covers to cure concrete surfaces to receive penetrating liquid floor treatments.
    c. Cure concrete surfaces to receive floor coverings with either a moisture-retaining cover or a curing compound that the manufacturer certifies does not interfere with bonding of floor covering used on Project.

3. Curing Compound: For non-liquid retaining structures and floors only. Comply with ASTM C171. Apply uniformly in continuous operation by power spray or roller according to manufacturer's written instructions. Recoat areas subjected to heavy rainfall within three hours after initial application. Maintain continuity of coating and repair damage during curing period.

    a. Removal: After curing period has elapsed, remove curing compound without damaging concrete surfaces by method recommended by curing compound manufacturer unless manufacturer certifies in writing that the curing compound does not interfere with bonding of floor covering used on Project.

4. Curing and Sealing Compound: For non-liquid retaining structures and floors only. Comply with ASTM C171. Apply uniformly to floors and slabs indicated in a continuous operation by power spray or roller according to manufacturer's written instructions. Recoat areas subjected to heavy rainfall within three hours after initial application. Repeat process 24 hours later and apply a second coat. Maintain continuity of coating and repair damage during curing period.

3.14 JOINT FILLING

A. Prepare, clean, and install joint filler according to manufacturer's written instructions.

1. Defer joint filling until concrete has aged at least three (3) month(s). Do not fill joints until construction traffic has permanently ceased.

B. Remove dirt, debris, saw cuttings, curing compounds, and sealers from joints; leave contact faces of joints clean and dry.

C. Install semi-rigid joint filler full depth in saw-cut joints and at least 2 inches deep in formed joints. Overfill joint and trim joint filler flush with top of joint after hardening.

3.15 WET TESTING

A. General
1. All new, water-retaining concrete structures shall be tested for water-tightness by the testing procedure described below and in accordance with ACI 350.1.
2. All testing work shall be performed by the Contractor in the presence of the Engineer. The Engineer shall be notified at least five (5) days in advance of the time at which testing will be performed.

B. Testing Water
1. Water for wet testing shall be furnished by the Contractor. The source of the water must be approved by the Engineer prior to filling of the structure. As a general rule, plant effluent water is acceptable for use as testing water; however, this must be confirmed by the Engineer.
2. Once testing is complete, testing water shall be disposed of in a manner acceptable to the Engineer and, unless otherwise permitted by the Engineer, shall not be allowed to enter other parts of the system.

C. Test Equipment
1. All temporary equipment needed for wet testing must be provided by the Contractor (e.g. connections between the structure to be tested and the water source, pumping equipment, metering devices, pressure or vacuum gauges, temporary flanges, valves, bulkheads, bracing, blocking, and other equipment that may be necessary to perform the testing).
2. All temporary equipment shall be removed upon satisfactory completion of wet testing.

D. Test Preparation
1. Unless otherwise specified, wet testing shall be performed after installation of pipe sleeves and before placement of backfill, cleaning, disinfection, installation of process equipment, or any other activities that would hinder visual inspection of the structure during the test.
2. Exposed concrete surfaces of the structure (including the floor) shall be cleaned of all foreign material and debris prior to the test. Standing water in or outside the structure that would interfere with the observation of the exposed concrete surfaces of the structure shall be removed. The concrete surfaces and concrete joints shall be thoroughly inspected for potential points of leakage, and those areas shall be repaired prior to filling the structure with water.

3. Adjacent structures having common walls shall be tested individually at different times to allow examination of the dividing walls for leaks.
4. Pipe connections or openings to structures, if not provided with drip tight valves, shall be temporarily plugged during testing. Where slide gates, sluice gates or similar devices are located, the Contractor shall provide bulkheads or the means to make them drip tight, and shall measure any leakage.
5. Filling of the structure shall not begin before the designed compressive strength of all concrete elements of the structure has been reached or before fourteen (14) days after all concrete walls or base slabs have been placed.

E. Test Procedure
1. Soaking Period: Fill the unlined concrete structure to 1 foot above the maximum operating water surface level and maintain that water level for a minimum of 72 hours, to minimize absorption of water into the concrete during testing. Identify and repair all visible leaks during the soaking period.
2. Testing Period: At the end of this soaking period, once all leaks have been repaired and the water level brought back to the required elevation, the testing period shall begin. Mark the water level with a weight suspended from a string and measure its elevation with a surveyor's level. Allow the structure to sit for a minimum of 48 hours. Following this period, identify and repair all visible leaks. Record and submit to the Engineer measurements of the water level at the beginning and end of the testing period.
3. Evaporation/Precipitation: During the testing period, suspend a bucket or pan in the structure and fill it halfway with testing water. Record and submit to the Engineer measurements of the water level at the beginning and end of the testing period, for use in accounting for any evaporation and precipitation that may have occurred during testing.

F. Leakage
1. Leakage requiring repair shall be defined as any moisture on the exterior surface of the structure, ranging from damp spots to dripping or trickling to shooting streams of water. All visible leakage is to be repaired even if magnitude is within allowable leakage.
2. Allowable leakage: For unlined tanks with a side-water depth of 25 feet or less, the net loss of water volume (including evaporation/precipitation) shall not exceed 0.1 percent in 24 hours.

G. Test Conclusion
1. If the leakage observed during testing (including evaporation/precipitation) is less than the allowable leakage, the structure shall be considered sufficiently water-tight. If it is greater than the allowable, the structure shall be drained, necessary repairs shall be made, and the structure shall be re-tested.

3.16 CONCRETE SURFACE REPAIRS

A. Defective Concrete: Repair and patch defective areas when approved by Engineer. Remove and replace concrete that cannot be repaired and patched to Engineer's approval.

B. Patching Mortar: Mix dry-pack patching mortar, consisting of 1 part Portland cement to 2-1/2 parts fine aggregate passing a No. 16 sieve, using only enough water for handling and placing.

