

Project Special Provisions  
Structure

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6/20/11

**PROJECT SPECIAL PROVISIONS**  
**STRUCTURE****PROJECT B-4211****NASH COUNTY****CONSTRUCTION, MAINTENANCE AND REMOVAL**  
**OF TEMPORARY STRUCTURE AT STATION 22+24.50-L-****(11-5-10)**

Construct, maintain and afterwards remove a temporary structure in accordance with the applicable parts of the Standard Specifications and this Special Provision (structure only; the approaches are not a part of this pay item). Provide a temporary structure with a minimum overall length of 306 feet (meters). Center the length of the structure about Station 16+96.66-DET- -Detour- with the alignment, grade, and skew as indicated on the Roadway plans. If the skew is not 90°, lengthening the structure to accommodate a 90° skew is permitted. Provide a temporary structure with a minimum clear roadway width of 24 feet (meters) and an underclearance elevation no less than elevation 114.20. Temporary structures over railroads shall maintain a minimum horizontal clearance of 25' from center of track to any temporary bent.

Design the temporary structure for HL-93 live load in accordance with the current edition of the AASHTO LRFD Bridge Design Specifications. The design of temporary structures need not satisfy the Extreme Event I Load Combination of the AASHTO LRFD Bridge Design Specifications. As a minimum, design the bridge rails for the AASHTO LRFD Test Level 2 (TL-2) crash test criteria, except when the plans state that a Test Level 3 (TL-3) bridge rail is required. The bridge rail design criteria are defined in the current edition of the AASHTO LRFD Bridge Design Specifications. In addition, design structural elements to which the bridge rail is attached, or elements which may receive loads transmitted through the rail, to distribute and/or withstand these loads.

Attach the bridge rails in a way that permits the bridge approach railing system to transition from the guardrail system and attach to the rigid railing system on the temporary bridge.

Provide a timber floor of laminated construction on the temporary structure. Place a sufficiently thick bottom layer of lumber normal to the centerline of roadway and a top layer of 2" x 8" (50 mm x 200mm) lumber on a 45° skew with the centerline of roadway. Lumber wider than 8" (200mm) is permitted if approved. For the bottom layer, use lumber that is dressed on all four sides to ensure a uniform width and thickness. For the top layer, use lumber dressed only on one side to ensure a uniform thickness. Place the lumber so that the crown of the lumber is the rough side and is "facing up" in order to receive a tack coat. Apply sand seal to the timber floor after the top layer of lumber is completed. When preservative treatment is specified, follow AWP Standards for the applicable use.

For Sand Seal, apply a liquid asphalt material and one or more applications of fine aggregate on the surface of wooden deck detour bridges. Use materials meeting the requirements of Division 10 of the Standard Specifications shown below:

- Asphalt, Grade CRS-2 or CRS-1 ..... Articles 1020-6, 1020-7
- Aggregate, #1S..... Article 1005-3

Clean and dry the surface of the bridges before applying treatment. Apply asphalt emulsion at a rate of 0.15 - 0.20 gal/yd<sup>2</sup> (0.7 - 0.9 liters/m<sup>2</sup>) followed by a uniform coverage of sand at a rate of 10 – 15 lbs/yd<sup>2</sup> (5.4 - 8.1 kg/m<sup>2</sup>). Roll the seal with a pneumatic-tired roller. Allow the seal to cure for a minimum of 24 hours before opening to traffic. Maintain the sand seal in an acceptable condition during the life of the detour, making additional applications as necessary.

If the timbers in the bottom layer of lumber are at least 8 inches (200mm) thick, an asphalt wearing surface of at least 3 inches (75 mm) in thickness is permitted in lieu of the sand seal and top layer of lumber. Bolt the timbers together horizontally in minimum 4 foot (1.2m) mats. Prior to the assembly of the mats, have all four sides of the individual timbers inspected in accordance with Article 1082-1 of the Standard Specifications. Place the face of timbers in contact with girder flanges so that they are even and positively bear on all girder flanges. If necessary, provide shimming to ensure positive bearing. Minor variations are permissible in the evenness of the top surface of timbers that is in contact with the asphalt. Secure the timber floor to the girder flanges at regular intervals.

Other floor systems are permitted if approved.

If timber piles are used, use piles that are new and conform to ASTM D25. Rough-peeled or clean-peeled untreated timber piles are permitted.

All wood and timber products shall be inspected in accordance with Article 1082-1 of the Standard Specifications.

Submit design calculations to the Engineer that, as a minimum, include stress calculations for the following structural components: railings, rail post, rail post connections, timber floor, main girders or floor beam system, bent cap, pile bearing, pile as a structural member and longitudinal and lateral stability of pile bents if necessary. Design calculations and detailed drawings of the structural components shall be signed and sealed by a North Carolina Registered Professional Engineer. For stream crossings, determine the pile stability assuming a scour depth equal to 250% of the pile diameter or width below the existing bed elevation. The Engineer may require a more detailed analysis of scour depth for pile bents containing more than a single row of piles.

Include material specifications for all new and used materials, including commercial grades and species of timber and lumber, in the detail drawings of the structure. In addition, show the location and a detailed sketch of the used materials indicating condition of the material, the location and geometry of existing but unused holes, attachments left over from previous use and any other irregularities in the material.

Indicate the condition of the used materials in the design calculations. Provide access to any used materials for inspection prior to assembly.

All critical bolted connections in the temporary structure require new high strength bolts. Indicate the location of the critical connections and recommended bolt size with tightening procedures in the detail drawings of the structure. The use of used high strength bolts is limited to non-critical connections and is subject to approval. For new high strength bolts, furnish the Engineer a copy of the manufacturer's test report for each component. Have the report indicate the testing date, the location where the components were manufactured, the lot number of the material represented, the rotational capacity tests lot number and the source identification marking used by the manufacturer of each component.

Before the temporary structure is loaded, the contractor shall inspect the structure and submit a written statement certifying that the erected structure complies with the approved detailed drawings. Temporary structures utilizing modular panels shall be inspected and certified by a manufacturer's representative. Any condition that does not comply with the accepted drawings, or any other condition deemed unsatisfactory by the Engineer, is cause for rejection until corrections are made.

Have all timber and lumber inspected by the Materials and Tests Unit or their authorized representative before shipping it to the project. The use of ungraded timber and lumber is not permitted. Use material conforming to grading rules of SPIB, NELMA or other nationally recognized specification.

The lump sum price bid for "Construction, Maintenance and Removal of Temporary Structure at Station 22+24.50-L-" will be full compensation for the above work including all materials, equipment, tools, labor and incidentals necessary to complete the work.

## **THERMAL SPRAYED COATINGS (METALLIZATION)**

**(6-07-05)**

### **1.0 DESCRIPTION**

Apply a thermal sprayed coating (TSC) and sealer to metal surfaces as specified herein when called for on the plans or by other Special Provisions, or when otherwise approved by the Engineer in accordance with the SSPC-CS 23.00/AWS C2.23/NACE No. 12 Specification. Only Arc Sprayed application methods are used to apply TSC coatings, the Engineer must approve other methods of application.

### **2.0 QUALIFICATIONS**

Only use NCDOT approved TSC Contractors meeting the following requirements:

1. Who have the capability of blast cleaning steel surfaces to SSPC SP-5 and SP-10 Finishes.
2. Who employ a Spray Operator(s) qualified in accordance with AWS C.16/C2.16M2002 and a Quality Control Inspector(s) who have documented training in the applicable test procedures of ASTM D-3276 and SSPC-CS 23.00.

A summary of the contractor's related work experience and the documents verifying each Spray Operator's and Quality Control Inspector's qualifications are submitted to the Engineer before any work is performed.

### 3.0 MATERIALS

Provide wire in accordance with the metallizing equipment manufacturer's recommendations. Use the wire alloy specified on the plans which meets the requirements in Annex C of the SSPC-CS 23.00 Specification. Have the contractor provide a certified analysis (NCDOT Type 2 Certification) for each lot of wire material.

Apply an approved sealer to all metallized surfaces in accordance with Section 9 of SSPC-CS 23. The sealer must either meet SSPC Paint 27 or is an alternate approved by the Engineer.

### 4.0 SURFACE PREPARATION AND TSC APPLICATION

Grind flame cut edges to remove the carbonized surface prior to blasting. Bevel all flame cut edges in accordance with Article 442-10(D) regardless of included angle. Blast clean surfaces to be metallized with grit or mineral abrasive in accordance with Steel Structures Painting Council SSPC SP-5/10(as specified) to impart an angular surface profile of 2.5 - 4.0 mils (0.063 – 0.100 mm). Surface preparation hold times are in accordance with Section 7.32 of SSPC-CS 23. If flash rusting occurs prior to metallizing, blast clean the metal surface again. Apply the thermal sprayed coating only when the surface temperature of the steel is at least 5°F (3°C) above the dew point.

At the beginning of each work period or shift, conduct bend tests in accordance with Section 6.5 of SSPC-CS 23.00. Any disbonding or delamination of the coating that exposes the substrate requires corrective action, additional testing, and the Engineer's approval before resuming the metallizing process.

Apply TSC with the alloy to the thickness specified on the plans or as provided in the table below. All spot results (the average of 3 to 5 readings) must meet the minimum requirement. No additional tolerance (as allowed by SSPC PA-2) is permitted. (For Steel Beams: For pieces with less than 200 ft<sup>2</sup> (18.6m<sup>2</sup>) measure 2 spots/surface per piece and for pieces greater than 200 ft<sup>2</sup> (18.6m<sup>2</sup>) add 1 additional spots/surface for each 500 ft<sup>2</sup> (46.5m<sup>2</sup>)).

Application	Thickness	Alloy	Seal Coat
Pot Bearings	8 mil	85/15 Zinc (W-Zn-Al-2)	0.5 mil
Armored Joint Angles	8 mil	85/15 Zinc (W-Zn-Al-2)	0.5 mil
Modular Joints	8 mil	99.99% Zn (W-Zn-1)	0.5 mil
Expansion Joint Seals	8 mil	99.99% Zn (W-Zn-1)	0.5 mil
Optional Disc Bearings	8 mil	85/15 Zinc (W-Zn-Al-2)	0.5 mil

When noted on the plans or as specified in the above chart, apply the sealer to all metallized surfaces in accordance with the manufacturer's recommendations and these provisions. Apply the seal coat only when the air temperature is above 40°F (4°C) and the surface temperature of the steel is at least 5°F (3°C) above the dew point. If the sealer is not applied within eight hours after the final application of TSC, the applicator verifies acceptable TSC surfaces and obtains approval from the Engineer before applying the sealer.

## 5.0 INSPECTION FREQUENCY

The TSC Contractor must conduct the following tests at the specified frequency and the results documented in a format approved by the Engineer.

Test/Standard	Location	Frequency	Specification
Ambient Conditions	Site	Each Process	5°F (3°C) above the dew point
Abrasive Properties	Site	Each Day	Size, angularity, cleanliness
Surface Cleanliness SSPC Vis 1	All Surfaces	Visual All Surfaces	SSPC-SP-10 Atmospheric Service SSPC-SP - 5 Immersion Service
Surface Profile ASTM D-4417 Method C	Random Surfaces	3 per 500 ft <sup>2</sup>	2.5 - 4.0 mils
Bend Test SSPC-CS 23.00	Site	5 per shift	Pass Visual
Thickness SSPC PA-2R SSPC-CS 23.00	Each Surface	Use the method in PA-2 Appendix 3 for Girders and Appendix 4 for frames and miscellaneous steel. See Note 1.	Zn - 8 mils minimum Al - 8 mils minimum Zn Al - 8 mils minimum  Areas with more than twice the minimum thickness are inspected for compliance to the adhesion and cut testing requirements of this specification.
Adhesion ASTM 4541	Random Surfaces Splice Areas	1 set of 3 per 500 ft <sup>2</sup>	Zn > 500 psi Al > 1000 psi Zn Al > 750 psi
Cut Test - SSPC-CS 23.00	Random Surfaces	3 sets of 3 per 500 ft <sup>2</sup>	No peeling or delamination
Job Reference Std. SSPC-CS 23.00	Site	1 per job	Meets all the above requirements

## 6.0 REPAIRS

All Repairs are to be performed in accordance with the procedures below, depending on whether the repair surface is hidden or exposed. As an exception to the following, field welded splices on joint angles and field welding bearing plates to girders may be repaired in accordance with the procedures for hidden surfaces.

**For hidden surfaces (including but not limited to interior girders, interior faces of exterior girders, and below-grade sections of piles):**

1. Welding of metallized surfaces may be performed only if specifically permitted by the Engineer. Remove metallizing at the location of field welds by blast cleaning (SSPC SP-6 finish), or hand (SSPC SP-2 finish) or power tool cleaning (SSPC SP-3 finish) just prior to welding. Clean sufficiently to prevent contamination of the weld. All repairs to welded connections are metallized in accordance with SSPC CS 23.00.
2. Minor areas less than or equal to  $0.1 \text{ ft}^2$  ( $9300\text{mm}^2$ ) exposing the substrate are metallized in accordance with SSPC CS 23.00 or painted in accordance with ASTM A780, "Repair of Damaged and Uncoated Areas of Hot Dip Galvanized Coatings."
3. Large areas greater than  $0.1 \text{ ft}^2$  ( $9300\text{mm}^2$ ) exposing the substrate are metallized in accordance with SSPC CS 23.00.
4. Damaged (burnished) areas not exposing the substrate with less than the specified coating thickness are metallized in accordance with SSPC CS 23.00 or painted in accordance with ASTM A780, "Repair of Damaged and Uncoated Areas of Hot Dip Galvanized Coatings."
5. Damaged (burnished) areas not exposing the substrate with more than the specified coating thickness are not repaired.
6. Defective coating is repaired by either method 2 or 3 depending on the area of the defect.

**For Exposed Surfaces (including but not limited to exterior faces of exterior girders and above-grade sections of piles):**

1. Welding of metallized surfaces may be performed only if specifically permitted by the Engineer. Remove metallization at the location of field welds by blast cleaning (SSPC SP-6 finish), or hand (SSPC SP-2 finish) or power tool cleaning (SSPC SP-3 finish) just prior to welding. Clean sufficiently to prevent contamination of the weld. All repairs to welded connections are metallized in accordance with SSPC CS 23.00.
2. All areas exposing the substrate are metallized in accordance with SSPC CS 23.00
3. Defective coating is repaired by either method 2 or 3 depending on the area of the defect.

## **7.0 TWELVE MONTH OBSERVATION PERIOD**

The contractor maintains responsibility for the coating system for a twelve (12) month observation period beginning upon the satisfactory completion of all the work required in the plans or as directed by the engineer. The contractor must guarantee the coating system under the payment and performance bond (refer to article 109-10). To successfully complete the observation period, the coating system must meet the following requirements after twelve(12) months service:

- No visible rust, contamination or application defect is observed in any coated area.
- Painted surfaces have a uniform color and gloss.



- Surfaces have an adhesion of no less than 500 psi (3.45 MPa) when tested in accordance with ASTM D-4541.

**8.0 BASIS OF PAYMENT**

The contract price bid for the bridge component to which the coating is applied will be full compensation for the thermal sprayed coating.

**EVAZOTE JOINT SEALS**

**(11-5-10)**

**1.0 SEALS**

Use preformed seals compatible with concrete and resistant to abrasion, oxidation, oils, gasoline, salt and other materials that are spilled on or applied to the surface. Use a resilient, UV stable, preformed, impermeable, flexible, expansion joint seal. The joint seal shall consist of low-density, closed cell, cross-linked polyethylene non-extrudable, foam. The joint seal shall contain no EVA (Ethylene Vinyl Acetate). Cell generation shall be achieved by being physically blown using nitrogen. No chemical blowing agents shall be used in the cell generation process.

Use seals manufactured with grooves 1/8" (3 mm) ± wide by 1/8" (3 mm) ± deep and spaced between 1/4" (6 mm) and 1/2" (13 mm) apart along the bond surface running the length of the joint. Use seals with a depth that meets the manufacturer's recommendation, but is not less than 70% of the uncompressed width. Provide a seal designed so that, when compressed, the center portion of the top does not extend upward above the original height of the seal by more than 1/4" (6 mm). Provide a seal that has a working range of 30% tension and 60% compression and meets the requirements given below.

TEST	TEST METHOD	REQUIREMENT
Tensile strength	ASTM D3575-08, Suffix T	110 – 130 psi (758 – 896 kpa)
Compression Set	ASTM D1056 Suffix B, 2 hr recovery	10% - 16%
Water Absorption	ASTM D3575	< 0.03 lb/ft <sup>2</sup> (< 0.001 kpa)
Elongation at Break	ASTM D3575	180% - 210%
Tear Strength	ASTM D624 (D3575-08, Suffix G)	14 – 20 pli
Density	ASTM D3575-08, Suffix W, Method A	1.8 – 2.2 lb/ft <sup>3</sup> (28.8 – 35.2 kg/m <sup>3</sup> )
Toxicity	ISO-10993.5	Pass (not cytotoxic)

Have the top of the evazote seal clearly shop marked. Inspect the evazote seals upon receipt to ensure that the marks are clearly visible before installation.

## 2.0 BONDING ADHESIVE

Use a two component, 100% solid, modified epoxy adhesive supplied by the joint seal manufacturer that meets the requirements given below.

TEST	TEST METHOD	REQUIREMENT
Tensile strength	ASTM D638	3000 psi (20.7 MPa) min.
Compressive strength	ASTM D695	7000 psi (48.3 MPa) min.
Hardness	Shore D Scale	75-85 psi (0.51-0.58 MPa)
Water Absorption	ASTM D570	0.25% by weight max.
Elongation to Break	ASTM D638	5% max.
Bond Strength	ASTM C882	2000 psi (13.8 MPa) min.

Use an adhesive that is workable to 40°F (4°C). When installing in ambient air or surface temperatures below 40°F (4°C) or for application on moist, difficult to dry concrete surfaces, use an adhesive specified by the manufacturer of the joint seal.

## 3.0 ELASTOMERIC CONCRETE

The elastomeric concrete shall not be placed until the reinforced concrete deck slab has cured for seven full days and reached a minimum strength of 3000 psi (20.7 Mpa).

Prepare the concrete surface within 48 hours prior to placing the elastomeric concrete. Before placing the elastomeric concrete, all concrete surfaces shall be thoroughly cleaned and dry. Sandblast the concrete surface in the blockout and clear the surface of all loose debris. Do not place the elastomeric concrete until the surface preparation is completed and approved.

A manufacturer's representative shall be present when placing elastomeric concrete. Do not place elastomeric concrete if the ambient air or surface temperature is below 45°F (7°C).

Prepare and apply a primer, as per manufacturer's recommendations, to all vertical concrete faces to be in contact with elastomeric concrete, and to areas specified by the manufacturer.

Prepare, batch, and place the elastomeric concrete in accordance with the manufacturer's instructions. Place the elastomeric concrete in the areas specified on the plans while the primer is still tacky and within 2 hours after applying the primer. Trowel the elastomeric concrete to a smooth finish.

#### 4.0 SAWING THE JOINT

The joint opening shall be initially formed to the width shown on the plans including the blackout for the elastomeric concrete.

The elastomeric concrete shall cure a minimum of 2 days prior to sawing the elastomeric concrete to the final width and depth as specified in the plans.