C. Repairing Formed Surfaces: Surface defects include color and texture irregularities, cracks, spalls, air bubbles, honeycombs, rock pockets, fins and other projections on the surface, and stains and other discolorations that cannot be removed by cleaning.

1. Immediately after form removal, cut out honeycombs, rock pockets, and voids more than 1/2 inch in any dimension to solid concrete. Limit cut depth to 3/4 inch. Make edges of cuts perpendicular to concrete surface. Clean, dampen with water, and brush-coat holes and voids with bonding agent. Fill and compact with patching mortar before bonding agent has dried. Fill form-tie voids with patching mortar or cone plugs secured in place with bonding agent.
2. Repair defects on surfaces exposed to view by blending white Portland cement and standard Portland cement so that, when dry, patching mortar matches surrounding color. Patch a test area at inconspicuous locations to verify mixture and color match before proceeding with patching. Compact mortar in place and strike off slightly higher than surrounding surface.
3. Repair defects on concealed formed surfaces that affect concrete's durability and structural performance as determined by Engineer.

D. Repairing Unformed Surfaces: Test unformed surfaces, such as floors and slabs, for finish and verify surface tolerances specified for each surface. Correct low and high areas. Test surfaces sloped to drain for trueness of slope and smoothness; use a sloped template.

1. Repair finished surfaces containing defects. Surface defects include spalls, popouts, honeycombs, rock pockets, crazing and cracks in excess of 0.01 inch wide or that penetrate to reinforcement or completely through unreinforced sections regardless of width, and other objectionable conditions.
2. After concrete has cured at least 14 days, correct high areas by grinding.
3. Correct localized low areas during or immediately after completing surface finishing operations by cutting out low areas and replacing with patching mortar. Finish repaired areas to blend into adjacent concrete.
4. Correct other low areas scheduled to receive floor coverings with a repair underlayment. Prepare, mix, and apply repair underlayment and primer according to manufacturer's written instructions to produce a smooth, uniform, plane, and level surface. Feather edges to match adjacent floor elevations.
5. Repair defective areas, except random cracks and single holes 1 inch or less in diameter, by cutting out and replacing with fresh concrete. Remove defective areas with clean, square cuts and expose steel reinforcement with at least a 3/4-inch clearance all around. Dampen concrete surfaces in contact with patching concrete and apply bonding agent. Mix patching concrete of same materials and mixture as original concrete, except without coarse aggregate. Place, compact, and finish blending with adjacent finished concrete. Cure in same manner as adjacent concrete.
6. Repair random cracks and single holes 1 inch or less in diameter with patching mortar. Groove top of cracks and cut out holes to sound concrete and clean off dust, dirt, and loose particles. Dampen cleaned concrete surfaces and apply bonding agent. Place patching mortar before bonding agent has dried. Compact patching mortar and finish to match adjacent concrete. Keep patched area continuously moist for at least 72 hours.

E. Perform structural repairs of concrete, subject to Engineer’s approval, using epoxy adhesive and patching mortar.

F. Repair materials and installation not specified above may be used, subject to Engineer's approval.

3.17 FIELD QUALITY CONTROL

A. Special Inspections: Owner will engage a–qualified testing and inspecting agency to perform field tests and inspections and prepare test reports.

B. Testing Agency: Engage a qualified testing and inspecting agency to perform tests and inspections and to submit reports.

C. Inspections:

1. Steel reinforcement placement.
2. Steel reinforcement welding.
3. Headed bolts and studs.
4. Concrete placement, including conveying and depositing.
5. Curing procedures and maintenance of curing temperature.

D. Concrete Tests: Testing of composite samples of fresh concrete obtained according to ASTM C 172/C 172M shall be performed according to the following requirements:

1. Testing Frequency: Obtain one composite sample for each day's pour of each concrete mixture exceeding 5 cu. yd., but less than 25 cu. yd., plus one set for each additional 50 cu. yd. or fraction thereof.

    a. When frequency of testing provides fewer than five compressive-strength tests for each concrete mixture, testing shall be conducted from at least five randomly selected batches or from each batch if fewer than five are used.

2. Slump: ASTM C 143/C 143M; one test at point of placement for each composite sample, but not less than one test for each day's pour of each concrete mixture. Perform additional tests when concrete consistency appears to change.
3. Air Content: ASTM C 231/C 231M, pressure method, for normal-weight concrete; one test for each composite sample, but not less than one test for each day's pour of each concrete mixture.
4. Concrete Temperature: ASTM C 1064/C 1064M; one test hourly when air temperature is 40 deg F and below or 80 deg F and above, and one test for each composite sample.
5. Compression Test Specimens: ASTM C 31/C 31M.

    a. Cast and laboratory cure two sets of two standard cylinder specimens for each composite sample.
    b. Cast and field cure two sets of two standard cylinder specimens for each composite sample.

6. Compressive-Strength Tests: ASTM C 39/C 39M;

    a. Test one set of two field-cured specimens at 7 days and one set of two specimens at 28 days.

b. A compressive-strength test shall be the average compressive strength from a set of two specimens obtained from same composite sample and tested at age indicated.