When sawing the joint to receive the evazote seal, always use a rigid guide to control the saw in the desired direction. To control the saw and to produce a straight line as indicated on the plans, anchor and positively connect a template or a track to the bridge deck. Do not saw the joint by visual means such as a chalk line. Fill the holes used for holding the template or track to the deck with an approved, flowable non-shrink, non-metallic grout.

Saw cut to the desired width and depth in one or two passes of the saw by placing and spacing two metal blades on the saw shaft to the desired width for the joint opening.

The desired depth is the depth of the seal plus 1/4" (6 mm) above the top of the seal plus approximately 1" (25 mm) below the bottom of the seal. An irregular bottom of sawed joint is permitted as indicated on the plans. Grind exposed corners on saw cut edges to a 1/4" (6 mm) chamfer.

Saw cut a straight joint, centered over the formed opening and to the desired width specified in the plans. Prevent any chipping or damage to the sawed edges of the joint.

Remove any staining or deposited material resulting from sawing with a wet blade to the satisfaction of the Engineer.

#### 5.0 PREPARATION OF SAWED JOINT FOR SEAL INSTALLATION

After sawing the joint, the Engineer will thoroughly inspect the sawed joint opening for spalls, popouts, cracks, etc. All necessary repairs will be made by the Contractor prior to blast cleaning and installing the seal.

Clean the joints by sandblasting with clean dry sand immediately before placing the bonding agent. Sandblast the joint opening to provide a firm, clean joint surface free of curing compound, loose material and any foreign matter. Sandblast the joint opening without causing pitting or uneven surfaces. The aggregate in the elastomeric concrete may be exposed after sandblasting.

After blasting, either brush the surface with clean brushes made of hair, bristle or fiber, blow the surface with compressed air, or vacuum the surface until all traces of blast products and abrasives are removed from the surface, pockets, and corners.

If nozzle blasting is used to clean the joint opening, use compressed air that does not contain detrimental amounts of water or oil.

Examine the blast cleaned surface and remove any traces of oil, grease or smudge deposited in the cleaning operations.

Bond the seal to the blast cleaned surface on the same day the surface is blast cleaned.

## **6.0 SEAL INSTALLATION**

Install the joint seal according to the manufacturer's procedures and recommendations and as recommended below. Do not install the joint seal if the ambient air or surface temperature is below 45°F (7°C). Have a manufacturer's certified trained factory representative present during the installation of the first seal of the project.

Before installing the joint seal, check the uninstalled seal length to insure the seal is the same length as the deck opening. When the joint seal requires splicing, use the heat welding method by placing the joint material ends against a teflon heating iron of 425-475°F (218-246°C) for 7 - 10 seconds, then pressing the ends together tightly. Do not test the welding until the material has completely cooled.

Begin installation by protecting the top edges of the concrete deck adjacent to the vertical walls of the joint as a means to minimize clean up. After opening both cans of the bonding agent, stir each can using separate stirring rods for each component to prevent premature curing of the bonding agent. Pour the two components, at the specified mixing ratio, into a clean mixing bucket. Mix the components with a low speed drill (400 rpm max.) until a uniform gray color is achieved without visible marbling. Apply bonding agent to both sides of the elastomeric concrete as well as both sides of the joint seal, making certain to completely fill the grooves with epoxy. With gloved hands, compress the joint seal and with the help of a blunt probe, push the seal into the joint opening until the seal is recessed approximately 1/4" (6 mm) below the surface. When pushing down on the joint seal, apply pressure only in a downward direction. Do not push the joint seal into the joint opening at an angle that would stretch the material. Seals that are stretched during installation shall be removed and rejected. Once work on placing a seal begins, do not stop until it is completed. Clean the excess epoxy from the top of the joint seal immediately with a trowel. Do not use solvents or any cleaners to remove the excess epoxy from the top of the seal. Remove the protective cover at the joint edges and check for any excess epoxy on the surface. Remove excess epoxy with a trowel, the use of solvents or any cleaners will not be allowed.

The installed system shall be watertight and will be monitored until final inspection and approval.

## **7.0 BASIS OF PAYMENT**

Payment for all evazote joint seals will be at the lump sum contract price bid for "Evazote Joint Seals". Prices and payment will be full compensation for furnishing all material, including elastomeric concrete, labor, tools and equipment necessary for installing these units in place and accepted.

**ELASTOMERIC CONCRETE****(1-27-10)****1.0 DESCRIPTION**

Elastomeric concrete is a mixture of a two-part polymer consisting of polyurethane and/or epoxy and kiln-dried aggregate. Provide an elastomeric concrete and binder system that is preapproved. Use the concrete in the blocked out areas on both sides of the bridge deck joints as indicated on the plans.

**2.0 MATERIALS**

Provide materials that comply with the following minimum requirements at 14 days (or at the end of the specified curing time).

<b>ELASTOMERIC CONCRETE PROPERTIES</b>	<b>TEST METHOD</b>	<b>MINIMUM REQUIREMENT</b>
Compressive Strength, psi (MPa)	(a) STM D695	2000 (13.8)
5% Deflection Resilience	ASTM D695	95
Splitting Tensile Strength	ASTM D3967	625 (4.31)
Bond Strength to Concrete, psi (MPa)	ASTM D882 (D882M)	450 (3.10)
Durometer Hardness	ASTM D2240	50

<b>BINDER PROPERTIES (without aggregate)</b>	<b>TEST METHOD</b>	<b>MINIMUM REQUIREMENT</b>
Tensile Strength, psi (MPa)	ASTM D638	1000 (6.89)
Ultimate Elongation	ASTM D638	150%
Tear Resistance, lb/in (kN/m)	ASTM D624	200 (34.9)

In addition to the requirements above, the elastomeric concrete must be resistant to water, chemical, UV and ozone exposure and withstand temperature extremes. Elastomeric concrete systems requiring preheated aggregates are not allowed.

### **3.0 PREQUALIFICATION**

Manufacturers of elastomeric concrete materials shall submit samples (including aggregate, primer and binder materials) and a Type 4 certification in accordance with article 106-3 (F) of the Standard Specifications for prequalification to:

North Carolina Department of Transportation  
Materials and Tests Unit  
1801 Blue Ridge Road  
Raleigh, NC 27607

Prequalification will be determined for the system. Individual components will not be evaluated, nor will individual components of previously evaluated systems be deemed prequalified for use.

The submitted binder (a minimum volume of 1 gallon) and corresponding aggregate samples will be evaluated for compliance with the Materials requirements specified above. Systems satisfying all of the Materials requirements will be prequalified for a one year period. Before the end of this period new product samples shall be resubmitted for prequalification evaluation.

If, at any time, any formulation or component modifications are made to a prequalified system that system will no longer be approved for use.

### **4.0 MATERIAL CERTIFICATION AND INSTALLATION**

Provide a Type 5 certification in accordance with article 106-3 (F) of the Standard Specifications, verifying that the materials satisfy the above requirements and proof of NCDOT prequalification.

Prior to placing the elastomeric concrete, thoroughly clean and dry all concrete surfaces. Sandblast the concrete surface in the blockout and clear the surface of all loose debris.

Provide a manufacturer's representative at the bridge site during the installation of the elastomeric concrete to ensure that all steps being performed comply with all manufacturer installation requirements including, but not limited to weather conditions (ambient temperature, relative humidity, precipitation, wind, etc), concrete deck surface preparation, binder and aggregate mixing, primer application, elastomeric concrete placement, curing conditions and minimum curing time before joint exposure to traffic.

### **5.0 FIELD SAMPLING**

Provide additional production material to allow freshly mixed elastomeric concrete to be sampled for acceptance. A minimum of six 2 inch cube molds and three 3x6 inch cylinders will be taken by the Department for each day's production. Compression, splitting tensile, and durometer hardness testing will be performed by the Department to determine acceptance. Materials failing to meet the requirements listed above are subject to removal and replacement at no cost to the Department.

## 6.0 BASIS OF PAYMENT

No separate payment will be made for elastomeric concrete. The lump sum contract price bid for “Evazote Joint Seals” will be full compensation for furnishing and placing the Elastomeric Concrete.

## FALSEWORK AND FORMWORK

(4-1-11)

### 1.0 DESCRIPTION

Use this Special Provision as a guide to develop temporary works submittals required by the Standard Specifications or other provisions; no additional submittals are required herein. Such temporary works include, but are not limited to, falsework and formwork.

Falsework is any temporary construction used to support the permanent structure until it becomes self-supporting. Formwork is the temporary structure or mold used to retain plastic or fluid concrete in its designated shape until it hardens. Access scaffolding is a temporary structure that functions as a work platform that supports construction personnel, materials, and tools, but is not intended to support the structure. Scaffolding systems that are used to temporarily support permanent structures (as opposed to functioning as work platforms) are considered to be falsework under the definitions given. Shoring is a component of falsework such as horizontal, vertical, or inclined support members. Where the term “temporary works” is used, it includes all of the temporary facilities used in bridge construction that do not become part of the permanent structure.

Design and construct safe and adequate temporary works that will support all loads imposed and provide the necessary rigidity to achieve the lines and grades shown on the plans in the final structure.

### 2.0 MATERIALS

Select materials suitable for temporary works; however, select materials that also ensure the safety and quality required by the design assumptions. The Engineer has authority to reject material on the basis of its condition, inappropriate use, safety, or nonconformance with the plans. Clearly identify allowable loads or stresses for all materials or manufactured devices on the plans. Revise the plan and notify the Engineer if any change to materials or material strengths is required.

### 3.0 DESIGN REQUIREMENTS

#### A. Working Drawings

Provide working drawings for items as specified in the contract, or as required by the Engineer, with design calculations and supporting data in sufficient detail to permit a structural and safety review of the proposed design of the temporary work.

On the drawings, show all information necessary to allow the design of any component to be checked independently as determined by the Engineer.

When concrete placement is involved, include data such as the drawings of proposed sequence, rate of placement, direction of placement, and location of all construction joints. Submit the number of copies as called for by the contract.

When required, have the drawings and calculations prepared under the guidance of, and sealed by, a North Carolina Registered Professional Engineer who is knowledgeable in temporary works design.

If requested by the Engineer, submit with the working drawings manufacturer's catalog data listing the weight of all construction equipment that will be supported on the temporary work. Show anticipated total settlements and/or deflections of falsework and forms on the working drawings. Include falsework footing settlements, joint take-up, and deflection of beams or girders. Falsework hangers that support concentrated loads and are installed at the edge of thin top flange concrete girders (such as bulb tee girders) shall be spaced so as not to exceed 75% of the manufacturer's stated safe working load. Use of dual leg hangers (such as Meadow Burke HF-42 and HF-43) are not allowed on concrete girders with thin top flanges. Design the falsework and forms supporting deck slabs and overhangs on girder bridges so that there will be no differential settlement between the girders and the deck forms during placement of deck concrete.

When staged construction of the bridge deck is required, detail falsework and forms for screed and fluid concrete loads to be independent of any previous deck pour components when the mid-span girder deflection due to deck weight is greater than  $\frac{3}{4}$ ".

Note on the working drawings any anchorages, connectors, inserts, steel sleeves or other such devices used as part of the falsework or formwork that remains in the permanent structure. If the plan notes indicate that the structure contains the necessary corrosion protection required for a Corrosive Site, epoxy coat, galvanize or metalize these devices. Electroplating will not be allowed. Any coating required by the Engineer will be considered incidental to the various pay items requiring temporary works.



Design falsework and formwork requiring submittals in accordance with the 1995 AASHTO *Guide Design Specifications for Bridge Temporary Works* except as noted herein.

### 1. Wind Loads

Table 2.2 of Article 2.2.5.1 is modified to include wind velocities up to 110 mph (177 km/hr). In addition, Table 2.2A is included to provide the maximum wind speeds by county in North Carolina.

**Table 2.2 - Wind Pressure Values**

Height Zone feet (m) above ground	Pressure, lb/ft <sup>2</sup> (kPa) for Indicated Wind Velocity, mph (km/hr)				
	70 (112.7)	80 (128.7)	90 (144.8)	100 (160.9)	110 (177.0)
0 to 30 (0 to 9.1)	15 (0.72)	20 (0.96)	25 (1.20)	30 (1.44)	35 (1.68)
30 to 50 (9.1 to 15.2)	20 (0.96)	25 (1.20)	30 (1.44)	35 (1.68)	40 (1.92)
50 to 100 (15.2 to 30.5)	25 (1.20)	30 (1.44)	35 (1.68)	40 (1.92)	45 (2.15)
over 100 (30.5)	30 (1.44)	35 (1.68)	40 (1.92)	45 (2.15)	50 (2.39)

### 2. Time of Removal

The following requirements replace those of Article 3.4.8.2.

Do not remove forms until the concrete has attained strengths required in Article 420-16 of the Standard Specifications and these Special Provisions.

Do not remove forms until the concrete has sufficient strength to prevent damage to the surface.

**Table 2.2A - Steady State Maximum Wind Speeds by Counties in North Carolina**

COUNTY	25 YR (mph) (km/hr)	COUNTY	25 YR (mph) (km/hr)	COUNTY	25 YR (mph) (km/hr)
Alamance	70 (112.7)	Franklin	70 (112.7)	Pamlico	100 (160.9)
Alexander	70 (112.7)	Gaston	70 (112.7)	Pasquotank	100 (160.9)
Alleghany	70 (112.7)	Gates	90 (144.8)	Pender	100 (160.9)
Anson	70 (112.7)	Graham	80 (128.7)	Perquimans	100 (160.9)
Ashe	70 (112.7)	Granville	70 (112.7)	Person	70 (112.7)
Avery	70 (112.7)	Greene	80 (128.7)	Pitt	90 (144.8)
Beaufort	100 (160.9)	Guilford	70 (112.7)	Polk	80 (128.7)
Bertie	90 (144.8)	Halifax	80 (128.7)	Randolph	70 (112.7)
Bladen	90 (144.8)	Harnett	70 (112.7)	Richmond	70 (112.7)
Brunswick	100 (160.9)	Haywood	80 (128.7)	Robeson	80 (128.7)
Buncombe	80 (128.7)	Henderson	80 (128.7)	Rockingham	70 (112.7)
Burke	70 (112.7)	Hertford	90 (144.8)	Rowan	70 (112.7)
Cabarrus	70 (112.7)	Hoke	70 (112.7)	Rutherford	70 (112.7)
Caldwell	70 (112.7)	Hyde	110 (177.0)	Sampson	90 (144.8)
Camden	100 (160.9)	Iredell	70 (112.7)	Scotland	70 (112.7)
Carteret	110 (177.0)	Jackson	80 (128.7)	Stanley	70 (112.7)
Caswell	70 (112.7)	Johnston	80 (128.7)	Stokes	70 (112.7)
Catawba	70 (112.7)	Jones	100 (160.9)	Surry	70 (112.7)
Cherokee	80 (128.7)	Lee	70 (112.7)	Swain	80 (128.7)
Chatham	70 (112.7)	Lenoir	90 (144.8)	Transylvania	80 (128.7)
Chowan	90 (144.8)	Lincoln	70 (112.7)	Tyrell	100 (160.9)
Clay	80 (128.7)	Macon	80 (128.7)	Union	70 (112.7)
Cleveland	70 (112.7)	Madison	80 (128.7)	Vance	70 (112.7)
Columbus	90 (144.8)	Martin	90 (144.8)	Wake	70 (112.7)
Craven	100 (160.9)	McDowell	70 (112.7)	Warren	70 (112.7)
Cumberland	80 (128.7)	Mecklenburg	70 (112.7)	Washington	100 (160.9)
Currituck	100 (160.9)	Mitchell	70 (112.7)	Watauga	70 (112.7)
Dare	110 (177.0)	Montgomery	70(112.7)	Wayne	80 (128.7)
Davidson	70 (112.7)	Moore	70 (112.7)	Wilkes	70 (112.7)
Davie	70 (112.7)	Nash	80 (128.7)	Wilson	80 (128.7)
Duplin	90 (144.8)	New Hanover	100 (160.9)	Yadkin	70 (112.7)
Durham	70 (112.7)	Northampton	80 (128.7)	Yancey	70 (112.7)
Edgecombe	80 (128.7)	Onslow	100 (160.9)		
Forsyth	70 (112.7)	Orange	70 (112.7)		

## B. Review and Approval

The Engineer is responsible for the review and approval of temporary works' drawings.

Submit the working drawings sufficiently in advance of proposed use to allow for their review, revision (if needed), and approval without delay to the work.

The time period for review of the working drawings does not begin until complete drawings and design calculations, when required, are received by the Engineer.

Do not start construction of any temporary work for which working drawings are required until the drawings have been approved. Such approval does not relieve the Contractor of the responsibility for the accuracy and adequacy of the working drawings.

## 4.0 CONSTRUCTION REQUIREMENTS

All requirements of Section 420 of the Standard Specifications apply.

Construct temporary works in conformance with the approved working drawings. Ensure that the quality of materials and workmanship employed is consistent with that assumed in the design of the temporary works. Do not weld falsework members to any portion of the permanent structure unless approved. Show any welding to the permanent structure on the approved construction drawings.

Provide tell-tales attached to the forms and extending to the ground, or other means, for accurate measurement of falsework settlement. Make sure that the anticipated compressive settlement and/or deflection of falsework does not exceed 1 inch (25 mm). For cast-in-place concrete structures, make sure that the calculated deflection of falsework flexural members does not exceed 1/240 of their span regardless of whether or not the deflection is compensated by camber strips.

### A. Maintenance and Inspection

Inspect and maintain the temporary work in an acceptable condition throughout the period of its use. Certify that the manufactured devices have been maintained in a condition to allow them to safely carry their rated loads. Clearly mark each piece so that its capacity can be readily determined at the job site.

Perform an in-depth inspection of an applicable portion(s) of the temporary works, in the presence of the Engineer, not more than 24 hours prior to the beginning of each concrete placement. Inspect other temporary works at least once a month to ensure that they are functioning properly. Have a North Carolina Registered Professional Engineer inspect the cofferdams, shoring, sheathing, support of excavation structures, and support systems for load tests prior to loading.

## B. Foundations

Determine the safe bearing capacity of the foundation material on which the supports for temporary works rest. If required by the Engineer, conduct load tests to verify proposed bearing capacity values that are marginal or in other high-risk situations.

The use of the foundation support values shown on the contract plans of the permanent structure is permitted if the foundations are on the same level and on the same soil as those of the permanent structure.

Allow for adequate site drainage or soil protection to prevent soil saturation and washout of the soil supporting the temporary works supports.

If piles are used, the estimation of capacities and later confirmation during construction using standard procedures based on the driving characteristics of the pile is permitted. If preferred, use load tests to confirm the estimated capacities; or, if required by the Engineer conduct load tests to verify bearing capacity values that are marginal or in other high risk situations.

The Engineer reviews and approves the proposed pile and soil bearing capacities.

## 5.0 REMOVAL

Unless otherwise permitted, remove and keep all temporary works upon completion of the work. Do not disturb or otherwise damage the finished work.

Remove temporary works in conformance with the contract documents. Remove them in such a manner as to permit the structure to uniformly and gradually take the stresses due to its own weight.

## 6.0 METHOD OF MEASUREMENT

Unless otherwise specified, temporary works will not be directly measured.