7. When strength of field-cured cylinders is less than 85 percent of companion laboratory-cured cylinders, Contractor shall evaluate operations and provide corrective procedures for protecting and curing in-place concrete.
8. Strength of each concrete mixture will be satisfactory if every average of any three-consecutive compressive-strength tests equals or exceeds specified compressive strength and no compressive-strength test value falls below specified compressive strength by more than 500 psi.
9. Test results shall be reported in writing to Engineer, concrete manufacturer, and Contractor within 48 hours of testing. Reports of compressive-strength tests shall contain Project identification name and number, date of concrete placement, name of concrete testing and inspecting agency, location of concrete batch in Work, design compressive strength at 28 days, concrete mixture proportions and materials, compressive breaking strength, and type of break for both 7- and 28-day tests.
10. Nondestructive Testing: Impact hammer, sonoscope, or other nondestructive device may be permitted by Engineer but will not be used as sole basis for approval or rejection of concrete.
11. Additional Tests: Testing and inspecting agency shall make additional tests of concrete when test results indicate that slump, air entrainment, compressive strengths, or other requirements have not been met, as directed by Engineer. Testing and inspecting agency may conduct tests to determine adequacy of concrete by cored cylinders complying with ASTM C 42/C 42M or by other methods as directed by Engineer.
12. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of replaced or additional work with specified requirements.
13. Correct deficiencies in the Work that test reports and inspections indicate do not comply with the Contract Documents.

E. Measure floor and slab flatness and levelness according to ASTM E 1155 within 24 hours of finishing for laboratory and office buildings.

F. For floors required for sloping, the slope must be within 1/16” tolerances of that required in the plans.

3.18 PROTECTION OF LIQUID FLOOR TREATMENTS

A. Protect liquid floor treatment from damage and wear during the remainder of construction period. Use protective methods and materials, including temporary covering, recommended in writing by liquid floor treatments installer.

END OF SECTION 03 30 00

SECTION 03 41 00 - PRECAST STRUCTURAL CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section Includes:

1. Precast structural concrete.

B. Related Requirements:

1. Section 03 30 00 "Cast-in-Place Concrete" for concrete topping and placing connection anchors in concrete.
2. Section 05 12 00 "Structural Steel Framing" for furnishing and installing connections attached to structural-steel framing.
3. Section 05 50 00 "Metal Fabrications" for kickers and other miscellaneous steel shapes.

1.3 ACTION SUBMITTALS

A. Product Data: For each type of product.

B. Design Mixtures: For each precast concrete mixture. Include compressive strength and, if required, water-absorption tests.

C. Shop Drawings:

1. Include member locations, plans, elevations, dimensions, shapes and sections, openings, support conditions, and types of reinforcement, including special reinforcement.
2. Detail fabrication and installation of precast structural concrete units, including connections at member ends and to adjoining construction.
3. Indicate joints, reveals, drips, chamfers, and extent and location of each surface finish.
4. Indicate separate face and backup mixture locations and thicknesses.
5. Indicate type, size, and length of welded connections by AWS standard symbols.
6. Detail loose and cast-in hardware, lifting and erection inserts, connections, and joints.
7. Indicate locations, tolerances, and details of anchorage devices to be embedded in or attached to structure or other construction.
8. Include and locate openings larger than 10 inches. Where additional structural support is required, include header design.

9. Indicate location of each precast structural concrete unit by same identification mark placed on panel.
10. Indicate relationship of precast structural concrete units to adjacent materials.
11. Indicate estimated camber for precast floor slabs with concrete toppings.
12. Indicate shim sizes and grouting sequence.
13. If design modifications are proposed to meet performance requirements and field conditions, submit design calculations and Shop Drawings. Do not adversely affect the appearance, durability, or strength of units when modifying details or materials and maintain the general design concept.

1.4 INFORMATIONAL SUBMITTALS

A. Qualification Data: For Installer.

B. Welding certificates.

C. Material Certificates: For the following:

1. Cementitious materials.
2. Reinforcing materials and prestressing tendons.
3. Admixtures.
4. Bearing pads.
5. Insulation.
6. Structural-steel shapes and hollow structural sections.

D. Material Test Reports: For aggregates, by a qualified testing agency.

1.5 QUALITY ASSURANCE

A. Fabricator Qualifications: A firm that assumes responsibility for engineering precast structural concrete units to comply with performance requirements. Responsibility includes preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer.

B. Installer Qualifications: A precast concrete erector qualified and designated by PCI's Certificate of Compliance, to erect Category S1 - Simple AND/OR Category S2 - Complex Structural Systems.

C. Quality-Control Standard: For manufacturing procedures, testing requirements, and quality-control recommendations for types of units required, comply with PCI MNL 116, "Manual for Quality Control for Plants and Production of Structural Precast Concrete Products."

D. Welding Qualifications: Qualify procedures and personnel according to the following:

1. AWS D1.1, "Structural Welding Code - Steel."
2. AWS D1.4, "Structural Welding Code - Reinforcing Steel."

1.6 COORDINATION

A. Furnish loose connection hardware and anchorage items to be embedded in or attached to other construction before starting that Work. Provide locations, setting diagrams, templates, instructions, and directions, as required, for installation.

1.7 DELIVERY, STORAGE, AND HANDLING

A. Support units during shipment on non-staining shock-absorbing material in same position as during storage.

B. Store units with adequate bracing and protect units to prevent contact with soil, to prevent staining, and to prevent cracking, distortion, warping or other physical damage.

1. Store units with dunnage across full width of each bearing point unless otherwise indicated.
2. Place adequate dunnage of even thickness between each unit.
3. Place stored units so identification marks are clearly visible, and units can be inspected.

C. Handle and transport units in a manner that avoids excessive stresses that cause cracking or damage.

D. Lift and support units only at designated points indicated on Shop Drawings.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design precast structural concrete units.

B. Design Standards: Comply with ACI 318 and with design recommendations in PCI MNL 120, "PCI Design Handbook - Precast and Prestressed Concrete," applicable to types of precast structural concrete units indicated.

C. Structural Performance: Precast structural concrete units and connections shall withstand design loads indicated within limits and under conditions indicated.

D. Structural Performance: Provide precast structural concrete units and connections capable of withstanding the design loads within limits and under conditions indicated in the plans and specifications and as required by the IBC.