## 7.0 BASIS OF PAYMENT

Payment at the contract unit prices for the various pay items requiring temporary works will be full compensation for the above falsework and formwork.

## **SUBMITTAL OF WORKING DRAWINGS**

**(4-1-11)**

### 1.0 GENERAL

Submit working drawings in accordance with Article 105-2 of the *Standard Specifications* and this provision. For this provision, "submittals" refers to only those listed in this provision. The list of submittals contained herein does not represent a list of required submittals for the project. Submittals are only necessary for those items as required by the

contract. Make submittals that are not specifically noted in this provision directly to the Resident Engineer. Either the Structure Design Unit or the Geotechnical Engineering Unit or both units will jointly review submittals.

If a submittal contains variations from plan details or specifications or significantly affects project cost, field construction or operations, discuss the submittal with and submit all copies to the Resident Engineer. State the reason for the proposed variation in the submittal. To minimize review time, make sure all submittals are complete when initially submitted. Provide a contact name and information with each submittal. Direct any questions regarding submittal requirements to the Resident Engineer, Structure Design Unit contacts or the Geotechnical Engineering Unit contacts noted below.

In order to facilitate in-plant inspection by NCDOT and approval of working drawings, provide the name, address and telephone number of the facility where fabrication will actually be done if different than shown on the title block of the submitted working drawings. This includes, but is not limited to, precast concrete items, prestressed concrete items and fabricated steel or aluminum items.

## 2.0 ADDRESSES AND CONTACTS

For submittals to the Structure Design Unit, use the following addresses:

Via US mail:

Mr. G. R. Perfetti, P. E.  
State Bridge Design Engineer  
North Carolina Department  
of Transportation  
Structure Design Unit  
1581 Mail Service Center  
Raleigh, NC 27699-1581

Attention: Mr. P. D. Lambert, P. E.

Via other delivery service:

Mr. G. R. Perfetti, P. E.  
State Bridge Design Engineer  
North Carolina Department  
of Transportation  
Structure Design Unit  
1000 Birch Ridge Drive  
Raleigh, NC 27610

Attention: Mr. P. D. Lambert, P. E.

Submittals may also be made via email.

Send submittals to:

[plambert@ncdot.gov](mailto:plambert@ncdot.gov) (Paul Lambert)

Send an additional e-copy of the submittal to the following address:

[jgaither@ncdot.gov](mailto:jgaither@ncdot.gov) (James Gaither)

For submittals to the Geotechnical Engineering Unit, use the following addresses:

For projects in Divisions 1-7, use the following Eastern Regional Office address:

Via US mail:

Mr. K. J. Kim, Ph. D., P. E.  
Eastern Regional Geotechnical  
Manager  
North Carolina Department  
of Transportation  
Geotechnical Engineering Unit  
Eastern Regional Office  
1570 Mail Service Center  
Raleigh, NC 27699-1570

Via other delivery service:

Mr. K. J. Kim, Ph. D., P. E.  
Eastern Regional Geotechnical  
Manager  
North Carolina Department  
of Transportation  
Geotechnical Engineering Unit  
Eastern Regional Office  
3301 Jones Sausage Road, Suite 100  
Garner, NC 27529

For projects in Divisions 8-14, use the following Western Regional Office address:

Via US mail:

Mr. John Pilipchuk, L. G., P. E.  
Western Regional Geotechnical  
Manager  
North Carolina Department  
of Transportation  
Geotechnical Engineering Unit  
Western Regional Office  
5253 Z Max Boulevard  
Harrisburg, NC 28075

Via other delivery service:

Mr. John Pilipchuk, L. G., P. E.  
Western Region Geotechnical  
Manager  
North Carolina Department  
of Transportation  
Geotechnical Engineering Unit  
Western Regional Office  
5253 Z Max Boulevard  
Harrisburg, NC 28075

The status of the review of structure-related submittals sent to the Structure Design Unit can be viewed from the Unit's web site, via the "Contractor Submittal" link.

Direct any questions concerning submittal review status, review comments or drawing markups to the following contacts:

Primary Structures Contact:

Paul Lambert  
(919) 250 – 4041  
(919) 250 – 4082 facsimile  
[plambert@ncdot.gov](mailto:plambert@ncdot.gov)

Secondary Structures Contacts:

James Gaither (919) 250 – 4042  
David Stark (919) 250 – 4044

**Eastern Regional Geotechnical Contact (Divisions 1-7):**

K. J. Kim  
(919) 662 – 4710  
(919) 662 – 3095 facsimile  
[kkim@ncdot.gov](mailto:kkim@ncdot.gov)

**Western Regional Geotechnical Contact (Divisions 8-14):**

John Pilipchuk  
(704) 455 – 8902  
(704) 455 – 8912 facsimile  
[jpilipchuk@ncdot.gov](mailto:jpilipchuk@ncdot.gov)

**3.0 SUBMITTAL COPIES**

Furnish one complete copy of each submittal, including all attachments, to the Resident Engineer. At the same time, submit the number of hard copies shown below of the same complete submittal directly to the Structure Design Unit and/or the Geotechnical Engineering Unit.

The first table below covers “Structure Submittals”. The Resident Engineer will receive review comments and drawing markups for these submittals from the Structure Design Unit. The second table in this section covers “Geotechnical Submittals”. The Resident Engineer will receive review comments and drawing markups for these submittals from the Geotechnical Engineering Unit.

Unless otherwise required, submit one set of supporting calculations to either the Structure Design Unit or the Geotechnical Engineering Unit unless both units require submittal copies in which case submit a set of supporting calculations to each unit. Provide additional copies of any submittal as directed.

**STRUCTURE SUBMITTALS**

<b>Submittal</b>	<b>Copies Required by Structure Design Unit</b>	<b>Copies Required by Geotechnical Engineering Unit</b>	<b>Contract Reference Requiring Submittal<sup>1</sup></b>
Arch Culvert Falsework	5	0	Plan Note, SN Sheet & "Falsework and Formwork"
Box Culvert Falsework <sup>7</sup>	5	0	Plan Note, SN Sheet & "Falsework and Formwork"
Cofferdams	6	2	Article 410-4
Evazote Joint Seals <sup>6</sup>	9	0	"Evazote Joint Seals"
Expansion Joint Seals (hold down plate type with base angle)	9	0	"Expansion Joint Seals"
Expansion Joint Seals (modular)	2, then 9	0	"Modular Expansion Joint Seals"
Expansion Joint Seals (strip seals)	9	0	"Strip Seals"
Falsework & Forms <sup>2</sup> (substructure)	8	0	Article 420-3 & "Falsework and Formwork"
Falsework & Forms (superstructure)	8	0	Article 420-3 & "Falsework and Formwork"
Girder Erection over Railroad	5	0	Railroad Provisions
Maintenance and Protection of Traffic Beneath Proposed Structure	8	0	"Maintenance and Protection of Traffic Beneath Proposed Structure at Station ____"
Metal Bridge Railing	8	0	Plan Note
Metal Stay-in-Place Forms	8	0	Article 420-3



Metalwork for Elastomeric Bearings <sup>4,5</sup>	7	0	Article 1072-10.
Miscellaneous Metalwork <sup>4,5</sup>	7	0	Article 1072-10
Optional Disc Bearings <sup>4</sup>	8	0	“Optional Disc Bearings”
Overhead Signs	13	0	Article 903-3(C) & Applicable Provisions
Placement of Equipment on Structures (cranes, etc.)	7	0	Article 420-20
Pot Bearings <sup>4</sup>	8	0	“Pot Bearings”
Precast Concrete Box Culverts	2, then 1 reproducible	0	“Optional Precast Reinforced Concrete Box Culvert at Station ____”
Precast Retaining Wall Panels	10	1	Article 1077-2
Prestressed Concrete Cored Slab (detensioning sequences) <sup>3</sup>	6	0	Article 1078-11
Prestressed Concrete Deck Panels	6 and 1 reproducible	0	Article 420-3
Prestressed Concrete Girder (strand elongation and detensioning sequences)	6	0	Articles 1078-8 and 1078-11
Removal of Existing Structure over Railroad	5	0	Railroad Provisions
Revised Bridge Deck Plans (adaptation to prestressed deck panels)	2, then 1 reproducible	0	Article 420-3
Revised Bridge Deck Plans (adaptation to modular expansion joint seals)	2, then 1 reproducible	0	“Modular Expansion Joint Seals”
Sound Barrier Wall Casting Plans	10	0	Article 1077-2 & “Sound Barrier Wall”
Sound Barrier Wall Steel Fabrication Plans <sup>5</sup>	7	0	Article 1072-10 & “Sound Barrier Wall”

Structural Steel <sup>4</sup>	2, then 7	0	Article 1072-10
Temporary Detour Structures	10	2	Article 400-3 & “Construction, Maintenance and Removal of Temporary Structure at Station _____”
TFE Expansion Bearings <sup>4</sup>	8	0	Article 1072-10

#### FOOTNOTES

1. References are provided to help locate the part of the contract where the submittals are required. References in quotes refer to the provision by that name. Articles and subarticles refer to the *Standard Specifications*.
2. Submittals for these items are necessary only when required by a note on plans.
3. Submittals for these items may not be required. A list of pre-approved sequences is available from the producer or the Materials & Tests Unit.
4. The fabricator may submit these items directly to the Structure Design Unit.
5. The two sets of preliminary submittals required by Article 1072-10 of the *Standard Specifications* are not required for these items.
6. Submittals for Fabrication Drawings are not required. Submittals for Catalogue Cuts of Proposed Material are required. See Section 5.A of the referenced provision.
7. Submittals are necessary only when the top slab thickness is 18” or greater.

**GEOTECHNICAL SUBMITTALS**

<b>Submittal</b>	<b>Copies Required by Geotechnical Engineering Unit</b>	<b>Copies Required by Structure Design Unit</b>	<b>Contract Reference Requiring Submittal<sup>1</sup></b>
Drilled Pier Construction Plans <sup>2</sup>	1	0	“Drilled Piers”
Crosshole Sonic Logging (CSL) Reports <sup>2</sup>	1	0	“Crosshole Sonic Logging” & “Drilled Piers”
Pile Driving Equipment Data Form <sup>2,3</sup>	1	0	Article 450-5 & “Piles”
Pile Driving Analyzer (PDA) Reports <sup>2</sup>	1	0	“Pile Driving Analyzer” & “Piles”
Retaining Walls <sup>4</sup>	8	2	Applicable Provisions
Contractor Designed Shoring <sup>4</sup>	7	2	“Temporary Shoring”, “Anchored Temporary Shoring” & “Temporary Soil Nail Walls”

**FOOTNOTES**

- References are provided to help locate the part of the contract where the submittals are required. References in quotes refer to the provision by that name. Articles refer to the *Standard Specifications*.
- Submit one hard copy of submittal to the Resident or Bridge Maintenance Engineer. Submit a second copy of submittal electronically (PDF via email) or by facsimile, US mail or other delivery service to the Geotechnical Engineering Unit. Electronic submission is preferred.
- Download Pile Driving Equipment Data Form from the following link:  
[www.ncdot.org/doh/preconstruct/highway/geotech/formdet/](http://www.ncdot.org/doh/preconstruct/highway/geotech/formdet/)  
See second page of form for submittal instructions.
- Electronic copies of submittal are required. See referenced provision.

**CONSTRUCTION, MAINTENANCE AND REMOVAL  
OF TEMPORARY ACCESS AT STATION 22+24.50-L-**

(11-17-06)

**1.0 GENERAL**

Construct, maintain, and remove the temporary access required to provide the working area necessary for construction of the new bridge, construction of the temporary detour structure, or for the removal of an existing bridge, as applicable. Temporary access may include other methods than those outlined in this Special Provision; however, all types of temporary access are required to meet the requirements of all permits, the Standard Specifications, and this Special Provision.

**2.0 TEMPORARY ROCK CAUSEWAY [WORKPAD]**

Construction of a temporary rock causeway [workpad] within the limits shown on the plans is permitted. Build the causeway [workpad] with Class II riprap topped by a layer of Class A riprap or as otherwise designated on the plans or approved by the Engineer. If desired, recycle the Class II riprap used in the causeway [workpad] for placement in the final riprap slope protection as directed by the Engineer. No payment will be made for recycled riprap as this material is considered incidental to the causeway [workpad] placement and removal. If this option is exercised, no adjustment in contract bid price will be allowed due to an underrun in the quantity of "Plain Rip Rap Class II (2'-0" (600 mm) Thick)".

Completely remove all causeway [workpad] material including pipes and return the entire causeway [workpad] footprint to the original contours and elevations within 90 days of the completion of the deck slab or as otherwise required by permits.

For sites affected by moratoriums or restrictions on in-stream work: Do not construct or remove causeway [workpad] during the moratorium period shown on the permit. If the completion of the deck slab falls within the prohibitive dates for causeway [workpad] construction or removal, begin causeway [workpad] removal immediately following the prohibitive dates.

**3.0 TEMPORARY WORK BRIDGE**

At the contractor's option, construction of a temporary work bridge in lieu of the causeway(s) [workpad] is acceptable, provided the temporary work bridge satisfies all permits. Submit details of the temporary work bridge to the Engineer prior to constructing the work bridge to ensure conformance with the plans and all permits. Completely remove the temporary bridge prior to final acceptance or as otherwise required by the permits.

**4.0 BASIS OF PAYMENT**

The lump sum price bid for "Construction, Maintenance and Removal of Temporary Access at Station 22+24.50-L-" will be full compensation for the above work, or other methods of access, including all material, pipes, work bridge components, equipment, tools, labor, disposal, and incidentals necessary to complete the work.

**CRANE SAFETY****(8-15-05)**

Comply with the manufacturer specifications and limitations applicable to the operation of any and all cranes and derricks. Prime contractors, sub-contractors, and fully operated rental companies shall comply with the current Occupational Safety and Health Administration regulations (OSHA).

Submit all items listed below to the Engineer prior to beginning crane operations involving critical lifts. A critical lift is defined as any lift that exceeds 75 percent of the manufacturer's crane chart capacity for the radius at which the load will be lifted or requires the use of more than one crane. Changes in personnel or equipment must be reported to the Engineer and all applicable items listed below must be updated and submitted prior to continuing with crane operations.

**CRANE SAFETY SUBMITTAL LIST**

- A. **Competent Person:** Provide the name and qualifications of the "Competent Person" responsible for crane safety and lifting operations. The named competent person will have the responsibility and authority to stop any work activity due to safety concerns.
- B. **Riggers:** Provide the qualifications and experience of the persons responsible for rigging operations. Qualifications and experience should include, but not be limited to, weight calculations, center of gravity determinations, selection and inspection of sling and rigging equipment, and safe rigging practices.
- C. **Crane Inspections:** Inspection records for all cranes shall be current and readily accessible for review upon request.
- D. **Certifications:** By July 1, 2006, crane operators performing critical lifts shall be certified by NC CCO (National Commission for the Certification of Crane Operators), or satisfactorily complete the Carolinas AGC's Professional Crane Operator's Proficiency Program. Other approved nationally accredited programs will be considered upon request. All crane operators shall also have a current CDL medical card. Submit a list of anticipated critical lifts and corresponding crane operator(s). Include current certification for the type of crane operated (small hydraulic, large hydraulic, small lattice, large lattice) and medical evaluations for each operator.

**GROUT FOR STRUCTURES****(7-12-07)****1.0 DESCRIPTION**

This special provision addresses grout for use in structures, including continuous flight auger (CFA) piles, micropiles, soil nail and anchored retaining walls and backfilling crosshole sonic logging (CSL) tubes or grout pockets, shear keys, dowel holes and recesses for cored slabs and box beams. This provision does not apply to grout placed in post-tensioning ducts for bridge beams, girders, or decks. Provide grout composed of portland cement, water and at the Contractor's option, fine aggregate and/or pozzolan. If necessary,

use set controlling admixtures. Proportion, mix and place grout in accordance with the plans, the applicable section of the *Standard Specifications* or special provision for the application and this provision.

## 2.0 MATERIALS

Refer to Division 10 of the *Standard Specifications*:

Item	Article
Portland Cement	1024-1
Water	1024-4
Fine Aggregate	1014-1
Fly Ash	1024-5
Ground Granulated Blast Furnace Slag	1024-6
Admixtures	1024-3

At the Contractor's option, use an approved packaged grout in lieu of the materials above with the exception of the water. Contact the Materials and Tests (M&T) Unit for a list of approved packaged grouts. Consult the manufacturer to determine if the packaged grout selected is suitable for the application and meets the compressive strength and shrinkage requirements.

## 3.0 REQUIREMENTS

Unless required elsewhere in the Contract, provide non-metallic grout with minimum compressive strengths as follows:

Property	Requirement
Compressive Strength @ 3 days	2500 psi (17.2 MPa)
Compressive Strength @ 28 days	4500 psi (31.0 MPa)

For applications other than micropiles, soil nails and ground anchors, use non-shrink grout with shrinkage of less than 0.15%.

When using approved packaged grout, a grout mix design submittal is not required. Submit grout mix designs in terms of saturated surface dry weights on M&T Form 312U in accordance with the applicable section of the *Standard Specifications* or special provision for the structure. Use an approved testing laboratory to determine the grout mix proportions. Adjust proportions to compensate for surface moisture contained in the aggregates at the time of mixing. Changes in the saturated surface dry mix proportions will not be permitted unless a revised grout mix design submittal is accepted.

For each grout mix design, provide laboratory test results for compressive strength, density, flow and if applicable, aggregate gradation and shrinkage. Submit compressive strength for at least 3 cube and 2 cylinder specimens at the age of 3, 7, 14 and 28 days for a total of at least 20 specimens tested. Perform laboratory tests in accordance with the following:

<b>Property</b>	<b>Test Method</b>
Compressive Strength	AASHTO T106 and T22
Density	AASHTO T133
Flow for Sand Cement Grout	ASTM C939 (as modified below)
Flow for Neat Cement Grout (no fine aggregate)	Marsh Funnel and Cup API RP 13B-1, Section 2.2
Aggregate Gradation for Sand Cement Grout	AASHTO T27
Shrinkage for Non-shrink Grout	ASTM C1090

When testing grout for flow in accordance with ASTM C939, modify the flow cone outlet diameter from  $\frac{1}{2}$  to  $\frac{3}{4}$  inch (13 to 19 mm).

When grout mix designs are submitted, the Engineer will review the mix designs and notify the Contractor as to their acceptability. Do not use grout mix designs until written acceptance has been received. Acceptance of grout mix designs or use of approved packaged grouts does not relieve the Contractor of responsibility to furnish a product that meets the Contract requirements.

Upon written request from the Contractor, a grout mix design accepted and used satisfactorily on a Department project may be accepted for use on other projects.

#### **4.0 SAMPLING AND PLACEMENT**

The Engineer will determine the locations to sample grout and the number and type of samples collected for field and laboratory testing. Use API RP 13B-1 for field testing grout flow and density of neat cement grout. The compressive strength of the grout will be considered the average compressive strength test results of 3 cube or 2 cylinder specimens at 28 days.

Do not place grout if the grout temperature is less than 50°F (10°C) or more than 90°F (32°C) or if the air temperature measured at the location of the grouting operation in the shade away from artificial heat is below 40°F (4°C).