1. Design precast structural concrete framing system and connections to maintain clearances at openings, to allow for fabrication and construction tolerances, to accommodate live-load deflection, shrinkage and creep of primary building structure, and other building movements. Maintain precast structural concrete deflections within limits of ACI 318.

a. Thermal Movements: Allow for in-plane thermal movements resulting from annual ambient temperature changes of plus 20 to plus 100 deg F.

2.2 MOLD MATERIALS

A. Molds: Rigid, dimensionally stable, non-absorptive material, warp and buckle free, that provides continuous precast concrete surfaces within fabrication tolerances indicated; nonreactive with concrete and suitable for producing required finishes.

1. Mold-Release Agent: Commercially produced form-release agent that does not bond with, stain, or adversely affect precast concrete surfaces and does not impair subsequent surface or joint treatments of precast concrete.

2.3 REINFORCING MATERIALS

A. Reinforcing Bars: ASTM A 615, Grade 60, deformed.

B. Low-Alloy-Steel Reinforcing Bars: ASTM A 706, deformed.

C. Steel Bar Mats: ASTM A 184, fabricated from ASTM A 615, Grade 60 or ASTM A 706, deformed bars, assembled with clips.

D. Plain-Steel Welded Wire Reinforcement: ASTM A 185, fabricated from as-drawn steel wire into flat sheets.

E. Deformed-Steel Welded Wire Reinforcement: ASTM A 497 or ASTM A 1064, flat sheet.

F. Supports: Suspend reinforcement from back of mold or use bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire reinforcement in place according to PCI MNL 116.

2.4 PRESTRESSING TENDONS

A. Pretensioning Strand: ASTM A 416, Grade 250 or Grade 270, uncoated, seven-wire, low-relaxation strand.

B. Unbonded Post-Tensioning Strand: ASTM A 416, Grade 270, uncoated, seven-wire, low-relaxation strand.

C. Post-Tensioning Bars: ASTM A 722, uncoated high-strength steel bar.

2.5 CONCRETE MATERIALS

A. Portland Cement: ASTM C 150, Type I or Type III, gray, unless otherwise indicated.

1. For surfaces exposed to view in finished structure, use gray or white cement, of same type, brand, and mill source.

B. Supplementary Cementitious Materials:

1. Fly Ash: ASTM C 618, Class C or F, with maximum loss on ignition of 3 percent.
2. Metakaolin: ASTM C 618, Class N.
3. Silica Fume: ASTM C 1240, with optional chemical and physical requirement.
4. Ground Granulated Blast-Furnace Slag: ASTM C 989, Grade 100 or 120.

C. Normal-Weight Aggregates: Except as modified by PCI MNL 116, ASTM C 33, with coarse aggregates complying with required class. Stockpile fine and coarse aggregates for each type of exposed finish from a single source (pit or quarry) for Project.

D. Water: Potable; free from deleterious material that may affect color stability, setting, or strength of concrete and complying with chemical limits of PCI MNL 116.

E. Air-Entraining Admixture: ASTM C 260, certified by manufacturer to be compatible with other required admixtures.

F. Chemical Admixtures: Certified by manufacturer to be compatible with other admixtures and to not contain calcium chloride, or more than 0.15 percent chloride ions or other salts by weight of admixture.

1. Water-Reducing Admixtures: ASTM C 494, Type A.
2. Retarding Admixture: ASTM C 494, Type B.
3. Water-Reducing and Retarding Admixture: ASTM C 494, Type D.
4. Water-Reducing and Accelerating Admixture: ASTM C 494, Type E.
5. High-Range, Water-Reducing Admixture: ASTM C 494, Type F.
6. High-Range, Water-Reducing and Retarding Admixture: ASTM C 494, Type G.
7. Plasticizing Admixture: ASTM C 1017, Type I.
8. Plasticizing and Retarding Admixture: ASTM C 1017, Type II.
9. Corrosion-Inhibiting Admixture: ASTM C 1582.

2.6 STEEL CONNECTION MATERIALS

A. Carbon-Steel Shapes and Plates: ASTM A 36.

B. Carbon-Steel-Headed Studs: ASTM A 108, Grade 1010 through 1020, cold finished, AWS D1.1, Type A or B, with arc shields and with minimum mechanical properties of PCI MNL 116.

C. Carbon-Steel Plate: ASTM A 283, Grade C.

D. Malleable-Iron Castings: ASTM A 47, Grade 32510 or Grade 35028.

E. Carbon-Steel Castings: ASTM A 27, Grade 60-30.

F. High-Strength, Low-Alloy Structural Steel: ASTM A 572.

G. Carbon-Steel Structural Tubing: ASTM A 500, Grade B or Grade C.

H. Wrought Carbon-Steel Bars: ASTM A 675, Grade 65.

I. Carbon-Steel Bolts and Studs: ASTM A 307, Grade A; carbon-steel, hex-head bolts and studs; carbon-steel nuts, ASTM A 563; and flat, unhardened steel washers, ASTM F 844.

J. Shop-Primed Finish: Prepare surfaces of nongalvanized-steel items, except those surfaces to be embedded in concrete, according to requirements in SSPC-SP 3, and shop apply lead- and chromate-free, rust-inhibitive primer, complying with performance requirements in MPI 79 OR SSPC-Paint 25 according to SSPC-PA 1.

K. Welding Electrodes: Comply with AWS standards.

L. Precast Accessories: Provide clips, hangers, plastic or steel shims, and other accessories required to install precast structural concrete units.

2.7 BEARING PADS

A. Provide one of the following bearing pads for precast structural concrete units as recommended by precast fabricator for application:

1. Elastomeric Pads: AASHTO M 251, plain, vulcanized, 100 percent polychloroprene (neoprene) elastomer, molded to size or cut from a molded sheet, 50 to 70 Shore, Type A durometer hardness, ASTM D 2240; minimum tensile strength 2250 psi, ASTM D 412.
2. Random-Oriented-Fiber-Reinforced Elastomeric Pads: Preformed, randomly oriented synthetic fibers set in elastomer. 70 to 90 Shore, Type A durometer hardness, ASTM D 2240; capable of supporting a compressive stress of 3000 psi with no cracking, splitting, or delaminating in the internal portions of pad. Test one specimen for every 200 pads used in Project.
3. Cotton-Duck-Fabric-Reinforced Elastomeric Pads: Preformed, horizontally layered cotton-duck fabric bonded to an elastomer; 80 to 100 Shore, Type A durometer hardness, ASTM D 2240; complying with AASHTO's "AASHTO LRFD Bridge Design Specifications," Division II, Section 18.10.2; or with MIL-C-882E.
4. Frictionless Pads: PTFE, glass-fiber reinforced, bonded to stainless- or mild-steel plate, or random-oriented-fiber-reinforced elastomeric pads; of type required for in-service stress.
5. High-Density Plastic: Multimonomer, nonleaching, plastic strip.

2.8 ACCESSORIES

A. Precast Accessories: Provide clips, hangers, high-density plastic or steel shims, and other accessories required to install structural precast concrete units.

2.9 GROUT MATERIALS

A. Sand-Cement Grout: Portland cement, ASTM C 150, Type I, and clean, natural sand, ASTM C 144 or ASTM C 404. Mix at ratio of 1 part cement to 2-1/2 to 3 parts sand, by

volume, with minimum water required for placement and hydration. Water-soluble chloride ion content less than 0.06 percent by weight of cement when tested according to ASTM C 1218.

B. Epoxy-Resin Grout: Two-component, mineral-filled epoxy resin; ASTM C 881, of type, grade, and class to suit requirements.

2.10 CONCRETE MIXTURES

A. Prepare design mixtures for each type of precast concrete required.
   1. Limit use of fly ash to 20 percent replacement of portland cement by weight and ground granulated blast-furnace slag to 20 percent of portland cement by weight; metakaolin and silica fume to 10 percent of portland cement by weight.

B. Design mixtures may be prepared by a qualified independent testing agency or by qualified precast plant personnel at precast structural concrete fabricator's option.

C. Limit water-soluble chloride ions to maximum percentage by weight of cement permitted by ACI 318 or PCI MNL 116 when tested according to ASTM C 1218.

D. Normal-Weight Concrete Mixtures: Proportion face and backup mixtures by either laboratory trial batch or field test data methods according to ACI 211.1, with materials to be used on Project, to provide normal-weight concrete with the following properties:

   1. Compressive Strength (28 Days): 5000 psi.
   2. Maximum Water-Cementitious Materials Ratio: 0.45.

E. Water Absorption: For structural precast concrete with an Engineerural finish, limit water absorption to 6 percent by weight or 14 percent by volume, tested according to ASTM C 642, except for boiling requirement.

F. Add air-entraining admixture at manufacturer's prescribed rate to result in concrete at point of placement having an air content complying with PCI MNL 116.

G. When included in design mixtures, add other admixtures to concrete mixtures according to manufacturer's written instructions.

H. Concrete Mix Adjustments: Concrete mix design adjustments may be proposed if characteristics of materials, Project conditions, weather, test results, or other circumstances warrant.

2.11 MOLD FABRICATION

A. Molds: Accurately construct molds, mortar tight, of sufficient strength to withstand pressures due to concrete-placement operations and temperature changes and for prestressing and detensioning operations. Coat contact surfaces of molds with release agent before reinforcement is placed. Avoid contamination of reinforcement and prestressing tendons by release agent.

B. Maintain molds to provide completed precast structural concrete units of shapes, lines, and dimensions indicated, within fabrication tolerances specified.

1. Edge and Corner Treatment: Uniformly chamfered.

2.12 FABRICATION

A. Cast-in Anchors, Inserts, Plates, Angles, and Other Anchorage Hardware: Fabricate anchorage hardware with sufficient anchorage and embedment to comply with design requirements. Accurately position for attachment of loose hardware, and secure in place during precasting operations. Locate anchorage hardware where it does not affect position of main reinforcement or concrete placement.

1. Weld-headed studs and deformed bar anchors used for anchorage according to AWS D1.1 and AWS C5.4, "Recommended Practices for Stud Welding."

B. Furnish loose hardware items including steel plates, clip angles, seat angles, anchors, dowels, cramps, hangers, and other hardware shapes for securing precast structural concrete units to supporting and adjacent construction.

C. Cast-in reglets, slots, holes, and other accessories in precast structural concrete units as indicated on the Contract Drawings.

D. Cast-in openings larger than 6 inches in any dimension. Do not drill or cut openings or prestressing strand without Engineer's approval.

E. Reinforcement: Comply with recommendations in PCI MNL 116 for fabricating, placing, and supporting reinforcement.

1. Clean reinforcement of loose rust and mill scale, earth, and other materials that reduce or destroy the bond with concrete. When damage to epoxy-coated reinforcement exceeds limits specified in ASTM A 775, repair with patching material compatible with coating material and epoxy coat bar ends after cutting.
2. Accurately position, support, and secure reinforcement against displacement during concrete-placement and consolidation operations. Completely conceal support devices to prevent exposure on finished surfaces.
3. Place reinforcing steel and prestressing strand to maintain at least 3/4-inch minimum concrete cover. Increase cover requirements for reinforcing steel to 1-1/2 inches when units are exposed to corrosive environment or severe exposure conditions. Arrange, space, and securely tie bars and bar supports to hold reinforcement in position while placing concrete. Direct wire tie ends away from finished, exposed concrete surfaces.
4. Install welded wire fabric in lengths as long as practicable. Lap adjoining pieces at least one full mesh spacing and wire tie laps, where required by design. Offset laps of adjoining widths to prevent continuous laps in either direction.