Provide grout at a rate that permits proper handling, placing and finishing in accordance with the manufacturer’s recommendations unless directed otherwise by the Engineer. Use grout free of any lumps and undispersed cement. Agitate grout continuously before placement.

Control grout delivery so the interval between placing batches in the same component does not exceed 20 minutes. Place grout before the time between adding the mixing water and placing the grout exceeds that in the table below.

<b>ELAPSED TIME FOR PLACING GROUT</b>		
<b>(with continuous agitation)</b>		
<b>Air or Grout Temperature</b> <b>Whichever is Higher</b>	<b>Maximum Elapsed Time</b>	
	<b>No Set Retarding Admixture Used</b>	<b>Set Retarding Admixture Used</b>
90°F (32°C) or above	30 min.	1 hr. 15 min.
80°F (27°C) through 89°F (31°C)	45 min.	1 hr. 30 min.
79°F (26°C) or below	60 min.	1 hr. 45 min.

**5.0 MISCELLANEOUS**

Comply with Articles 1000-9 through 1000-12 of the *Standard Specifications* to the extent applicable for grout in lieu of concrete.

**HIGH STRENGTH BOLTS:**

**(5-25-10)**

The 2006 Standard Specifications shall be revised as follows:

In Section **440-8(A) - General**, revise the third paragraph and insert a new paragraph four, respectively, as follows:

Make sure that plain bolts and washers have a thin coat of lubricant at the time of installation.

Use nuts that are pre-waxed by the producer/supplier prior to shipping to the project.



In Section **440-8(D) – Inspection** replace the first sub-paragraph under the third paragraph with the following:

At least once each working day, place 3 calibration sample bolts of the same grade, size, representative length, and conditions as those under inspection in a tension indicating calibration device. Furnish a tension indicating calibration device certified by an approved independent testing lab within 12 calendar months prior to testing the bolts under inspection. The calibration device should be in good working order and provide accuracy within plus or minus 10 percent for the range of loads between 25,000 and 40,000 pounds. Place a washer under the part turned in tightening for each bolt if washers are so used in the structure. If no washer is used make sure that the material abutting the part turned is the same as that used in the structure.

### **PRESTRESSED CONCRETE MEMBERS**

**(10-12-10)**

The 2006 Standard Specifications shall be revised as follows:

**Section 1078-1 - General**, add the following after the second paragraph:

The intent of this section is to require the producer to provide prestressed concrete members that meet the Specifications and exhibit characteristics that are not objectionable to the Department.

#### **(A) Producer Qualification**

Producers of precast, prestressed concrete members are required to establish proof of their competency and responsibility in accordance with the Precast/Prestressed Concrete Institute's (PCI) Plant Certification Program in order to perform work for the project. Certification of the manufacturing plant under the PCI program and submission of proof of certification to the State Materials Engineer is required prior to beginning fabrication. Maintain certification at all times while work is being performed for the Department. Submit proof of certification following each PCI audit to the State Materials Engineer for continued qualification. These same requirements apply to producers subcontracting work from the producer directly employed by the Contractor.

Employ producers PCI certified in Product Group B, Bridge Products, and in one of the appropriate categories as listed below:

- B2 Prestressed Miscellaneous Bridge Products: Includes solid piles, sheet piles and bent caps.
- B3 Prestressed Straight-Strand Bridge Members: Includes all box beams, cored slabs, straight-strand girders and bulb-tees, bridge deck panels, hollow piles, prestressed culverts and straight strand segmental components.
- B4 Prestressed Deflected-Strand Bridge Members: Includes deflected strand girders and bulb-tees, haunched girders, deflected strand segmental superstructure components and other post-tensioned elements.

Categories for elements not listed above will be as required by the project special provision or plans.

**(B) Working Drawing Submittals**

Prior to casting girders, submit complete working drawings to the Engineer for approval. The drawings shall detail the exact location and description of all casting holes, attachments and inserts cast in the member for both temporary and permanent applications. The casting holes, attachments and inserts are in association with, but not limited to: fall protection, overhang falsework, metal stay-in-place forms, solar platforms, temporary girder bracing, transit, erection, lifting and handling. If the plan notes indicate that the structure contains the necessary corrosion protection required for a Corrosive Site, epoxy coat, galvanize or metalize all metallic components except stainless steel and malleable iron components. Electroplating will not be allowed.

**Section 1078-7 – Placing Strands, Ties, and Reinforcing Steel**, replace the first paragraph with the following:

Position strands, ties, supports, reinforcing bars of the sizes shown on the plans and bearing plates in accordance with the detailed dimensions shown on the plans and effectively secure against displacement from their correct positions. The use of previously tensioned strands is not permitted. For prestressing strands, do not allow deflections or displacements of any kind between the end anchorages unless shown on the plans. Place the steel reinforcing in final position after tensioning of the strands. Bend all tie wires to the inside of the member so that the ends are farther from the edge than the material tied. Support bottom strands spacings not to exceed 20 feet by supports meeting the requirements of Article 1070-4 or by other approved means. Plastic supports may be used when approved.

**Section 1078-7 – Placing Strands, Ties, and Reinforcing Steel**, replace the third paragraph with the following:

Strand splices are only permitted at the end of a reel and when using a single strand jack. Ensure that the strand lengths to be spliced together have the same lay of wire to avoid unraveling and position the splice so that it does not fall within a member. Do not torch cut the ends of the spliced strand lengths. Cut by shears, abrasive grinders, or other means approved by the Engineer. No more than one strand splice per bed is allowed on an individual strand and the use of previously tensioned strands for splicing is not permitted.

**Section 1078-8 – Tensioning Procedure**, add the following to the beginning of the Section:

A producer quality control representative shall be present during strand tensioning.

**Section 1078-9 – Placing Concrete**, replace the entire Section with the following:

Place concrete in accordance with Article 1077-8 and the additional requirements of this article.

Upon completion of stressing strand, place concrete within a reasonable time to prevent contamination of the strands and reinforcing steel.

Place concrete for girders 54" or less in height, and concrete for all cored slabs and box beams, in 2 or more equal horizontal layers. Place concrete for girders over 54" in height in 3 horizontal layers. When placing concrete in 3 layers locate the top of the first layer approximately at the top of the bottom flange and locate the top of the second layer approximately at the top of the web. To prevent separation of surfaces between layers, do not allow the time between successive placements onto previously placed concrete to exceed 20 minutes, unless the previously placed concrete has not yet stiffened, as evidenced by the continuous effective use of vibration. Should shrinkage or settlement cracks occur, the Engineer reserves the right to require additional layers and/or vibration.

The requirement of the above paragraph may be waived with the permission of the Engineer if self consolidating concrete is used.

Internal or a combination of internal and external vibration is required as is necessary to produce uniformly dense concrete without honeycomb.

Place concrete in cold weather in accordance with the requirements of Article 420-9.

Place concrete in daylight unless an adequate lighting system meeting the approval of the Engineer is provided.

Do not exceed a temperature of 95°F in the freshly mixed concrete when placed in the forms.

Place the concrete in the bed in one continuous operation, finishing each member before proceeding to the next one. If the pour stops before the concrete in all the members in the bed is placed, start curing immediately. Do not place concrete in any remaining members in that bed setup once curing at elevated temperatures has begun.

When cored slabs and box beams are cast, employ an internal hold-down system to prevent the voids from moving. At least six weeks prior to casting cored slabs or box beams, submit to the Engineer for review and comment, detailed drawings of the proposed void material and hold-down system. In addition to structural details, indicate the location and spacing of the holds-downs. Submit the proposed method of concrete placement and of consolidating the concrete under the void.

**Section 1078-11 – Transfer of Load**, replace the first paragraph with the following:

A producer quality control representative or equivalent qualified personnel shall be present during removal of forms and during transfer of load.

Transfer load from the anchorages to the members when the concrete reaches the required compressive strength shown on the plans. Loosen and remove all formwork in one

continuous operation as quickly as possible as soon as release strength is obtained. As soon as the forms are removed, and after the NCDOT Inspector has had a reasonable opportunity to inspect the member, transfer the load from the anchorages to the members as quickly as possible in one continuous operation using the approved detensioning sequence.

**Section 1078-12 – Vertical Cracks in Prestressed Concrete Girders Prior to Detensioning**, replace the entire Section with the following:

This Section addresses prestressed concrete members that have vertical casting cracks prior to strand detensioning. Certain types of these cracks have been determined by the Department to render the girders unacceptable.

Unacceptable cracked members are those with two or more vertical cracks spaced at a distance less than the member depth which extend into the bottom flange. Such members are not considered serviceable and will be rejected. Members with two or more vertical cracks spaced at a distance less than the member depth but do not extend into the bottom flange are subject to an engineering assessment. Such members may not be considered serviceable and may be rejected.

Members with one or more vertical cracks that extend into the bottom flange and are spaced at a distance greater than the member depth are subject to an engineering assessment to determine their acceptability. If this engineering assessment is required, submit, at no additional cost to the Department, a proposal for repairing the member and a structural evaluation of the member prepared by a North Carolina Licensed Professional Engineer. In the structural evaluation, consider the stresses under full service loads had the member not cracked and the effects of localized loss of prestress at the crack as determined by methods acceptable to the Department.

All members, except those defined as unacceptable, which exhibit vertical cracks prior to detensioning, shall receive a 7 day water cure as directed by the Engineer. The water cure shall begin within 4 hours after detensioning the prestressing strands and shall be a minimum of 3'-0" beyond the region exhibiting vertical cracks.

The Department has the final determination regarding acceptability of any members in question.

**Section 1078-13 – Prestressed Concrete Girder Web Splitting**, replace the entire Section with the following:

After detensioning of certain girders with draped strands, cracks occasionally occur in the webs at the ends of the girders. If such cracks occur, employ a method to remedy this condition on all subsequent girders of the same type and strand pattern. If debonding of strands is used, satisfy the following criteria:

- (A) Do not debond the two straight strands in the top of the girder. Debond one half of the straight strands, as nearly as possible, in the bottom flange. As nearly as possible,

debond one quarter of the straight strands in the bottom of girder 4 feet from each end of the girder and debond one quarter of the straight strands 2 feet from each end of the girder.

- (B) Use a debonding pattern that is symmetrical about the vertical axis of the girder.
- (C) Debond strands so that the center of gravity of the strands in the bottom of the girder remain within 1" of their original location at the end of the girder.
- (D) Debond strands by encasing the strand in a conduit meeting the approval of the Engineer. Conduit may be rigid one-piece or rigid two-piece split sheathing. Do not use flexible conduit or sheathing.

No separate payment is made for debonding strands as payment is included in the contract unit price bid for prestressed concrete girders.

**Section 1078-14 – Handling, Transporting and Storing**, replace the second paragraph with the following:

Store all prestressed members on solid, unyielding, storage blocks in a manner to prevent torsion or objectionable bending. In handling prestressed concrete girders 54" or less in height, including cored slabs and box beams, maintain them in an upright position at all times and pick them up within 5 feet of the points of bearing and transport and store supported only within 3 feet of points of bearing. In handling prestressed concrete girders greater than 54" in height, maintain them in an upright position at all times and submit for approval the proposed method of lifting, transporting, and storing the girders. When requested, provide calculations to confirm girders are not overstressed by such operations.

**Section 1078-15 – Final Finish**, replace the entire Section with the following:

Finish prestressed concrete members that are intended for composite action with subsequently placed concrete or asphalt with a roughened surface for bonding. Make sure that no laitance remains on the surfaces to be bonded.

Rough float the tops of girders. Broom finish the top surface of the cored slab and box beam sections receiving an asphalt overlay. Rake the top surface of cored slab and box beam sections receiving a concrete overlay to a depth of 3/8". No surface finish is required for sides and bottom of the slab and beam sections except the exposed side of the exterior unit as noted below. Provide a resulting surface finish essentially the same color and surface finish as the surrounding concrete.

Provide a 3/4" chamfer along the bottom edges on ends and sides of all box beam and cored slab sections, top outside edges of exterior sections and acute corners of sections. Round the top edges on ends of all sections with a 1/4" finishing tool. Provide square corners along top edges on all sections along shear keys. Do not chamfer vertical edges at ends of sections.

Fill all voids in the diagonal face of the bottom flange of prestressed concrete girders and the outside face of exterior cored slabs and box beams with a sand-cement or other approved grout. Fill all voids in piles greater than 1/2" in diameter or depth as above. Provide a resulting

surface finish essentially the same color and surface finish as the surrounding concrete. Repair voids greater than 1/4" in diameter or depth in other faces of these and other members except piles in a like manner. Where an excessive number of smaller voids exist in any member, the Engineer requires a similar repair.

Repair honeycomb, excessively large fins, and other projections as directed. Submit, at no additional cost to the Department, a proposal for repairing members with honeycomb, cracks, or spalls. Do not repair members containing honeycomb, cracks, or spalls until a repair procedure is approved and the member is inspected by the Engineer. Any appreciable impairment of structural adequacy that cannot be repaired to the satisfaction of the Engineer is cause for rejection.

Clean and fill holes caused by strand hold downs upon removal from the casting bed. Use patches of materials approved by the Engineer that develop strength at least equal to the minimum 28 day strength requirement for the concrete prior to approval of the member. Ensure that members are clean and surfaces have a uniform appearance.

Give the top surface of prestressed concrete panels a raked finish or other approved finish to provide an adequate bond with the cast-in-place concrete. As soon as the condition of the concrete permits, rake the top surface of the concrete making depressions of approximately 1/4". Take care when raking not to catch and pull the coarse aggregate.

Clean reinforcing bars exposed on the tops of girders and exterior cored slabs or box beams of mortar build up and excessive rust.

Apply epoxy protective coating to the ends of prestressed members as noted on the plans.

**Section 1078-16 (A) – Alignment and Dimensional Tolerances**, revise Table 1078-3 “Tolerances for Prestressed Cored Slabs” as follows:

Width - Differential of adjacent spans in the same structure	1/2"
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**Section 1078-16 (B) – Alignment and Dimensional Tolerances**, revise Table 1078-4 “Tolerances for Prestressed Girders” as follows:

Position of holes for diaphragm bolts (K)	±1/4"
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**Section 1078-16 (F) – Alignment and Dimensional Tolerances**, revise Table 1078-8 “Tolerances for Box Beams” to be consistent with cored slab tolerances as follows:

Width - Any one span	Plan width + 1/8" per joint
Width – Differential of adjacent spans in the same structure	1/2"

**Section 1078-16 – Identification of Members**, revise Section number to the following:

Section 1078-17

**Section 1078-17 – Quality Control**, revise Section number to the following:

Section 1078-18

**ADHESIVELY ANCHORED ANCHOR BOLTS OR DOWELS**

**(6-11-07)**

**1.0 GENERAL**

Installation and Testing of Adhesively anchored anchor bolts and dowels shall be in accordance with Section 420-13, 420-21 and 1081-1 of the Standard Specifications except as modified in this provision.

**2.0 INSTALLATION**

Installation of the adhesive anchors shall be in accordance with manufacturer's recommendations and shall occur when the concrete is above 40 degrees Fahrenheit and has reached its 28 day strength.

The anchors shall be installed before the adhesive's initial set ('gel time').

**3.0 FIELD TESTING**

Replace the third paragraph of Section 420-13 (C) with the following:

“In the presence of the Engineer, field test the anchor bolt or dowel in accordance with the test level shown on the plans and the following:.

Level One Field testing: Test a minimum of 1 anchor but not less than 10% of all anchors to 50% of the yield load shown on the plans. If less than 60 anchors are to be installed, install and test the required number of anchors prior to installing the remaining anchors. If more than 60 anchors are to be installed, test the first 6 anchors prior to installing the remaining anchors, then test 10% of the number in excess of 60 anchors.

Level Two Field testing: Test a minimum of 2 anchors but not less than 10% of the all anchors to 80% of the yield load shown on the plans. If less than 60 anchors are to be installed, install and test the required number of anchors prior to installing the remaining anchors. If more than 60 anchors are to be installed, test the first 6 anchors prior to installing the remaining anchors, then test 10% of the number in excess of 60 anchors.

Testing should begin only after the Manufacturer's recommended cure time has been reached. For testing, apply and hold the test load for three minutes. If the

jack experiences any drop in gage reading, the test must be restarted. For the anchor to be deemed satisfactory, the test load must be held for three minutes with no movement or drop in gage reading.”

#### **4.0 REMOVAL AND REPLACEMENT OF FAILED TEST SPECIMENS:**

Remove all anchors and dowels that fail the field test without damage to the surrounding concrete. Redrill holes to remove adhesive bonding material residue and clean the hole in accordance with specifications. For reinstalling replacement anchors or dowels, follow the same procedures as new installations. Do not reuse failed anchors or dowels unless approved by the Engineer.

#### **5.0 USAGE**

The use of adhesive anchors for overhead installments is not permitted without written permission from the Engineer.

#### **6.0 BASIS OF PAYMENT**

No separate measurement or payment will be made for furnishing, installing, and testing anchor bolts/dowels. Payment at the contract unit prices for the various pay items will be full compensation for all materials, equipment, tools, labor, and incidentals necessary to complete the work.

### **DIRECT TENSION INDICATORS**

**(6-12-09)**

The 2006 Standard Specifications shall be revised as follows:

Replace Section 440-8(C)(6) – **Direct Tension Indicators** with the following:

Supply direct tension indicators in accordance with the requirements of ASTM F959 and Article 1072-7.

Furnish the Engineer with at least one metal feeler gage for each container of direct tension indicators shipped before beginning installation.

Make sure that the lot number on the containers of direct tension indicators is for the same lot number tested as indicated on the test documents.

Furnish to the Engineer three samples of load indicating washers from each lot number, each size and type for tests and two each of the metal feeler gages required for performing the tests.

Install the direct tension indicator under the bolt head. If it is necessary to install the direct tension indicator under the nut, or if the bolt head shall be turned, install additional hardened washers between the nut or bolt head and the direct tension indicator.



Provide a tension indicating device on the project for determining the tension imposed on a fastener when the protrusions on direct tension indicator are properly compressed.

Test 3 samples from each lot of direct tension indicators in the presence of the Engineer. Achieve a minimum bolt tension of 5% greater than that required by Table 440-1 of Article 440-8.

Do not substitute direct tension indicators for hardened steel washers required with short slotted or oversized holes. If desired, use direct tension indicators in conjunction with hardened steel washers.

Install direct tension indicators initially to a snug tight condition as specified in Subarticle 440-8(C)(3). After initial tightening, fully tighten beginning at the most rigid part of the joint and continuing toward its free edges.

For tightening fasteners containing direct tension indicators, use a clean and lubricated wrench. Maintain air supply and hoses in good condition and provide air pressure of at least 100 psi at the wrench.

When tightening the fasteners, ensure that the part of the fastener being restrained from turning does not rotate during the tightening process. Ensure that no portion of the direct tension indicator protrusions is accidentally partially flattened before installing in the structural steel joints.

Do not reuse direct tension indicators. If it is necessary to loosen a bolt previously tensioned, discard and replace the direct tension indicator.

## **CURING CONCRETE**

**(6-12-09)**

The 2006 Standard Specifications shall be revised as follows:

Replace the first paragraph of Section **420-15(A) – Curing Concrete – General** with the following:

Unless otherwise specified in the contract, use any of the following methods except for membrane curing compounds on bridge deck and approach slab, or on concrete which is to receive epoxy protective coating in accordance with 420-18. Advise the Engineer in advance of the proposed method. Have all material, equipment, and labor necessary to promptly apply the curing on the site before placing any concrete. Cure all patches in accordance with this article. Improperly cured concrete is considered defective.

Replace the third paragraph of Section **420-15(C) – Curing Concrete – Membrane Curing Compound Method** with the following:

Seal the surface with a single uniform coating of the specified type of curing compound applied at the rate of coverage recommended by the manufacturer or as directed, but not less than 1 gallon per 150 square feet of surface area.

**FORMS FOR CONCRETE BRIDGE DECKS****(6-12-09)**

The 2006 Standard Specifications shall be revised as follows:

In Section **420-3(D) – Forms for Concrete Bridge Decks** replace *AASHTO Standard Specifications* with *AASHTO LRFD Bridge Construction Specifications* and *AASHTO LRFD Bridge Design Specifications*.

In Section **420-3(D)(1) – Precast Prestressed Concrete Panels** replace *AASHTO Standard Specifications* with *AASHTO LRFD Bridge Design Specifications*.

**PLACING LOAD ON STRUCTURE MEMBERS****(8-4-09)**

The 2006 Standard Specifications shall be revised as follows:

Replace the fifth paragraph of Section **420-20 – Placing Load on Structure Members** with the following:

Do not place vehicles or construction equipment on a bridge deck until the deck concrete develops the minimum specified 28 day compressive strength and attains an age of at least 14 curing days. The screed may be rolled across a previously cast bridge deck if the entire pour has not achieved initial set. If any portion of the deck concrete has achieved initial set, the screed can not be rolled across the bridge deck until the concrete develops a compressive strength of at least 1,500 psi. Construction equipment is allowed on bridge approach slabs after the slab concrete develops a compressive strength of at least 3,000 psi and attains an age of at least 7 curing days. A curing day is defined in Subarticle 420-15(A).

**6” Steel Natural Gas Pipeline:****(SPECIAL)****1. Scope of Work**

The Contractor shall be responsible for furnishing all equipment, labor, and materials necessary to install a 6” steel natural gas pipeline on the bridge and approximately 80’ of underground piping.

All Work shall be done in accordance with requirements of CFR Title 49 Part 192 "Transportation of Natural and Other Gas By Pipeline: Minimum Federal Safety Standards," as amended, and any applicable Standards which are hereby incorporated in these specifications by reference.

**2. General Construction Requirements - Materials****General**

When brand names of materials have been determined, the Contractor shall obtain approval, through the Engineer, from the State Design Services Engineer and the Owner prior to their use and/or installation. Whenever the specifications and the plan

sheet drawings are in conflict, the specifications shall govern. The Contractor may substitute materials with different brand names of the ones specified upon approval of the Engineer.

The Contractor shall furnish, but is not limited to furnishing, catalog cut sheets and/or shop drawings of the materials. Thirty days shall be allowed for the Engineer's review of each submittal. Eight copies of each catalog cut sheet and/or shop drawing (signed and sealed) shall be submitted.

#### Steel Pipe

The natural gas steel carrier pipe shall be 6 5/8" O.D., API X-42, ERW, .280 wt. without any coating. The pipe attached to the bridge shall be painted after installation. The 6 5/8" steel pipe used under ground shall be the same grade pipe and have a external 18-20 mil. FBE coating. The steel pipe used for the casing and sleeves shall be 10 3/4" O.D., ASTM A 53, Grade B, ERW, .365 wt. without any coating.

#### Pipe Sleeves

The pipe sleeves shall be of the thickness shown on the plans and shall conform to the requirements of ASTM A53 Grade B or APPI 5K Grade B. The pipe sleeves are to be installed in the endwalls and diaphragms as shown on the plans. Both ends of the sleeves shall be flush with both faces of the intermediate diaphragms and extend 12" on the approach sides of the end diaphragms and at the vertical grade that the gas pipeline will be installed. If not fabricated to fit a torch shall be used to cut the ends of the sleeves, and protective shields are to be placed on both faces of the endwalls. All rough edges on the ends and inside of the sleeves caused by cutting shall be removed by filing or reaming.

#### Concrete Inserts

Concrete inserts shall be of an approved galvanized type having a minimum working load tension capacity of 2500 lbs for 3/4" rods. Concrete inserts shall be installed in strict compliance with the recommendations specified by the manufacturer.

#### Hardware

Bolts, Nuts and Washers shall be high strength and galvanized in accordance with Article 1072-7 of Standard Specifications.

#### Hanger Rods

The Hanger Rods shall be of an approved galvanized type, threaded on both ends or threaded continuously and conforming to ASTM-A36 or A-575. The hanger rods shall be of a proper length so as to place the gas pipeline at the vertical location shown on the plans.

Pipe Hangers

The Pipe Hangers shall be an approved adjustable pipe roller type capable of supporting gas pipeline and accepting the hanger rod. The entire hanger assembly is to be galvanized except the pipe roll, which is to be coated with a minimum of 0.13 mm thickness of polyvinyl chloride or neoprene.

Endwall Seal

Seals shall be placed to fill the annual space between the carrier pipe and the endwalls, as indicated on the plans. The Seal shall be of an approved link, lock, or modular sleeve and casing type. Seals shall be modular mechanical type consisting or interlocking synthetic rubber links shaped to continuously fill the annual space between the carrier pipe and the endwall. Links shall be loosely assembled with bolts to form a continuous rubber belt around the pipe with a pressure plate under each bolt head and nut. The Seal shall be recessed minimum of 2 inches from the fill face of the endwalls. After the seal assembly is positioned around the carrier pipe, tightening of the bolts shall cause the rubber sealing elements to expand and provide a watertight seal between the carrier pipe and the endwall, thus preventing the flow of stray currents from the main to the bridge. See the Utility Attachment Detail Sheet.

Lateral Braces

The Lateral Braces, including U-bolts shall be fabricated from ASTM A36 steel in accordance with the details shown on the plans. The U-bolts, with the exception of the threaded ends, shall be coated with a minimum of 0.13 mm thickness of polyvinyl chloride or neoprene. FRP pipe saddles will be placed between the U-bolts and the pipe.

Only the non-coated ends of the U-bolts are required to be galvanized. The FRP pipe saddles shall be secured to the pipe surface between the angle iron and the pipe with bands if needed.

Paint

Primer coats (two coats) of paint shall be with Sherwin Williams Kem Kromik Universal Metal Primer, White. Finish coat (minimum of 2 coats) shall be with Sherwin Williams Industrial Gloss Enamel prepared to match the following custom manual match:

BAC Colorant	OZ	32	64	128
W1 - White	4	62	1	-
B1 - Black	4	2	-	-
G2 - New Green	-	3	1	1
Y3 - Deep Gold	-	21	1	1

Alternatively, the Contractor may use paint manufactured from International Protective Coatings, or other approved equal. Primer coats (two coats) of paint shall be with Intercure 200 HS and finish coat (minimum of 2 coats) shall be with Interthane 870 HS.

### 3. General Construction Requirements – Installation

#### Bridge Hanging

The Contractor must provide all pipe, pipeline components (including hanger assembly and materials; paint, protective wraps, and miscellaneous expendable materials; labor, equipment, trenching, clean-up, testing, tamping of back field, bending of pipe, traffic control) and other work necessary to attach pipeline to bridges and install buried pipeline to the existing distribution system as shown on the Plans. Coordination and timing of this work shall be done with the respective highway officials as well as with the City of Rocky Mount gas department.

After installation, the steel pipe shall be cleaned to white metal by sandblasting or other approved methods and the pipe painted with two prime coats and two finish coats of Sherwin Williams, International Protective Coatings, or other approved primer and paint. Substitutions for approved equal may be submitted to the Engineer for review and approval. All paint shall be submitted for shop drawing approval prior to purchase.

The Contractor shall use protective measures to protect the bridge girders from sandblasting operations during the cleaning of the pipe and during the painting of the pipe. Should any damage occur to the bridge or its surface, the Contractor shall immediately repair same. Backfill and compaction at the bridge abutments shall be as specified by the North Carolina Department of Transportation specifications.

#### Welding

The Work included under this phase of construction includes the furnishing of all labor, materials, equipment, and services necessary for the welding of all pipe joints, fittings, special, and other fabrications in the gas system. All connections shall be welded, unless otherwise specified.

All welding materials shall be furnished by the Contractor.

All requirements affecting the quality of the completed welds shall apply equally to roll welding and position welding. The spacing of the pipe before welding and the kind and character of the weld applied shall be in accordance with the best known practice and shall be subjected to the approval of the Engineer.

The Contractor shall protect filler metals and fluxes from deterioration and excessive moisture changes. Welding rods or other material which show signs of damage or deterioration shall not be used. During windy weather, suitable windguards shall be provided to protect the Work. The Contractor shall temporarily suspend Work whenever, in the opinion of the Engineer, conditions are not conducive to good Work.

Any and all welding on the pipeline or appurtenances thereto, testing and qualifications of welders, destructive or nondestructive inspection shall be in accordance with the Minimum Federal Safety Standards requirements for welding and the terms of API Std. 1104 "Standard for Welding Pipelines and Related Facilities", which are hereby incorporated by reference and made a part of these Specifications.

**The Contractor shall use only competent and skilled workmen on welding. No welding shall be done on any piping, fittings, or other equipment until the welders have been fully qualified in accordance with the test requirements set forth in the above requirements. The Contractor must furnish evidence to the Engineer that these requirements have been met for each welder prior to the commencement of Work. In addition to a welder's certification card, evidence of meeting requirements shall include, but not necessarily be limited to, the backup paperwork indicating the number of specimens tested of each type (tensile strength, root bend, nick break, face bend, etc.) and the results of each individual specimen tested.**

All cost for any testing of welders shall be assumed by the Contractor.

Visual, non-destructive, and destructive inspection standards may be used to determine weld quality.

The Owner may, at its own discretion, employ x-ray or other nondestructive devices to inspect all or any portion of the welds prior to the coating operation. Should any weld prove to be defective for any reason, the Contractor will assume all cost for cutting out and replacing the weld.

The welding inspector or Engineer will be the sole judge of (a) what constitutes an acceptable weld and (b) disposition of defective welds. This determination will be made either during the welding or on inspection of the initial radiograph.

Welding machines in poor operating condition or having insufficient capacity will be removed at the direction of the Engineer.

Arc burns on the pipe shall be removed by grinding, provided the reduced wall thickness is not less than 90% of the wall thickness required in the design of the pipeline. Arc burns that cannot be repaired by grinding shall be cut out as a cylinder.

Steel pipe and fittings shall be butt welded by the oxy-acetylene or the shielded metal-arc welding process using a manual welding technique, unless other welding methods are submitted to and approved by the Engineer.

All surfaces to be welded shall be clean and free of material that may be detrimental to the weld. The ends of pipe at all welded joints shall be properly beveled, and the bevels shall be made by the use of a pipe beveling machine, or other method approved by the Engineer.

All welds on piping of 2-inch nominal diameter and larger shall be made with not less than three (3) beads. The size of electrode for each pass on each size of pipe shall be as approved by the Engineer. Each bead shall be applied completely around the pipe, and shall be thoroughly cleaned of all scale, slag, or other foreign material before the next bead is started. The filler bead and final bead shall be applied as soon as practical behind the stringer bead. The completed weld shall project a minimum of one-sixteenth (1/16) of an inch above the surface of the pipe at all points and shall have a width of not less than one-half (1/2) inch or one-sixteenth (1/16) of an inch over the shoulder of the pipe bevel. No two beads shall start or stop at the same place.

Welding electrodes, electrode sizes, total number of beads, and amperage range for butt welds shall be as follows:

For API5L pipe - All beads with E-6010 electrodes, or all beads with E-7010 electrodes or the stringer and cover beads with E-6010 and the balance with E-7010 electrodes.

Pipe Wall <u>Thickness</u>	<u>Electrode Diameter</u>			<u>Total No. of</u>	
	<u>Root</u>	<u>Hot Pass</u>	<u>Fillers</u>	<u>Cap</u>	<u>Beads</u>
.153 or less	3/32"	---	---	1/8"	2
.154-.249	1/8"	1/8"	---	5/32"	3
.250-.330	5/32"	5/32"	5/32"	3/16"	4
.331-.375	5/32"	5/32"	3/16"	3/16"	5

<u>Electrode Size</u>	<u>Amperage Range</u>
3/32"	40-80
1/8"	75-130
5/32"	90-175
3/16"	140-225

Each completed weld shall be free of overlaps, undercuts, excessive convexity, scale, oxides, pin holes, non-metallic inclusions, air pockets, or any other defect.

Tie-in welds shall be made in a manner and at such a time as approved by the Engineer and/or the Engineer's Inspector.

Cooling of welds by using any substance other than air shall not be permitted. Accelerated cooling by any method shall not be used until the weld is below 600 degrees F. The pipe shall not be moved until the weld is below 600 degrees F.

Fittings shall be used at the intersections of the lines. All weld fittings shall be furnished by the Contractor.

#### Trenching and Backfilling

Trenching shall include all excavation necessary to prepare the ditch for the pipe to be installed regardless of what means or methods are necessary to produce such ditch.

The trench shall be excavated to a depth which will provide a minimum cover of thirty-six (36) inches or as otherwise shown on the Drawings. Minimum cover shall be measured from the top of the pipe to the average elevation of the original ground on the two sides of the trench, or to the ordinance grade whichever is the lower.

The trench shall be completed in a manner which will offer a smooth, continuous support to the entire length of the pipeline. The trench shall be dug true to line and any change in direction shall be made only with approval of the Engineer. All sharp objects such as rocks, glass, etc., shall be removed from the trench or the trench shall be imbedded with sand. The trench shall be dug six inches deeper in areas requiring padding of the trench to protect the pipe or coating.

No trench shall be back-filled unless the pipe has proper depth and fit and there is firm support around the pipe, particularly beneath pipe joints and fittings.

All backfill material used shall be free from stones, sticks, or broken concrete, brick, large clods or lumps or other material which might damage the pipe or the pipe coating. Wherever it is deemed necessary by the Engineer, hand labor shall be used in starting the backfill.

The Contractor may be required to obtain specific degrees of compaction of critical areas as directed by the NCDOT. This type of compaction shall be in four (4) inch to eight (8) inch layers as required by the Engineer.

#### Casing Installation

Installing casing shall include all the work required to install the casing pipe, insulating spacers, and end seals. A watertight seal approved by the Engineer shall be provided at each end of the casing to ensure against the entrance of ground moisture and debris.



Carrier pipe and casings shall be swabbed clean of dirt and other foreign material before installing the carrier pipe in the casing. The leading end of the carrier pipe shall be closed before inserting. The carrier pipe should at all points of contact be insulated from the casing by means of plastic casing insulators and cradles. No casing having an electrical short to the carrier pipe will be approved until all shorts have been insulated.

#### Protective Coverings

All steel pipe used underground to transport gas shall be plant coated. The coating shall be SCOTCHKOTE 6233 fusion bond epoxy coating, 16-18 mils. Alternatively, Valspar Pipeclad 2000 coating, or other approved equal coating material can be used. The coating shall include shot blast cleaning, electrostatically applied powder, and inspection for holidays as specified in the materials section of the specifications.

All steel pipe joints and line fittings shall be wrapped with Tapecoat Primer and hot applied Tapecoat 20, or approved equal. Alternatively the joints can be coated with Canusa-CPS shrink sleeves, or other approved equal coating. The surface shall be wire brushed to remove loose rust and scale, dust, or dirt. Oil and grease shall be removed with a suitable solvent.

The surface to be coated shall be free of moisture. After the application of any priming solution required, the tape shall be properly heated and applied spirally with a minimum of fifty (50%) percent overlap.

All pipe and fittings coated with Tapecoat 20, Canusa-CPS, or approved equal or with a factory coating shall be tested with a Holiday Detector in the presence of the Engineer before it is lowered into the trench. All coating will be tested by jeeping for holidays. The Contractor shall furnish all labor and a type of detector discharge at least twice the thickness of the coating to assure adequate inspection voltage and compensation for any variation in coating thickness.

The Contractor shall paint all above ground metallic structures. The painting shall consist of two (2) coats of primer applied on clean surface and two (2) finish coats. Both Primer and Finish coats are to be spray applied; brush application is not acceptable. Paint shall be as specified in the Materials Section of the Specifications.

*Surface preparation prior to primer coating:* All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:1992.

Oil and grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive blast clean to Sa2 1/2 (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of primer, the surface should be re-blasted to the specified visual standard. Surface defects revealed by the blast cleaning process, should be ground, filed, or treated in the appropriate manner.

Weld seams and damaged areas should be blast cleaned to Sa2 1/2 (ISO 8501-1:1988) or SSPC-SP6.

*Surface preparation prior to finish coating:* Finish coats should always be applied over primer coats. The primer surface should be dry and free from all contamination, and finish coat should be applied within the time specified by the coating manufacturers. Any damaged areas or areas of primer breakdown should be prepared to the specified standard and patch primed as specified for overall priming prior to the application of the finish coats.

In effect, all coatings shall be applied in the manner recommended by the Manufacturer of the coating materials and as approved by the Engineer. Both Primer and Finish coats are to be spray applied; brush application is not acceptable. The Contractor shall furnish all coating materials.

#### Cleaning and Pressure Testing

The carrier pipe shall be thoroughly cleaned by forcing a "pig" type mechanical cleaner through the pipe a sufficient number of times to remove all foreign matter which may have been trapped inside the pipe during construction. **A minimum of three "pig" runs shall be required.** The pigs used on final run must be clean and dry when inserted and removed from pipe.

After cleaning has been approved by the Engineer, all new pipelines shall be proved to be gas tight by an appropriate pressure test using air or inert gas; **water will NOT be approved as a test medium.** The Engineer may require the work to be divided into convenient sections for testing.

All tests shall be conducted in the presence of a representative of the City of Rocky Mount gas department.

All test segments shall be backfilled throughout its entire length before starting the test except for necessary bell holes and open valve settings as approved by the Engineer.

The 6" steel line (60 MAOP psig) shall be tested to 100 psig using air or nitrogen.

The pressure test on completed work shall be left on for a minimum of twenty-four (24) hours and shall show no loss in pressure after temperature corrections have been made. Recording pressure gauges shall be installed at the end of the test section and the recording charts shall be delivered to the City of Rocky Mount at the completion of the test.

The Contractor shall provide all equipment necessary for testing including but not limited to pipe testing caps or plugs, compressors, pumps, pipe connections, all recording pressure gauges, valves fittings, air or nitrogen required to complete the testing. The Contractor shall perform all Work required in connection with the testing. Recording pressure gauges shall be installed in all test sections as required and the recording thereof shall be delivered to the Engineer at the completion of the test.

All breaks, leaks, or defects in the pipe, valves, and fittings shall be repaired and made good by the Contractor at his expense. The line shall be re-tested until the test requirements have been fulfilled. Any variation of length of time shall be approved by the Engineer.

#### Drug Testing

The Contractor shall maintain a drug testing plan compliant with CFR 49 Part 199, part 40 and employees of the Contractor who will physically make the tie-in welds are required to be a participant in the anti-drug/drug testing program.