F. Reinforce precast structural concrete units to resist handling, transportation, and erection stresses and specified in-place loads.

G. Comply with requirements in PCI MNL 116 and in this Section for measuring, mixing, transporting, and placing concrete. After concrete batching, no additional water may be added.

H. Place concrete in a continuous operation to prevent cold joints or planes of weakness from forming in precast concrete units.

I. Thoroughly consolidate placed concrete by vibration without dislocating or damaging reinforcement and built-in items, and minimize pour lines, honeycombing, or entrapped air voids on surfaces. Use equipment and procedures complying with PCI MNL 116.

J. Comply with PCI MNL 116 procedures for hot- and cold-weather concrete placement.

K. Identify pickup points of precast structural concrete units and orientation in structure with permanent markings, complying with markings indicated on Shop Drawings. Imprint or permanently mark casting date on each precast structural concrete unit on a surface that does not show in finished structure.

L. Cure concrete, according to requirements in PCI MNL 116, by moisture retention without heat or by accelerated heat curing using live steam or radiant heat and moisture. Cure units until compressive strength is high enough to ensure that stripping does not have an effect on performance or appearance of final product.

M. Discard and replace precast structural concrete units that do not comply with requirements, including structural, manufacturing tolerance, and appearance, unless repairs meet requirements in PCI MNL 116 and meet Engineer's approval.

2.13 FABRICATION TOLERANCES

A. Fabricate precast structural concrete units to shapes, lines, and dimensions indicated so each finished unit complies with PCI MNL 116 product dimension tolerances as well as position tolerances for cast-in items.

2.14 COMMERCIAL FINISHES

A. Standard Grade: Normal plant-run finish produced in molds that impart a smooth finish to concrete. Surface holes smaller than 1/2 inch caused by air bubbles, normal color variations, form joint marks, and minor chips and spalls are permitted. Fill air holes greater than 1/4 inch in width that occur more than once per 2 sq. in. Major or unsightly imperfections, honeycombs, or structural defects are not permitted. Limit joint offsets to 1/8 inch.

B. Screed or float finish unformed surfaces. Strike off and consolidate concrete with vibrating screeds to a uniform finish. Hand screed at projections. Normal color variations, minor indentations, minor chips, and spalls are permitted. Major imperfections, honeycombing, or defects are not permitted.

2.15 SOURCE QUALITY CONTROL

A. Testing Agency: Engage a qualified testing agency to evaluate precast structural concrete fabricator's quality-control and testing methods.

1. Allow testing agency access to material storage areas, concrete production equipment, concrete placement, and curing facilities. Cooperate with testing agency and provide samples of materials and concrete mixtures as may be requested for additional testing and evaluation.

B. Strength of precast structural concrete units is considered deficient if units fail to comply with ACI 318 requirements for concrete strength.

C. Patching: If core test results are satisfactory and precast structural concrete units comply with requirements, clean and dampen core holes and solidly fill with same precast concrete mixture that has no coarse aggregate, and finish to match adjacent precast concrete surfaces.

D. Defective Units: Discard and replace precast structural concrete units that do not comply with requirements, including strength, manufacturing tolerances, and color and texture range. Chipped, spalled, or cracked units may be repaired, subject to Engineer's approval. Engineer reserves the right to reject precast units that do not match approved samples, sample panels, and mockups. Replace unacceptable units with precast concrete units that comply with requirements.

PART 3 - EXECUTION

3.1 EXAMINATION

A. Examine supporting structural frame or foundation and conditions for compliance with requirements for installation tolerances, bearing surface tolerances, and other conditions affecting performance of the Work.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

C. Do not install precast concrete units until supporting, cast-in-place concrete has attained minimum allowable design compressive strength and until supporting steel or other structure is structurally ready to receive loads from precast concrete units.

3.2 INSTALLATION

A. Install clips, hangers, bearing pads, and other accessories required for connecting precast structural concrete units to supporting members and backup materials.

B. Erect precast structural concrete level, plumb, and square within specified allowable tolerances. Provide temporary structural framing, shoring, and bracing as required to maintain position, stability, and alignment of units until permanent connections are complete.

1. Install temporary steel or plastic spacing shims or bearing pads as precast structural concrete units are being erected. Tack weld steel shims to each other to prevent shims from separating.
2. Maintain horizontal and vertical joint alignment and uniform joint width as erection progresses.

3. Remove projecting lifting devices and use plastic patch caps or sand-cement grout to fill voids within recessed lifting devices flush with surface of adjacent precast surfaces when recess is exposed.

C. Connect precast structural concrete units in position by bolting, welding, grouting, or as otherwise indicated on Shop Drawings. Remove temporary shims, wedges, and spacers as soon as practical after connecting and grouting are completed.

D. Field cutting of precast units is not permitted without approval of Engineer.

E. Fasteners: Do not use drilled or powder-actuated fasteners for attaching accessory items to precast, prestressed concrete units.

F. Welding: Comply with applicable requirements in AWS D1.1 and AWS D1.4 for welding, welding electrodes, appearance, quality of welds, and methods used in correcting welding work.

1. Protect precast structural concrete units and bearing pads from damage by field welding or cutting operations, and provide noncombustible shields as required.
2. Clean weld-affected steel surfaces with chipping hammer followed by brushing, and apply a minimum 4.0-mil-thick coat of galvanized repair paint to galvanized surfaces according to ASTM A 780.
3. Visually inspect welds and remove, reweld, or repair incomplete and defective welds.

G. At bolted connections, use lock washers, tack welding, or other approved means to prevent loosening of nuts after final adjustment.

1. Where slotted connections are used, verify bolt position and tightness. For sliding connections, properly secure bolt but allow bolt to move within connection slot.

H. Grouting or Dry-Packing Connections and Joints: Grout connections and joints and open spaces at keyways, connections, and joints where required or indicated on Shop Drawings. Retain flowable grout in place until hard enough to support itself. Alternatively, pack spaces with stiff dry-pack grout material, tamping until voids are completely filled.

1. Place grout and finish smooth, level, and plumb with adjacent concrete surfaces.
2. Fill joints completely without seepage to other surfaces.
3. Trowel top of grout joints on roofs smooth and uniform. Finish transitions between different surface levels not steeper than 1 to 12.
4. Place grout end cap or dam in voids at ends of hollow-core slabs.
5. Promptly remove grout material from exposed surfaces before it affects finishes or hardens.
6. Keep grouted joints damp for not less than 24 hours after initial set.

3.3 ERECTION TOLERANCES

A. Erect precast structural concrete units level, plumb, square, and in alignment without exceeding the noncumulative erection tolerances of PCI MNL 135.

B. Minimize variations between adjacent slab members by jacking, loading, or other method recommended by fabricator and approved by Engineer.

3.4 FIELD QUALITY CONTROL

A. Visually inspect field welds and test according to ASTM E 165 or to ASTM E 709 and ASTM E 1444. High-strength bolted connections are subject to inspections.

B. Testing agency will report test results promptly and in writing to Contractor and Engineer.

C. Repair or remove and replace work where tests and inspections indicate that it does not comply with specified requirements.

D. Additional testing and inspecting, at Contractor's expense, shall be performed to determine compliance of replaced or additional work with specified requirements.

E. Prepare test and inspection reports.

3.5 REPAIRS

A. Repair precast structural concrete units if permitted by Engineer.

1. Repairs may be permitted if structural adequacy, serviceability, durability, and appearance of units have not been impaired.

B. Mix patching materials and repair units so cured patches blend with color, texture, and uniformity of adjacent exposed surfaces and show no apparent line of demarcation between original and repaired work, when viewed in typical daylight illumination from a distance of 20 feet.

C. Wire brush, clean, and paint damaged prime-painted components with same type of shop primer.

D. Remove and replace damaged precast structural concrete units that cannot be repaired or when repairs do not comply with requirements as determined by Engineer.

3.6 CLEANING

A. Clean mortar, plaster, fireproofing, weld slag, and other deleterious material from concrete surfaces and adjacent materials immediately.

B. Clean exposed surfaces of precast concrete units after erection and completion of joint treatment to remove weld marks, other markings, dirt, and stains.

1. Perform cleaning procedures, if necessary, according to precast concrete fabricator's written recommendations. Protect other work from staining or damage due to cleaning operations.

2. Do not use cleaning materials or processes that could change the appearance of exposed concrete finishes or damage adjacent materials.

END OF SECTION 03 41 00

SECTION 03 60 00 - GROUTING

PART 1 - GENERAL

1.1 SUMMARY

A. Section Includes:

1. Portland cement grout.
2. Rapid-curing epoxy grout.
3. Nonshrink cementitious grout.

B. Related Requirements:

1. Section 03 30 00 - Cast-in-Place Concrete: Cast-in-place or in-situ concrete for structural building frames, slabs on fill or grade, and other concrete components.

1.2 REFERENCE STANDARDS

A. American Concrete Institute:

1. ACI 301 - Specifications for Structural Concrete for Buildings.
2. ACI 318 - Building Code Requirements for Structural Concrete.
3. ACI 350 – Code Requirements for Environmental Engineering Concrete Structures

B. ASTM International:

1. ASTM C33 - Standard Specification for Concrete Aggregates.
2. ASTM C40 - Standard Test Method for Organic Impurities in Fine Aggregates for Concrete.
3. ASTM C150 - Standard Specification for Portland Cement.
4. ASTM C191 - Standard Test Methods for Time of Setting of Hydraulic Cement by Vicat Needle.
5. ASTM C307 - Standard Test Method for Tensile Strength of Chemical-Resistant Mortar, Grouts, and Monolithic Surfacings.
6. ASTM C531 - Standard Test Method for Linear Shrinkage and Coefficient of Thermal Expansion of Chemical-Resistant Mortars, Grouts, Monolithic Surfacings, and Polymer Concretes.
7. ASTM C579 - Standard Test Methods for Compressive Strength of Chemical-Resistant Mortars, Grouts, Monolithic Surfacings, and Polymer Concretes.
8. ASTM C827 - Standard Test Method for Change in Height at Early Ages of Cylindrical Specimens of Cementitious Mixtures.

C. U. S. Army Corps of Engineers Concrete Research Division (CRD):

1. CRD-C621 - Non-Shrink Grout.

1.3 SUBMITTALS

A. Section 013300 - Submittal Procedures: Requirements for submittals.

B. Product Data: Submit manufacturer information regarding grout.

C. Manufacturer's Certificate: Certify that products meet or exceed specified requirements.

D. Manufacturer Instructions: Submit instructions for mixing, handling, surface preparation, and placing epoxy-type and nonshrink grouts.

E. Field Quality-Control Submittals: Indicate results of Contractor-furnished tests and inspections.

1.4 DELIVERY, STORAGE, AND HANDLING

A. Section 016000 - Product Requirements: Requirements for transporting, handling, storing, and protecting products.

B. Inspection: Accept materials on Site in manufacturer's original packaging and inspect for damage.

C. Store materials according to manufacturer instructions.

D. Protection:

1. Protect materials from moisture and dust by storing in clean, dry location remote from construction operations areas.
2. Provide additional protection according to manufacturer instructions.

1.5 AMBIENT CONDITIONS

A. Section 01 50 00 - Temporary Facilities and Controls: Requirements for ambient condition control facilities for product storage and installation.

B. Maximum Conditions: Do not perform grouting if temperatures exceed manufacturer’s recommendations.

C. Minimum Conditions: Maintain minimum temperature per the manufacturer before, during, and after grouting, until grout has set.