The Contractor must furnish documentation of the participation in a qualified anti-drug testing program for its employees to the City of Rocky Mount gas department. A negative (no evidence of drug use) test must be documented for any employees who will be involved in making tie-in welds to the system prior to performing such work.

#### Operator Qualification

Any work performed that is considered a “covered task” by the City of Rocky Mount’s Operator Qualification Plan by Contractor personnel on the Owner’s natural gas system shall be performed by personnel who have been “qualified”. In order for a Contractor’s employee to be “qualified” to perform the “covered task”, the employee must be evaluated and certified by the standards outlined in the City of Rocky Mount’s Operator Qualification Plan. It shall be the Contractor’s responsibility to obtain any needed “qualifications” and provide the necessary certification and documentation to the Owner at the Contractor’s cost.

#### **4. Payment**

Payment shall be made at the contract lump sum price bid for “Install 6” steel natural gas pipeline” which includes the installation of the 6” steel pipe, the 10” steel pipe sleeves, inserts, pipe hangers, lateral braces, labor, materials, and incidentals. The lump sum bid price shall be full compensation for all equipment and labor necessary to complete the work in accordance with the plans, Specifications, and as directed by the Engineer.

**DRILLED PIERS**

(7-19-11)

**1.0 DESCRIPTION**

Construct drilled piers consisting of cast-in-place reinforced concrete cylindrical sections in excavated holes typically stabilized with casings or slurry. Provide permanent casings, standard penetration tests, integrity testing and assistance with the shaft inspection device as noted on the plans. Construct drilled piers with the required resistances and dimensions in accordance with the contract and accepted submittals. Use a prequalified Drilled Pier Contractor to construct drilled piers.

Define "excavation" and "hole" as a drilled pier excavation and "pier" as a drilled pier. Define "rock" as a continuous intact natural material in which the penetration rate with a rock auger is less than 2" (50 mm) per 5 minutes of drilling at full crowd force. This definition excludes discontinuous loose natural materials such as boulders and man-made materials such as concrete, steel, timber, etc. and is not for measurement and payment purposes. See Section 7.0 of this provision for measurement and payment of drilled piers.

**2.0 MATERIALS**

Refer to Division 10 of the *Standard Specifications*:

<b>Item</b>	<b>Section</b>
Portland Cement Concrete, Class Drilled Pier	1000
Reinforcing Steel	1070

Use standard size No. 78M coarse aggregate for Drilled Pier concrete.

Provide Type 3 material certifications in accordance with Article 106-3 of the *Standard Specifications* for permanent casings and roller, chair, steel pipe and cap materials. Store steel materials on blocking at least 12" (300 mm) above the ground and protect it at all times from damage; and when placing in the work make sure it is free from dirt, dust, loose mill scale, loose rust, paint, oil or other foreign materials. Load, transport, unload and store drilled pier materials so materials are kept clean and free of damage.

**A. Steel Casing**

Define "casing" as a temporary or permanent casing. Use smooth non-corrugated clean watertight steel casings of ample strength to withstand handling and installation stresses and pressures imposed by concrete, earth, backfill and fluids.

**1. Temporary Casings**

Provide temporary casings with nominal wall thicknesses of at least 0.375" (9 mm) and outside diameters equal to or larger than the design pier diameters for which casings are used.

## 2. Permanent Casings

Use permanent casings with yield strengths of at least 36 ksi (250 MPa) and nominal wall thicknesses that meet the following requirements.

### MINIMUM PERMANENT CASING WALL THICKNESS

Casing Diameter	Nominal Wall Thickness
< 48" (1220 mm)	0.375" (9 mm)
48" (1220 mm) - 78" (1982 mm)	0.500" (12 mm)
> 78" (1982 mm)	0.625" (16 mm)

Provide permanent casings with outside diameters equal to the design pier diameters for which casings are used unless larger diameter permanent casings are approved.

## B. Slurry

Define "slurry" as bentonite or polymer slurry. Mix bentonite clay or synthetic polymer with water to form bentonite or polymer slurry.

### 1. Bentonite Slurry

Provide bentonite slurry that meets the following requirements.

#### BENTONITE SLURRY REQUIREMENTS<sup>1</sup>

Property	ANSI/API RP <sup>2</sup> 13B-1	Requirement
Density <sup>3</sup> (Mud Weight)	Section 4	64.3 – 72.0 lb/cf (1030-1153 kg/m <sup>3</sup> )
Viscosity	Section 6.2 Marsh Funnel	28 – 50 sec/qt (sec/0.95 l)
Sand Content	Section 9	≤ 4 % <sup>4</sup> ≤ 2 % <sup>5</sup>
pH	Section 11 Glass Electrode pH Meter <sup>6</sup>	8 – 11

<sup>1</sup>Slurry temperature of at least 40°F (4.4°C) required

<sup>2</sup>American National Standards Institute/American Petroleum Institute Recommended Practice

<sup>3</sup>Increase density requirements by 2 lb/cf (32 kg/m<sup>3</sup>) in saltwater

<sup>4</sup>In tanks before pumping slurry into excavations

<sup>5</sup>In excavations immediately before placing concrete

<sup>6</sup>pH paper is also acceptable for measuring pH

## 2. Polymer Slurry

Use a polymer slurry product approved by the Department. Value engineering proposals for other polymer slurry products will not be considered. A list of approved polymer slurry products is available from:

[www.ncdot.org/doh/preconstruct/highway/geotech/leftmenu/Polymer.html](http://www.ncdot.org/doh/preconstruct/highway/geotech/leftmenu/Polymer.html)

Provide polymer slurry that meets the following requirements.

### POLYMER SLURRY REQUIREMENTS<sup>1</sup>

Property	ANSI/API RP <sup>2</sup> 13B-1	Requirement
Density <sup>3</sup> (Mud Weight)	Section 4	≤ 64 lb/cf (1025 kg/m <sup>3</sup> )
Viscosity	Section 6.2 Marsh Funnel	32 – 135 sec/qt (sec/0.95 l)
Sand Content	Section 9	≤ 0.5 % <sup>4,5</sup>
pH	Section 11 Glass Electrode pH Meter <sup>6</sup>	8 – 11.5

<sup>1</sup>Slurry temperature of at least 40°F (4.4°C) required

<sup>2</sup>American National Standards Institute/American Petroleum Institute Recommended Practice

<sup>3</sup>Increase density requirements by 2 lb/cf (32 kg/m<sup>3</sup>) in saltwater

<sup>4</sup>In tanks before pumping slurry into excavations

<sup>5</sup>In excavations immediately before placing concrete

<sup>6</sup>pH paper is also acceptable for measuring pH

## C. Rollers and Chairs

Use rollers and chairs that are non-metallic and resistant to corrosion and degradation. Provide rollers with the necessary dimensions to maintain the minimum required concrete cover shown on the plans and center rebar cages within excavations. Use chairs of sufficient strength to support rebar cages in excavations and of the size necessary to raise cages off bottom of holes to maintain the minimum required distance shown on the plans.

## D. Steel Pipes and Caps

Use schedule 40 black steel pipes for access tubes for crosshole sonic logging (CSL). Provide CSL tubes with an inside diameter of at least 1.5" (38 mm). Use CSL tubes with a round, regular inside diameter free of defects and obstructions, including any pipe joints, in order to permit free, unobstructed passage of probes for CSL testing. Provide watertight CSL tubes free of corrosion with clean internal and external faces to ensure a good bond between concrete and tubes. Fit CSL tubes with watertight plastic caps on the bottom and removable caps on top.

## E. Grout

Use nonshrink grout in accordance with the contract.

**3.0 PRECONSTRUCTION REQUIREMENTS**

## A. Drilled Pier Construction Plan Submittal

Submit the proposed drilled pier construction plan for all drilled piers for acceptance. Provide 2 copies of this plan at least 30 days before starting drilled pier construction. Do not begin drilled pier construction until a construction plan is accepted. Provide detailed project specific information in the drilled pier construction plan that includes the following:

1. Overall description and sequence of drilled pier construction;
2. List and sizes of equipment including cranes, drill rigs, vibratory and downhole hammers, Kelly bars, augers, core barrels, casings (diameters, thicknesses and lengths), cleanout buckets, air lifts, pumps, slurry equipment, tremies, pump pipes and other equipment;
3. Procedures for casing installation and temporary casing removal including how telescoping temporary casings will be removed;
4. If applicable, details of slurry testing and use including intended purpose, product information and additives, manufacturer's recommendations for use, name and contact information for slurry manufacturer's technical representative, mixing and handling procedures and how slurry level will be maintained above the highest piezometric head;
5. Methods for drilling and cleaning holes including how cores will be removed and drilling spoils and slurry will be handled and disposed of;
6. Details of CSL tubes, caps and joints including pipe size and how tubes will be attached to reinforcing steel;
7. Procedures for lifting and setting reinforcing steel including how rebar cages will be supported and centralized;
8. Procedures for placing concrete including how tremies and pump pipes will be controlled and contaminated concrete will be contained;
9. Concrete mix design that meets Section 1000 of the *Standard Specifications*;
10. Approved packaged grout or grout mix design that meets the *Grout for Structures* provision;
11. CSL Consultant including Field and Project Engineer; and
12. Other information shown on the plans or requested by the Engineer.

If alternate construction procedures are proposed or necessary, a revised drilled pier construction plan submittal may be required. If the work deviates from the accepted submittal without prior approval, the Engineer may suspend drilled pier construction until a revised plan is accepted.

## B. Preconstruction Meeting

Before starting drilled pier construction, hold a preconstruction meeting to discuss the installation, monitoring and inspection of the drilled piers. Schedule this meeting after all drilled pier submittals have been accepted and the Drilled Pier Contractor has mobilized to the site. The Resident or Bridge Maintenance Engineer, Bridge Construction Engineer, Geotechnical Operations Engineer, Contractor and Drilled Pier Contractor Superintendent will attend this preconstruction meeting.

## 4.0 CONSTRUCTION METHODS

Do not excavate holes, install piles or allow equipment loads or vibrations within 20 ft (6 m) of completed piers until 16 hours after Drilled Pier concrete reaches initial set.

When drilling from a barge, use a fixed template that maintains hole position and alignment during drilled pier construction. Do not use floating templates or templates attached to barges.

Check for correct drilled pier alignment and location before beginning drilling. Check plumbness of Kelly bars before beginning and frequently during drilling.

Provide drilled piers with the minimum required diameters shown on the plans except for piers constructed with permanent casings and slurry or permanent casings to rock. For these situations, the pier diameter may be 2" (50 mm) less than the design pier diameter shown on the plans.

Install drilled piers with tip elevations no higher than shown on the plans or approved by the Engineer. Provide piers with the minimum required tip resistance and, when noted on the plans, penetration into rock.

## A. Excavation

Excavate holes with equipment of the sizes required to construct drilled piers. Use equipment and methods accepted in the drilled pier construction plan or approved by the Engineer. Inform the Engineer of any deviations from the accepted plan.

Use drill rigs with sufficient capacity to drill through soil, rock, boulders, timbers, man-made objects and any other materials encountered and drill 20 ft (6 m) deeper or 20% longer than the maximum drilled pier length shown on the plans, whichever is greater. Drilling below pier tip elevations shown on the plans may be required to attain sufficient resistance.

Do not use blasting to advance drilled pier excavations. Blasting for core removal is only permitted when approved by the Engineer. Contain and dispose of drilling spoils and waste concrete as directed and in accordance with Section 802 of the *Standard Specifications*. Drilling spoils consist of all materials and fluids removed from excavations.



Stabilize excavations with only casings or slurry and casings except, as approved by the Engineer, portions of excavations in rock. Use casings or slurry in rock if unstable material is anticipated or encountered. Stabilize excavations from beginning of drilling through concrete placement. If excavations become unstable, the Engineer may suspend drilling and require a revised drilled pier construction plan. If it becomes necessary to replace a casing during drilling, backfill the excavation, insert a larger casing around the casing to be replaced or stabilize the excavation with slurry before removing the casing.

When noted on the plans, do not dewater drilled pier excavations. Otherwise, if excavations are in rock, dewater excavations to the satisfaction of the Engineer.

#### B. Casings

Provide temporary casings to stabilize holes and protect personnel entering excavations. Permanent casings may be required as noted on the plans. Install permanent casings with tip elevations no deeper than shown on the plans or approved by the Engineer. Additional drilled pier length and reinforcing steel may be required if permanent casings are installed below elevations noted on the plans.

Install casings in continuous sections. Overlap telescoping casings at least 24" (600 mm). Remove casings and portions of permanent casings above the ground line or top of piers, whichever is higher, after placing concrete. Do not cut off permanent casings until Drilled Pier concrete attains a compressive strength of at least 3,000 psi (20.7 MPa).

When using slurry construction without permanent casings, temporary casings at least 10 ft (3 m) long are required at top of excavations. Maintain top of casings at least 12" (300 mm) above the ground line.

#### C. Slurry Construction

Unless noted otherwise on the plans, slurry construction or polymer slurry is at the Contractor's option.

Use slurry and additives to stabilize holes in accordance with the manufacturer's recommendations. Provide a technical representative employed by the slurry manufacturer to assist and guide the Drilled Pier Contractor onsite during the construction of the first drilled pier. If problems are encountered during drilled pier construction, the Engineer may require the technical representative to return to the site.

Provide documentation that mixing water is suitable for slurry. Use slurry equipment that is sufficient for mixing, agitating, circulating and storing slurry. Thoroughly premix slurry with water in tanks before pumping into excavations. Allow bentonite slurry to hydrate at least 24 hours in tanks before use.

Pump slurry into excavations before encountering water. Maintain slurry level at least 5 ft (1.5 m) or one pier diameter, whichever is greater, above the highest piezometric head along the drilled pier length. The highest piezometric head is anticipated to be the static water or groundwater elevation. However, the Drilled Pier Contractor is responsible for determining the highest piezometric head for each pier.

Maintain the required slurry properties at all times except for sand content. Desand or replace slurry as needed to meet the required sand content in tanks before pumping slurry into excavations and in excavations immediately before placing concrete.

### 1. Time

Agitate bentonite slurry in holes at least every 4 hours. If this 4 hour time limit is exceeded, the Engineer may require holes to be overreamed at least 1" (25 mm) and no more than 3" (75 mm) below casings. Overream holes with grooving tools, overreaming buckets or other approved methods.

Construct drilled piers so the maximum time slurry is in contact with uncased portions of holes from drilling through concrete placement does not exceed 36 hours. If this 36 hour time limit is exceeded, the Engineer may require the hole diameter to be enlarged at least 6" (150 mm). If the enlarged hole diameter is greater than the permanent casing diameter, replace casing with a larger permanent casing with an outside diameter equal to the diameter of the enlarged hole.

### 2. Slurry Testing

Define a "sample set" as slurry samples collected from mid-height and within 2 ft (0.6 m) of the bottom of slurry tanks or holes. Take a sample set from slurry tanks to test slurry before beginning drilling. Do not pump slurry into excavations until both slurry samples from tanks meet the required slurry properties. Take sample sets from excavations to test slurry at least every 4 hours and immediately before placing concrete. Do not place concrete until both slurry samples from an excavation meet the required slurry properties. If any slurry test results do not meet the requirements, the Engineer may suspend drilling until both samples from a sample set meet the required slurry properties.

Sign, date and submit slurry test reports upon completion of each pier. The Department reserves the right to perform comparison slurry tests at any time.

### 3. Disposal

Comply with all Federal, State and local regulations, as well as the project permits and commitments, when disposing of slurry and drilling spoils mixed with slurry. Contain slurry and drilling spoils and keep out of water at all times.

#### D. Cleaning and Inspection

Provide clean holes with level bottoms so elevations within bottom of holes do not vary by more than 12" (300 mm). Remove soft and loose material from bottom of holes using methods accepted in the drilled pier construction plan or approved by the Engineer. When bottom of holes are not hand cleaned, remove sediment from holes with cleanout buckets, air lifts or pumps.

After cleaning is complete, provide all equipment, personnel and assistance required for the Engineer to visually inspect holes from above or by entering excavations. Remove all cleaning and drilling equipment from holes during inspections and do not interfere with inspections.

##### 1. Tip Resistance

If the Engineer determines that the material below an excavation does not provide the minimum required tip resistance, increase the drilled pier length and lengthen reinforcing steel as directed. One of the following methods may be required to check the conditions and continuity of material below excavations.

###### a. Test Hole

If excavations are in rock, drill a 1.5" (38 mm) diameter test hole at least 6 ft (1.8 m) below bottom of holes for the Engineer to determine the continuity of rock below holes.

###### b. Standard Penetration Test

Standard penetration tests (SPT) may be required as noted on the plans. When required, drive a split-barrel sampler 18" (450 mm) below bottom of holes or to refusal in accordance with ASTM D1586. Perform SPT in holes at least 12" (300 mm) away from casing walls and support drill rods so rods remain vertical and straight. Report the number of blows applied in each 6" (150 mm) increment and provide recovered samples to the Engineer. The Engineer will determine the standard penetration resistance required.

##### 2. Bottom Cleanliness

Holes are clean if at least 50% of bottom of holes has less than 0.5" (13 mm) of sediment and no portions of bottom of holes have more than 1.5" (38 mm) of sediment. If bottom of holes does not meet this cleanliness criteria, remove sediment from holes until the Engineer determines holes are clean. One or more of the following methods may be required to inspect the bottom cleanliness of holes.

a. Steel Probe

If drilled pier excavations are not dewatered or as directed, provide a #10 (#32) rebar steel probe that is 24" (600 mm) long with a flat tip on one end and a non-stretch cable connected to the other end. Provide a cable long enough to lower the steel probe to the bottom of holes for the Engineer to determine the amount of sediment in holes.

b. Shaft Inspection Device

The Engineer may use the shaft inspection device (SID) as noted on the plans. The Engineer provides the SID and personnel to operate it. Notify the Engineer at least 2 days before finishing holes that will be inspected with the SID.

Assist the Engineer in handling the SID and associated equipment and supporting the SID during inspections. Provide working areas large enough for the SID, associated equipment and SID personnel within reach of the SID cables and clear view of holes being inspected. If necessary, provide a secure location to store the SID and associated equipment onsite overnight.

Approximately one hour is required to inspect a hole with the SID after the SID and associated equipment are set up. The Engineer will use the SID to measure the amount of sediment at 5 locations around the bottom of holes.

E. Reinforcing Steel and Concrete

Assemble rebar cages consisting of bar and spiral reinforcing steel shown on the plans. Securely cross tie reinforcing steel at each intersection with double wire. Attach a chair under each reinforcing bar and rollers near the top and bottom of rebar cages and every 10 ft (3 m) along cages in between. The number of rollers required at each location along rebar cages is one roller per foot (0.3 meter) of design pier diameter with at least 4 rollers per location. Space rollers equally around rebar cages at each location. Attach rollers so rollers are supported across 2 adjacent reinforcing bars and will freely rotate when rebar cages are lowered into excavations.