PART 2 - PRODUCTS

2.1 PORTLAND CEMENT GROUT

A. Portland Cement: Comply with ASTM C150, Type I and II.

B. Water:

1. Potable.
2. No impurities, suspended particles, algae, or dissolved natural salts in quantities capable of causing:

    a. Corrosion of steel.
    b. Volume change increasing shrinkage cracking.
    c. Efflorescence.
    d. Excess air entraining.

C. Fine Aggregate:

1. Washed natural sand.
2. Gradation:

    a. Comply with ASTM C33.
    b. Represented by smooth granulometric curve within required limits.

3. Free from injurious amounts of organic impurities according to ASTM C40.

D. Mix:

1. Portland cement, sand, and water.
2. Do not use ferrous aggregate or staining ingredients in grout mixes.

2.2 RAPID-CURING EPOXY GROUT

A. Manufacturers:

1. L&M Construction Chemicals
2. Sika Corporation
3. WR Meadows

B. Description:

1. High-strength, three-component epoxy grout formulated with thermosetting resins and inert fillers.
2. Rapid-curing, high adhesion, and resistant to ordinary chemicals, acids, and alkalis.

C. Performance and Design Criteria:

1. Compressive Strength:

    a. 12,000 psi at seven days.
    b. Comply with ASTM C579.

2. Minimum Tensile Strength:

    a. 2,000 psi.
    b. Comply with ASTM C307.

3. Coefficient of Expansion:

    a. 30x10-6 inch per degree F.
    b. Comply with ASTM C531.

4. Shrinkage:

    a. None.
    b. Comply with ASTM C827.

2.3 NONSHRINK CEMENTITIOUS GROUT

A. Manufacturers:

1. Euclid Chemical Company

2. Sika Corporation

3. L&M Construction Chemicals

B. Description:

1. Pre-mixed and ready-for-use formulation requiring only addition of water.
2. Nonshrink, non-corrosive, nonmetallic, non-gas forming, and no chlorides.

C. Performance and Design Criteria:

1. Certified to maintain initial placement volume or expand after set, and to meet following minimum properties when tested according to CRD-C621 for Type D nonshrink grout:

    a. Setting Time:

        1) Initial: Approximately two hours.
        2) Final: Approximately three hours.
        3) Comply with ASTM C191.

    b. Maximum Expansion: 0.10 to 0.40 percent.
    c. Compressive Strength:

        1) One-Day: 4,000 psi.
        2) Seven-Day: 7,000 psi.
        3) 28-Day: 10,000 to 10,800 psi.
        4) Comply with CRD-C621.

2.4 FORMWORK

A. As specified in Section 03 30 00 – Cast-In-Place Concrete.

PART 3 - EXECUTION

3.1 EXAMINATION

A. Section 01 70 00 - Execution and Closeout Requirements: Requirements for installation examination.

B. Verify areas to receive grout.

3.2 PREPARATION

A. Section 01 70 00 - Execution and Closeout Requirements: Requirements for installation preparation.

B. Remove defective concrete, laitance, dirt, oil, grease, and other foreign material from concrete surfaces by brushing, hammering, chipping, or other similar means until sound and clean concrete surface is achieved.

C. Roughen concrete lightly, but not to interfere with placement of grout.

D. Remove foreign materials from metal surfaces in contact with grout.

E. Align, level, and maintain final positioning of components to be grouted.

F. Saturate concrete surfaces with clean water, and then remove excess water.

3.3 INSTALLATION

A. Formwork:

1. Construct leak proof forms anchored and shored to withstand grout pressures.
2. Install formwork with clearances to permit proper placement of grout.
3. As specified in Section 03 30 00 – Cast-In-Place Concrete.

B. Mixing:

1. Portland Cement Grout:

   a. Use proportions of two parts sand and one-part cement, measured by volume.
   b. Prepare grout with water to obtain consistency to permit placing and packing.
   c. Mix water and grout in two steps:

      1) Premix using approximately 2/3 of water.
      2) After partial mixing, add remaining water to bring mix to desired placement consistency and continue mixing two to three minutes.

   d. Mix only quantities of grout capable of being placed within 30 minutes after mixing.

e. Do not add additional water after grout has been mixed.
f. Minimum Compressive Strength: 2,400psi in 48 hours and 7,000psi in 28 days.

2. Rapid-Curing Epoxy Grout:

a. Mix and prepare according to manufacturer instructions.
b. Minimum Compressive Strength: 2,400 psi in 48 hours and 7,000 psi in 28 days.

3. Nonshrink Cementitious Grout:

a. Mix and prepare according to manufacturer instructions.
b. Minimum Compressive Strength: 2,400 psi in 48 hours and 7,000 psi in 28 days.

4. Mix grout components in proximity to Work area and transport mixture quickly and in manner not permitting segregation of materials.

C. Placing of Grout:

1. Place grout material quickly and continuously.
2. Do not use pneumatic-pressure or dry-packing methods.
3. Apply grout from one side only to avoid entrapping air.
4. Do not vibrate placed grout mixture or permit placement if area is being vibrated by nearby equipment.
5. Thoroughly compact final installation and eliminate air pockets.
6. Do not remove leveling shims for at least 48 hours after grout has been placed.

D. Curing:

1. Prevent rapid loss of water from grout during first 48 hours by use of approved membrane curing compound or by using wet burlap method.
2. Immediately after placement, protect grout from premature drying, excessively hot or cold temperatures, and mechanical injury.
3. After grout has attained its initial set, keep damp for minimum three days.

3.4 FIELD QUALITY CONTROL

A. Inspection and Testing:

1. Comply with ACI 301 and as specified in Section.
2. Submit proposed mix design of each class of grout to Engineer of Record for review prior to commencement of Work.
3. Tests of grout components may be performed to ensure compliance with specified requirements.

END OF SECTION 03 60 00