If CSL tubes are required, securely attach CSL tubes to spiral reinforcing steel on the inside of rebar cages with at least 3" (75 mm) clearance to reinforcing bars. Extend CSL tubes from 6" (150 mm) above pier tip elevations to at least 2 ft (0.6 m) above the ground line or top of permanent casings, whichever is greater. The number of CSL tubes required for each drilled pier is one tube per foot (0.3 m) of design pier diameter with at least 4 tubes per pier. Space CSL tubes equally around rebar cages so distances between tubes measured around spiral reinforcing steel are uniform. Install CSL tubes as straight and parallel to each other as possible. Fit caps on top and bottom of CSL tubes.

After the Engineer determines that the material below excavations provides the minimum required tip resistance and holes are clean, place rebar cages and then concrete in excavations. Do not rack or distort rebar cages and CSL tubes when lifting and handling cages. Set rebar cages directly on bottom of holes or, as approved by the Engineer, hang cages from permanent casings. When hanging rebar cages, leave devices supporting cages in place until Drilled Pier concrete attains a compressive strength of at least 3,000 psi (20.7 MPa).

Do not delay placing cages or concrete unless excavations are cased to rock or otherwise approved. If delays occur, the Engineer may require removal of rebar cages to reinspect bottom cleanliness of holes. If bottom of holes does not meet the cleanliness criteria described above, remove sediment from holes until the Engineer determines holes are clean before resetting rebar cages.

After placing rebar cages with CSL tubes, remove top caps, fill tubes with clean water and reinstall caps before placing concrete. Check for correct cage position before placing concrete and keep rebar cages plumb during concrete placement. Maintain cage position so rebar cages do not move vertically more than 6" (150 mm) and columns or footings have the minimum required concrete cover shown on the plans.

Remove all temporary casings during concrete placement. Do not twist, move or otherwise disturb temporary casings until the concrete depth inside casings is at least 10 ft (3 m) or half the head, whichever is greater, above the bottom of casing being disturbed. Define "head" as the difference between the highest piezometric head along the drilled pier length and the static water elevation inside the excavation.

When removing temporary casings, maintain the required concrete depth above the bottom of casing being removed except when the concrete level is at or above top of piers. Sustain sufficient concrete depths to overcome pressures imposed by earth, backfill and fluids. As temporary casings are withdrawn, ensure fluids trapped behind casings is displaced upward and discharged out of excavations without contaminating or displacing concrete.

Pour concrete in excavations to form uniform jointless monolithic drilled piers. Do not trap soil, air, fluids or other contaminants in concrete. Place concrete in accordance with Subarticle 1000-4(E) for Class AA and A concrete. Remove contaminated concrete from top of piers at time of concrete placement.

Inform the Engineer of the volume of concrete placed for each pier. For piers constructed with slurry or as directed, record a graphical plot of depth versus theoretical and actual concrete volumes.

Dry or wet placement of concrete is at the Contractor's option for piers constructed with only casings if the water inflow rate into excavations is less than 6" (150 mm) per half hour after removing any pumps from holes. Wet placement of concrete is required for all other drilled pier construction.

### 1. Dry Placement

If holes are filling with water for dry placement of concrete, dewater excavations as much as possible before placing concrete. For drilled piers less than 80 ft (24 m) long, pour concrete down the center of excavations so concrete does not hit reinforcing steel or excavation sidewalls. For piers longer than 80 ft (24 m), place concrete with a tremie or pump pipe down the center of excavations so length of free fall is less than 80 ft (24 m).

### 2. Wet Placement

For wet placement of concrete, maintain static water or slurry levels in holes before placing concrete. Place concrete through steel tremies or pump pipes. Use tremies with watertight joints and a diameter of at least 10" (250 mm). Pump concrete in accordance with Article 420-5 of the *Standard Specifications*. Use approved devices to prevent contaminating concrete when tremies or pump pipes are initially placed in excavations. Extend tremies or pump pipes into concrete at least 5 ft (1.5 m) at all times except when the concrete is initially placed.

When the concrete level reaches the static water elevation inside the excavation, dry placement of concrete is permitted. Before changing to dry placement, pump water or slurry out of holes and remove contaminated concrete from the exposed concrete surface.

## 5.0 INTEGRITY TESTING

Define "integrity testing" as crosshole sonic logging (CSL) and pile integrity testing (PIT). Integrity testing may be required as noted on the plans. The Engineer will determine how many and which drilled piers require integrity testing. Do not test piers until Drilled Pier concrete cures for at least 7 days and attains a compressive strength of at least 3,000 psi (20.7 MPa).

### A. Crosshole Sonic Logging

If CSL testing is required, use a prequalified CSL Consultant to perform CSL testing and provide CSL reports. Use a CSL Operator approved as a Field Engineer (key person) for the CSL Consultant. Provide CSL reports sealed by an engineer approved as a Project Engineer (key person) for the same CSL Consultant.

#### 1. CSL Testing

Perform CSL testing in accordance with ASTM D6760. If probes for CSL testing will not pass through to the bottom of CSL tubes, the Engineer may require coring to replace inaccessible tubes. Do not begin coring until core hole size and locations are approved. Core at least 1.5" (38 mm) diameter holes the full length of piers. Upon completion of coring, fill holes with clean water and cover to keep out debris. Perform CSL testing in core holes instead of inaccessible tubes.

For piers with 4 or 5 CSL tubes, test all tube pairs. For piers with 6 or more CSL tubes, test all adjacent tube pairs around spiral reinforcing steel and at least 50% of remaining tube pairs selected by the Engineer. Record CSL data at depth intervals of 2.5" (65 mm) or less from the bottom of CSL tubes to top of piers.

## 2. CSL Reports

Submit 2 copies of each CSL report within 7 days of completing CSL testing. Include the following in CSL reports:

### a. Title Sheet

Department's TIP number and WBS element number

Project description

County

Bridge station number

Pier location

Personnel

Report date

### b. Introduction

### c. Site and Subsurface Conditions (including water table elevation)

### d. Pier Details

Pier and casing diameters, lengths and elevations

Drilled Pier concrete compressive strength

Installation methods including use of casings, slurry, pumps, tremies, dry or wet placement of concrete, etc.

### e. CSL Results

Logs with plots of signal arrival times and energy vs. depth for all tube pairs tested

### f. Summary/Conclusions

Table of velocity reductions with corresponding locations (tube pair and depth) for all tube pairs tested

List of suspected anomalies with corresponding locations (tube pair(s) and depth range)

### g. Attachments

Boring log(s)

Field inspection forms and concrete curves (from Engineer)

CSL tube locations, elevations, lengths and identifications

CSL hardware model and software version information

PDF copy of all CSL data

**B. Pile Integrity Testing**

If required, the Engineer will perform PIT. Provide access to and prepare top of piers for PIT as directed. See ASTM D5882 for PIT details.

**C. Further Investigation**

Define “further investigation” as any additional testing, excavation or coring following initial integrity testing. Based on concrete placement and initial integrity testing results, the Engineer will determine if drilled piers are questionable and require further investigation within 7 days of receiving CSL reports or completing PIT. For initial CSL testing, the Engineer will typically determine whether further investigation is required based on the following criteria.

<b>Velocity Reductions</b>	<b>Further Investigation Required?</b>
< 20 %	No
20 – 30 %	As Determined by the Engineer
> 30 %	Yes

If further investigation is necessary, the Engineer will typically require one or more of the following methods to investigate questionable piers.

**1. CSL Testing**

If required, use CSL testing as described above to retest questionable piers and as directed, perform testing with probes vertically offset in CSL tubes. CSL offset data will typically be required for all locations (tube pair and depth) with velocity reductions greater than 30% and at other locations as directed. Record offset data at depths, intervals and angles needed to completely delineate anomalies.

Provide CSL reports as described above. When CSL offset data is required, perform tomographic analysis and provide 3 dimensional color coded tomographic images of piers showing locations and sizes of anomalies.

**2. Excavation**

If required, excavate around questionable piers and remove permanent casing as needed to expose Drilled Pier concrete. Do not damage piers when excavating or removing casings. The Engineer will determine the portions of piers to expose.

**3. Coring**

If required, core questionable piers and provide PQ size cores that meet ASTM D2113. The Engineer will determine the number, location and depth of core holes



required. Handle, log and store concrete cores in accordance with ASTM D5079. Provide cores to the Engineer for evaluation and testing. Sign, date and submit core logs upon completion of each core hole.

#### D. Defective Piers

For questionable piers that are exposed or cored, the Engineer will determine if piers are defective based on the results of excavation or coring. For questionable piers that are not exposed or cored, the Engineer will determine if piers are defective based on the results of CSL testing. Questionable piers with only CSL testing will be considered defective if any velocity reductions between any tube pairs are greater than 30%.

### 6.0 DRILLED PIER ACCEPTANCE

Drilled pier acceptance is based in part on the following criteria.

1. Temporary casings and drilling tools are removed from the drilled pier excavation or the Engineer determines that a stuck temporary casing may remain in the excavation.
2. Drilled Pier concrete is properly placed and does not have any evidence of segregation, intrusions, contamination, structural damage or inadequate consolidation (honeycombing).
3. Center of pier is within 3" (75 mm) of plan location and 2% of plumb. Top of pier is within 1" (25 mm) above and 3" (75 mm) below the elevation shown on the plans or approved by the Engineer.
4. Rebar cage is properly placed and top and center of cage is within tolerances for center of pier. Tip of permanent casing does not extend below the elevation noted on the plans or approved by the Engineer.
5. Drilled pier is not defective or the Engineer determines the defective pier is satisfactory. A pier will be considered defective based on Section 5.0 of this provision.

Do not grout CSL tubes or core holes, backfill around a pier or perform any work on a drilled pier until the Engineer accepts the pier. If the Engineer determines a pier is unacceptable, remediation is required. Remediation may include, but is not limited to grouting, removing part or all of unacceptable piers, modifying pier designs or providing replacement or additional piers or piles. Submit working drawings and design calculations for acceptance in accordance with Article 105-2 of the *Standard Specifications*. Ensure remediation submittals are designed, detailed and sealed by an engineer licensed by the State of North Carolina. Do not begin remediation work until remediation plans are approved. When repairing unacceptable piers, perform post repair testing to gauge success of the repair. No extension of completion date or time will be allowed for remediation of unacceptable drilled piers and post repair testing.

## 7.0 MEASUREMENT AND PAYMENT

\_\_\_\_ *Dia. Drilled Piers in Soil*, \_\_\_\_ *Dia. Drilled Piers Not in Soil* and \_\_\_\_ *Dia. Drill Piers* will be measured and paid in linear feet (meters). Acceptable drilled piers will be measured as the difference between the specified top of pier and pier tip elevations or revised elevations approved by the Engineer.

For bents with a not in soil pay item shown on the plans, drilled piers will be paid as \_\_\_\_ *Dia. Drilled Piers in Soil* and \_\_\_\_ *Dia. Drilled Piers Not in Soil*. Define "not in soil" as material with a rock auger penetration rate of less than 2" (50 mm) per 5 minutes of drilling at full crowd force. When not in soil is encountered, seams, voids and weathered rock less than 3 ft (1 m) thick with a rock auger penetration rate of greater than 2" (50 mm) per 5 minutes of drilling at full crowd force will be paid at the contract unit price for \_\_\_\_ *Dia. Drilled Piers Not in Soil*. Seams, voids and weathered rock greater than 3 ft (1 m) thick will be paid at the contract unit price for \_\_\_\_ *Dia. Drilled Piers in Soil* where not in soil is no longer encountered. For bents with a not in soil pay item shown on the plans, drilled piers through air or water will be paid at the contract unit price for \_\_\_\_ *Dia. Drilled Piers in Soil*.

For bents without a not in soil pay item shown on the plans, drilled piers will be paid as \_\_\_\_ *Dia. Drill Piers*. The contract unit price for \_\_\_\_ *Dia. Drilled Piers* will be full compensation for drilling through any materials encountered.

The contract unit prices for \_\_\_\_ *Dia. Drilled Piers in Soil*, \_\_\_\_ *Dia. Drilled Piers Not in Soil* and \_\_\_\_ *Dia. Drill Piers* will also be full compensation for spoils and slurry containment and disposal, slurry construction including a slurry manufacturer representative and overreaming and enlarging piers and any concrete removal, miscellaneous grading and excavation. No additional payment will be made for excess Drilled Pier concrete due to caving or sloughing holes or telescoping casings.

Reinforcing steel will be measured and paid in accordance with Article 425-6 of the *Standard Specifications*.

*Permanent Steel Casing for \_\_\_\_ Dia. Drilled Pier* will be measured and paid in linear feet (meters). Permanent casings will only be paid for when required by the Engineer or shown on the plans. Permanent casings will be measured as the difference between the ground line or specified top of pier elevation, whichever is higher, and the specified permanent casing tip elevation or revised elevation approved by the Engineer. If a permanent casing cannot be installed to the tip elevation shown on the plans, up to 3 ft (1 m) of casing cut-off will be paid at the contract unit price for *Permanent Steel Casing for \_\_\_\_ Dia. Drilled Pier*.

*SID Inspections* will be measured and paid in units of each. *SID Inspections* will be measured as one per pier. The contract unit price for *SID Inspections* will be full compensation for inspecting holes with the SID the first time. No additional payment will be made for subsequent inspections of the same hole.

The Contractor is responsible for any damage to the SID equipment due to the Contractor's fault or negligence. Replace any damaged equipment at no additional cost to the Department.

*SPT Testing* will be measured and paid in units of each. *SPT Testing* will be measured as the number of standard penetration tests performed.

*CSL Testing* will be measured and paid in units of each. *CSL Testing* will be measured as one per pier. The contract unit price for *CSL Testing* will be full compensation for performing initial CSL testing and providing CSL reports. Subsequent CSL testing of and CSL reports for the same pier will be considered further investigation. No separate payment will be made for CSL tubes. CSL tubes including coring for inaccessible tubes and grouting will be incidental to the contract unit prices for drilled piers.

No payment will be made for stuck temporary casings that cannot be removed from drilled pier excavations or additional drilled pier length and reinforcing steel required due to temporary casings that remain in excavations. No payment will be made for PIT. No payment will be made for further investigation of defective piers. Further investigation of piers that are not defective will be paid as extra work in accordance with Article 104-7 of the *Standard Specifications*. No payment will be made for remediation of unacceptable drilled piers or post repair testing.

Payment will be made under:

<b>Pay Item</b>	<b>Pay Unit</b>
____ Dia. Drilled Piers in Soil	Linear Foot (Meter)
____ Dia. Drilled Piers Not in Soil	Linear Foot (Meter)
____ Dia. Drilled Piers	Linear Foot (Meter)
Permanent Steel Casing for ____ Dia. Drilled Piers	Linear Foot (Meter)
SID Inspections	Each
SPT Testing	Each
CSL Testing	Each

**PILES**

(3-5-10)

Revise the *Standard Specifications* as follows:

Page 4-71, Delete Section 450 **BEARING PILES** and replace it with the following:

**1.0 DESCRIPTION**

Furnish and install piles with sufficient lengths in accordance with the contract and accepted submittals. Provide steel and prestressed concrete piles and composite piles with both concrete and steel sections as shown on the plans. Drive and drill in piles and use pile tips and accessories as shown on the plans. Galvanize, restrike, redrive, splice, cut off and build up piles and perform predrilling, spudding and pile driving analyzer (PDA) testing as necessary or required. For this provision, “pile embedment” refers to the required pile embedment in the cap or footing and “pile penetration” refers to the minimum required pile tip elevation or penetration into natural ground, whichever is deeper.

**2.0 MATERIALS**

Refer to Division 10 of the *Standard Specifications*:

<b>Item</b>	<b>Section</b>
Flowable Fill, Non-Excavatable	340
Portland Cement Concrete, Class A	1000
Reinforcing Steel	1070
Steel Pipe Pile Plates	1072
Steel and Prestressed Concrete Piles	1084

For drilled-in piles, use Class A Concrete in accordance with Article 1000-4 of the *Standard Specifications* except as modified herein. Provide concrete with a slump of 6 to 8 inches (150 to 200 mm). Use an approved high-range water reducer to achieve this slump.

For galvanized steel piles, see Section 1076 of the *Standard Specifications*. For composite piles with both prestressed concrete and steel H pile sections, use prestressed concrete piles and steel H piles in accordance with Section 1084 of the *Standard Specifications*. Use steel pile points and splicers approved by the NCDOT Materials & Tests (M&T) Unit. Obtain a list of approved pile points and splicers from:

<https://apps.dot.state.nc.us/vendor/approvedproducts/>

**3.0 PILE LENGTHS**

The estimated pile lengths shown on the plans are for bid purposes only. Provide piles of sufficient lengths for the required driving resistance, pile penetration and pile embedment. At the Contractor’s option and no additional cost to the Department, make investigations as necessary to determine required pile lengths.

#### 4.0 CONSTRUCTION METHODS

##### A. Handling and Storing Piles

Handle, transport and store piles so that piles are kept clean and undamaged. Do not use chains, cables or hooks that can damage or scar piles. Do not damage coatings on steel piles. When handling prestressed concrete piles, support piles at pick-up points as shown on the plans.

Protect steel piles as far as practicable from corrosion. Store piles above ground upon platform skids, or other supports, and keep free from dirt, grease, vegetation and other foreign material. Damaged, bent or cracked piles will be rejected.

##### B. Pile Installation

If applicable, completely excavate for caps and footings before installing piles. If applicable and unless noted otherwise on the plans, construct embankments to bottom of cap or footing elevations for a horizontal distance of 50 ft (15 m) from any pile except where fill slopes are within 50 ft (15 m) of a pile.

Install piles with the following tolerances.

1. Axial alignment within  $\frac{1}{4}$  inch per foot (21 mm per meter) of vertical or batter shown on the plans
2. Horizontal alignment within 3" (75 mm) of plan location, longitudinally and transversely
3. Pile embedment within 3" (75 mm) more and 2" (50 mm) less of the embedment shown on the plans

No additional payment will be made for increased cap or footing dimensions due to piles installed out of position.

If necessary, build up prestressed concrete piles or splice steel piles as shown on the plans. Do not use more than 3 sections (2 splices) of steel piling per pile. Cut off piles at required elevations along a plane normal to the axis of the pile as necessary. Do not damage or spall piles when cutting off prestressed concrete piles.

##### C. Pile Accessories

If required, use pile accessories including pipe pile plates and steel pile points and splicers as shown on the plans. Perform any welding in accordance with the contract. Weld pipe pile plates with the specified dimensions to steel pipe piles as shown on the plans.

Attach steel pile points to steel piles in accordance with the manufacturer's instructions. The minimum weld length is twice the flange width for steel H piles.

Use steel pile tips with prestressed concrete piles as shown on the plans. Use steel pile splicers for splicing steel H pile tips and composite piles. Attach pile splicers in accordance with the manufacturer's instructions.

#### D. Driven Piles

When predrilling, spudding and installing the initial portions of steel piles with vibratory hammers, submit these pile installation methods with the proposed pile driving methods and equipment for review and acceptance. Spudding is defined as driving or dropping a steel H pile and then removing it. The Engineer will approve the predrilling depth and diameter, spudding depth and H pile size and depth of pile installation with a vibratory hammer. Do not use vibratory hammers to install prestressed concrete piles.

Drive piles in accordance with the accepted submittals and this provision. Unless otherwise approved, do not drive piles within 50 ft (15 m) of cast-in-place concrete until the concrete cures for at least 3 days.

Limit driving stresses in accordance with the *AASHTO LRFD Bridge Design Specifications*. If a tip elevation is noted on the plans for steel and prestressed concrete piles, drive piles to the minimum required driving resistance and tip elevation. Otherwise, drive steel and prestressed concrete piles to the minimum required driving resistance and a penetration into natural ground of at least 10 ft (3 m). For composite piles, drive piles to the minimum required driving resistance and the prestressed concrete and steel H pile sections to their respective minimum required tip elevations noted on the plans.

Also, drive piles to the minimum required tip elevation or penetration into natural ground, whichever is deeper, in a continuous operation unless stopped due to exceeding the maximum blow count or driving stresses, insufficient pile length or other approved reasons. Natural ground within an area of a new embankment is defined as the bottom of the embankment or footings, whichever is lower.

Protect coatings in an approved manner when driving coated steel piles through templates. Redrive piles raised or moved laterally due to driving adjacent piles.

##### 1. Predrilling and Spudding

If necessary or required, perform predrilling for piles and spudding with a steel H pile as noted on the plans or in accordance with the accepted submittals. Predrill pile locations to the specified elevations noted on the plans, revised elevations approved by the Engineer or depths in accordance with the accepted submittals. When noted on the plans and at the Contractor's option, spudding may be used in lieu of predrilling. Do not perform spudding below specified predrilling elevations, revised elevations approved by the Engineer or depths in accordance with the accepted submittals.

When noted on the plans or predrilling in water or wetlands, use temporary steel casings meeting the requirements of steel casings for pile excavation in accordance with this provision with the exception of casing diameter. For steel casing diameters, use casings with a minimum inside diameter equal to the predrilling diameter. Use steel casings from a minimum of 2 ft (0.6 m) above the static water elevation or ground line, whichever is higher, to a minimum of 5 ft (1.5 m) below the ground or mud line. More than 5 ft (1.5 m) embedment may be necessary if steel casings are not stable or predrilling or spudding disturbs material outside the casings.

Perform predrilling and spudding such that large ground movements and voids below ground do not occur and piles can be driven to the required resistance and pile penetration. Do not deposit spoils above the ground or mud line in water or wetlands. Dispose of spoils in accordance with Section 802 of the *Standard Specifications* and as directed by the Engineer. When predrilling or spudding is complete, remove all steel casings before driving piles.

## 2. Driving Equipment

Submit the proposed pile driving methods and equipment (pile driving equipment data form) including the pile driving hammer, hammer cushion, pile helmet and cushion for all piles for review and acceptance. Do not submit more than two pile driving hammers per pile type per submittal. Provide 2 copies of this form at least 30 calendar days before driving piles. All equipment is subject to satisfactory field performance.

Drive piles with accepted driving equipment using air, steam or diesel hammers. Use pile driving hammers that will not overstress piles and provide the required driving resistance at a blows per foot ranging from 30 to 180. Use a variable energy hammer to drive prestressed concrete piles.

Operate air and steam hammers within the manufacturer's specified ranges and 10% of the manufacturer's rated speed in blows per minute or a rate approved by the Engineer. Use a plant and equipment for air or steam hammers with sufficient capacity to maintain, under working conditions, the volume and pressure specified by the manufacturer. Equip the plant and equipment with accurate pressure gauges that are easily accessible. Provide striking parts of air and steam hammers that weigh at least one-third the weight of the pile helmet and pile, with a minimum weight of 2,750 lbs (1,250 kg).

Equip open-end (single acting) diesel hammers with a graduated scale (jump stick) extending above the ram cylinder, graduated rings or grooves on the ram or an electric sound activated remote measuring instrument to determine the hammer stroke during driving. Equip closed-end (double acting) diesel hammers with a calibrated bounce chamber pressure gauge mounted near the ground and provide a current calibrated chart or graph equating bounce chamber pressure and gauge hose

length to equivalent energy. Submit this chart or graph with the proposed pile driving methods and equipment for closed-end diesel hammers.

Hold pile heads in position with pile helmets that closely fit over the pile heads and extend down the sides of piles a sufficient distance. Protect pile heads of prestressed concrete piles from direct impact with accepted pile cushions. Use pile cushions made of pine plywood with a minimum thickness of 4" (100 mm). Unless otherwise approved, provide a new pile cushion for each prestressed concrete pile. Replace pile cushions during driving when a cushion is compressed more than one-half its original thickness or begins to burn.

The Engineer may inspect the hammer cushion before beginning driving and periodically throughout the project. Expose the hammer cushion for inspection as directed by the Engineer. Replace or repair any hammer cushion that is less than 25% of its original thickness.

### 3. Required Driving Resistance

The Engineer will determine the acceptability of the proposed pile driving methods and equipment and provide the blows per foot and equivalent set for 10 blows for the required driving resistance. The minimum required driving resistance is equal to the factored resistance noted on the plans plus any additional resistance for downdrag and scour, if applicable, divided by a resistance factor. When performing PDA testing in accordance with the *AASHTO LRFD Bridge Design Specifications*, the resistance factor is 0.75. Otherwise, the resistance factor for the wave equation analysis is 0.60.

Unless otherwise approved, stop driving piles when refusal is reached. Refusal is defined as 240 blows per foot or any equivalent set.

### 4. Redriving Piles

Once the required pile penetration is achieved, the Contractor may choose to or the Engineer may require the Contractor to stop driving, wait and restrike or redrive piles to achieve the required driving resistance. If the Contractor chooses to restrike or redrive piles, no payment will be made for restrikes or redrives. If the Engineer requires the Contractor to restrike or redrive piles, payment will be made in accordance with section 5.0 of this provision. When the Engineer requires restrikes or redrives, the Engineer will determine the number of restrikes or redrives and the time to wait after stopping driving and between restrikes and redrives. The time to wait will range from 4 to 24 hours.



Use the same pile driving methods, equipment and compressed pile cushion from the previous driving to restrike or redrive the pile unless the cushion is unacceptable due to deterioration. Do not use a cold diesel hammer for a restrike or redrive, unless it is impractical to do otherwise as determined by the Engineer. In general, warm up the hammer by applying at least 20 blows to a previously driven pile or timber mats on the ground.

#### E. Drilled-in Piles

If required, perform pile excavation to specified elevations shown on the plans or revised elevations approved by the Engineer. Excavate holes at pile locations with diameters that will result in at least 3" (75 mm) of clearance all around piles. Before filling holes, support and center piles in excavations and when noted on the plans, drive piles to the required driving resistance. Remove any fluid from excavations, and at the Contractor's option, fill holes with either concrete or flowable fill unless required otherwise in the contract.

##### 1. Pile Excavation

Use equipment of adequate capacity and capable of drilling through soil, rock, boulders, debris, man-made objects and any other materials encountered. Blasting is not permitted to advance excavations. Blasting for core removal is only permitted when approved by the Engineer. Dispose of drilling spoils in accordance with Section 802 of the *Standard Specifications* and as directed by the Engineer. Drilling spoils consist of all excavated materials including fluids removed from excavations by pumps or drilling tools.

If unstable, caving or sloughing soils are anticipated or encountered, stabilize holes with either slurry or temporary steel casings. When using slurry, submit slurry details including product information, manufacturer's recommendations for use, slurry equipment details and written approval from the slurry supplier that the mixing water is acceptable before beginning drilling. When using steel casings, use either the sectional type or one continuous corrugated or non-corrugated piece. Steel casings should consist of clean watertight steel of ample strength to withstand handling and driving stresses and the pressures imposed by concrete, earth and backfill. Use steel casings with an outside diameter equal to the hole size and a minimum wall thickness of ¼ inch (6 mm).

##### 2. Filling Holes

Check the water inflow rate at the bottom of holes after all pumps have been removed. If the inflow rate is less than 6" (150 mm) per half hour, remove any fluid and free fall concrete or flowable fill into excavations. Ensure that concrete or flowable fill flows completely around piles. If the water inflow rate is greater than 6" (150 mm) per half hour, propose and obtain acceptance of a procedure for

placing concrete or flowable fill before filling holes. Place concrete or flowable fill in a continuous manner and remove all steel casings.

#### F. Pile Driving Analyzer

If required, test piles with a pile driving analyzer (PDA) manufactured by Pile Dynamics, Inc., analyze data and provide PDA reports. Perform PDA testing in accordance with ASTM D4945. Either the Engineer will perform PDA testing and analysis or use a PDA Consultant prequalified by the NCDOT Contractual Services Unit for Pile Driving Analyzer Work (work code 3060) to perform PDA testing and analysis and provide PDA reports. When using a PDA Consultant, use a PDA Operator approved as a Field Engineer (key person) for the PDA Consultant. Also, provide PDA reports sealed by a Professional Engineer approved as a Project Engineer (key person) for the same PDA Consultant.

The Engineer will determine the number of piles and which piles to be tested with a PDA. Do not drive piles with a PDA until the proposed pile driving methods and equipment has been preliminarily accepted. Notify the Engineer of the pile driving schedule a minimum of 7 calendar days in advance.

The Engineer will complete the review and acceptance of the proposed pile driving methods and equipment and provide the blows per foot and equivalent set for 10 blows for the required driving resistance within 10 calendar days after the Engineer receives the PDA report or the Engineer finishes PDA testing. A PDA report for or PDA testing on multiple piles may be required as determined by the Engineer before the 10 day time period begins.

##### 1. Preparation

Provide piles for PDA testing that are 5 ft (1.5 m) longer than the estimated pile lengths shown on the plans. Supply an AC electrical power source of a voltage and frequency suitable for computer equipment.

Provide a shelter to protect the PDA equipment and operator from conditions of sun, water, wind and temperature. The shelter should have a minimum floor size of 6 ft by 6 ft (1.8 m by 1.8 m) and a minimum roof height of 8 ft (2.4 m). If necessary, heat or cool the shelter to maintain a temperature between 50 and 85 degrees F (10 and 30 degrees C). Place the shelter within 75 ft (23 m) of the pile such that the PDA cables reach the computer and the operator can clearly observe the pile. The Engineer may waive the shelter requirement if weather conditions allow.

Drill up to a total of 16 bolt holes in either 2 or 4 sides of the pile, as directed by the PDA Consultant or Engineer, at an approximate distance equal to 3 times the pile diameter below the pile head. If the PDA Consultant or Engineer chooses to drill the bolt holes, provide the necessary equipment, tools and assistance to do so. A hammer drill is required for concrete piles. Allow for 2 hours per pile to drill holes.

Lift, align and rotate the pile to be tested with a PDA as directed by the PDA Consultant or Engineer. Place the pile in the leads and template so that the PDA instruments and their accompanying wires will not be damaged. Attach PDA instruments as directed by the PDA Consultant or Engineer after the pile is placed in the leads and the template.

## 2. Testing

Use only the preliminarily accepted pile driving methods and equipment to drive piles with the PDA instruments attached. Drive piles in accordance with this provision and as directed by the PDA Operator or Engineer. The PDA Operator or Engineer may require the Contractor to modify the pile installation procedure during driving. Dynamic measurements will be recorded and used to evaluate the hammer performance, driving resistance and stresses, energy transfer, pile integrity and various soil parameters such as quake and damping.

If required, reattach the PDA instruments and restrike or redrive the pile in accordance with this provision. Obtain the required stroke and at least 6" (150 mm) of penetration as directed by the PDA Operator or Engineer. Dynamic measurements will be recorded during restriking and re-driving. The Engineer will determine when PDA testing has been satisfactorily completed.

The Contractor is responsible in terms of both actual expense and time delays for any damage to the PDA instruments and supporting equipment due to the Contractor's fault or negligence. Replace any damaged equipment at no additional cost to the Department.

## 3. Analysis

When using a PDA Consultant, analyze data with the CAse Pile Wave Analysis Program (CAPWAP), version 2006 or later, manufactured by Pile Dynamics, Inc. At a minimum, analysis is required for a hammer blow near the end of initial drive and for each restrike and re-drive. Additional CAPWAP analysis may be required as determined by the PDA Consultant or Engineer.

#### 4. Report

When using a PDA Consultant, submit 2 copies of each PDA report within 7 calendar days of completing field testing. Include the following in PDA reports:

##### a. Title Sheet

- NCDOT TIP number and WBS element number
- Project description
- County
- Bridge station number
- Pile location
- Personnel
- Report date

##### b. Introduction

##### c. Site and Subsurface Conditions (including water table elevation)

##### d. Pile Details

- Pile type and length
- Required driving resistance and resistance factor
- Concrete compressive strength and/or steel pile yield strength
- Pile splice type and locations
- Pile batter
- Installation methods including use of predrilling, spudding, vibratory hammer, template, barge, etc.

##### e. Driving Details

- Hammer make, model and type
- Hammer and pile cushion type and thickness
- Pile helmet weight
- Hammer efficiency and operation data including fuel settings, bounce chamber pressure, blows per minute, equipment volume and pressure
- Ground or mud line elevation and template reference elevation at the time of driving
- Final pile tip elevation
- Driving data (ram stroke, blows per foot (0.3 meter) and set for last 10 hammer blows)
- Restrike and redrive information

- f. PDA Field Work Details
- g. CAPWAP Analysis Results
  - Table showing percent skin and tip, skin and toe damping, skin and toe quake and match quality
- h. Summary/Conclusions
- i. Attachments
  - Boring log(s)
  - Pile driving equipment data form (from Contractor)
  - Field pile driving inspection data (from Engineer)
  - Accelerometer and strain gauge locations
  - Accelerometer and strain gauge serial numbers and calibration information
  - PDA hardware model and CAPWAP software version information
  - Electronic copy of all PDA data and executable CAPWAP input and output files

## 5.0 MEASUREMENT AND PAYMENT

\_\_\_\_\_ *Prestressed Concrete Piles*, \_\_\_\_\_ *Steel Piles* and \_\_\_\_\_ *Galvanized Steel Piles* will be measured and paid for in linear feet (meters). Steel and prestressed concrete piles will be measured as the pile length before installation minus any pile cut-offs. No payment will be made for pile cut-offs or cutting off piles. No payment will be made for damaged, defective or rejected piles or any piles for falsework, bracing, templates or temporary work bridges. The contract unit prices for \_\_\_\_\_ *Prestressed Concrete Piles*, \_\_\_\_\_ *Steel Piles* and \_\_\_\_\_ *Galvanized Steel Piles* will also be full compensation for driving piles.

Composite piles will be measured as the pile length of the prestressed concrete and steel H pile sections before installation minus any pile cut-offs. The concrete and steel sections will be measured and paid for at the contract unit prices for \_\_\_\_\_ *Prestressed Concrete Piles* and \_\_\_\_\_ *Steel Piles*, respectively. No payment will be made for portions of steel H pile sections embedded in prestressed concrete sections or steel pile splicers and any associated hardware or welding.

For driven piles, once the required resistance and pile penetration is achieved, the Contractor may drive the remaining portion of piles to grade in lieu of cutting off piles provided the remaining portions do not exceed 5 ft (1.5 m) and the piles can be driven without being damaged or reaching the maximum blow count or refusal. When this occurs, the additional length of piles driven will be measured and paid for at the contract unit prices for \_\_\_\_\_ *Prestressed Concrete Piles*, \_\_\_\_\_ *Steel Piles* and \_\_\_\_\_ *Galvanized Steel Piles*.

For prestressed concrete piles that are built up, the build-up will be measured and paid for at the contract unit price for \_\_\_\_\_ *Prestressed Concrete Piles*. Steel pile tips are not included in the measurement of prestressed concrete piles. No separate payment will be made for steel pile tips or splicers and any associated hardware or welding. Steel pile tips and steel pile splicers will be considered incidental to the contract unit price for \_\_\_\_\_ *Prestressed Concrete Piles*.

*Steel Pile Points* and *Pipe Pile Plates* will be measured and paid for in units of each. *Steel Pile Points* and *Pipe Pile Plates* will be measured as one per pile.

*Predrilling for Piles* will be measured and paid for in linear feet (meters). For bents with a predrilling pay item as shown on the substructure plans, predrilling will be paid for as *Predrilling for Piles* and measured per pile location as the depth from the ground or mud line to specified predrilling elevations or revised elevations approved by the Engineer. The contract unit price for *Predrilling for Piles* will also be full compensation for using temporary steel casings. For bents without a predrilling pay item as shown on the substructure plans, predrilling will be considered incidental to the contract unit prices for \_\_\_\_\_ *Prestressed Concrete Piles*, \_\_\_\_\_ *Steel Piles* and \_\_\_\_\_ *Galvanized Steel Piles*.

No direct payment will be made for spudding or using temporary steel casings for spudding. Spudding and using temporary steel casings for spudding will be considered incidental to the contract unit prices for \_\_\_\_\_ *Prestressed Concrete Piles*, \_\_\_\_\_ *Steel Piles* and \_\_\_\_\_ *Galvanized Steel Piles*.

*Pile Redrives* will be measured and paid for in units of each. *Pile Redrives* will be measured as the number of restrikes or redrives required by the Engineer. No payment will be made for restrikes or redrives when the Contractor chooses to restrike or redrive piles.

*Pile Excavation in Soil* and *Pile Excavation Not in Soil* will be measured and paid for in linear feet (meters). Pile excavation will be measured as the depth from the ground line to the specified elevations or revised elevations approved by the Engineer. Not in soil is defined as material with a rock auger penetration rate of less than 2" (50 mm) per 5 minutes of drilling at full crowd force. Once not in soil is encountered, seams, voids and weathered rock less than 3 ft (1 m) thick with a rock auger penetration rate of greater than 2" (50 mm) per 5 minutes of drilling at full crowd force will be paid for at the contract unit price for *Pile Excavation Not in Soil*. Seams, voids and weathered rock greater than 3 ft (1 m) thick will be paid for at the contract unit price for *Pile Excavation in Soil* where not in soil is no longer encountered. The contract unit prices for *Pile Excavation in Soil* and *Pile Excavation Not in Soil* will also be full compensation for stabilizing and filling holes with either concrete or flowable fill.

*PDA Testing* will be measured and paid for in units of each. No payment for *PDA Testing* will be made if the Engineer performs PDA testing. If the Engineer does not perform PDA testing, *PDA Testing* will be measured as one per pile. The contract unit price for *PDA Testing* will be full compensation for performing PDA testing the first time a pile is tested with a PDA, performing analysis on data collected during initial drive, restrikes and

redrives and providing the PDA report. Subsequent PDA testing of the same piles will be considered incidental to the contract unit price for *Pile Redrives*.

*PDA Assistance* will be measured and paid for in units of each. *PDA Assistance* will be measured as one per pile. The contract unit price for *PDA Assistance* will be full compensation for the Contractor's assistance to perform the PDA testing during initial drive, restrikes and redrives.

Payment will be made under:

<b>Pay Item</b>	<b>Pay Unit</b>
_____ Prestressed Concrete Piles	Linear Foot (Meter)
_____ Steel Piles	Linear Foot (Meter)
_____ Galvanized Steel Piles	Linear Foot (Meter)
Steel Pile Points	Each
Pipe Pile Plates	Each
Predrilling for Piles	Linear Foot (Meter)
Pile Redrives	Each
Pile Excavation in Soil	Linear Foot (Meter)
Pile Excavation Not in Soil	Linear Foot (Meter)
PDA Testing	Each
PDA Assistance	Each