

PRECAST REINFORCED CONCRETE BOX CULVERT AT L-STATION 49+24.11:**General**

This Special Provision covers precast reinforced concrete box culverts intended for the construction of culverts and for the conveyance of storm water.

Where a precast reinforced box culvert is required on the plans, design the precast culvert sections in accordance with AASHTO M259 and provide the size and number of barrels as indicated on the plans. Precast wing walls will not be allowed. For culverts with less than 2 feet (0.6 m) of cover, design the precast culvert sections in accordance with AASHTO M273. Detail the culvert with cast in place wings. Provide a precast box culvert that meets the requirements of Section 1077 and any other applicable parts of the Standard Specifications.

The design of the precast members is the responsibility of the Contractor and is subject to review, comments and approval. Submit two sets of detailed plans for review. Include all details in the plans, including the size and spacing of the required reinforcement necessary to build the precast box culvert. Include checked design calculations for the precast members complying with the latest AASHTO Standard Specifications and requirements detailed herein. Have a North Carolina Registered Professional Engineer check and seal the plans and design calculations. After the plans are reviewed and, if necessary, the corrections made, submit one set of reproducible tracings on 22" x 34" sheets to become the revised contract plans.

A pre-installation meeting is required prior to installation. Representatives from the Contractor, the precast box manufacturer, and the Department should attend this meeting. The precast box manufacturer representative shall be on site during installation.

Precast Reinforced Concrete Box Sections**A. Types**

Precast reinforced concrete box sections manufactured in accordance with this Special Provision are designated by span, rise, and design earth cover.

B. Design

1. Design – The box section dimensions and reinforcement details are subject to the provisions of Section F.
2. Placement of Reinforcement – Provide a 1 inch (25 mm) concrete cover over the circumferential reinforcement subject to the provisions of Section F. Extend the inside circumferential reinforcement into the male portion of the joint and the outside circumferential reinforcement into the female portion of the joint. Detail the clear distance of the end circumferential wires so it is not less than 1/2 inch (13 mm) nor more than 2 inches (51 mm) from the ends of the box section. Assemble reinforcement per the requirements of AASHTO M259, Section 7.3. The

exposure of the ends of the wires used to position the reinforcement is not a cause for rejection.

3. Laps and Spacing – Use lap splices for the circumferential reinforcement. Detail the circumferential wires so that the center to center spacing is not less than 2 inches (50 mm) nor more than 4 inches (100 mm). Do not detail the longitudinal wires with a center to center spacing of more than 8 inches (200 mm).
4. The design earth cover is reported on the plans as the elevation difference between the point of maximum fill and the top of the top slab.

C. Joints

1. Produce the precast reinforced concrete box section with male and female ends. Design and form these ends of the box section so, when the sections are laid together, they make a continuous line of box sections with a smooth interior free of appreciable irregularities in the flowline, all compatible with the permissible variations given in Section F. The internal joint formed at the male and female ends of the precast units shall be sealed with either bitumen/butyl sealant or closed-cell neoprene material. The internal joint material shall be installed in accordance with the manufacturer's recommendations. The material shall be shown on the shop drawings when they are submitted for review.
2. Seal the external joint with an outside sealer wrap that is at least 12 inches (300 mm) wide and covers the joint on both the sides and the top of the box section. Use ConWrap CS-212 from Concrete Sealants, Inc., EZ-Wrap from Press-Seal Gasket Corporation, Seal Wrap from Mar-Mac Manufacturing Co., Inc., Cadilloc External Pipe Joint from Cadilloc, or an approved equal for the outside sealer wrap. If the outside sealer wrap is not applied in a continuous strip along the entire joint, a 12 inch (300 mm) minimum lap of the outside sealer wrap is permitted. Before placing the outside sealer wrap, clean and prime the area receiving the outside sealer wrap in accordance with the sealer wrap manufacturer recommendations. The joint wrap manufacturer installation recommendations shall be included with shop drawings submitted for review. The external joint wrap shall be installed in three pieces, as indicated on Figure 1 below:

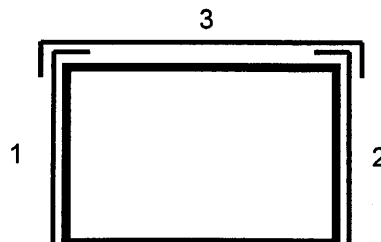


Figure 1

Cover the external joint sealer with a 3 foot (900 mm) strip of filter fabric conforming to Type 4 requirements in Section 1056 of the Standard Specifications. Place multiple lines of a precast reinforced concrete box culvert such that the longitudinal joint between the sections has a minimum width of 3 inches (75 mm). Fill the joint between multiple lines of precast box sections with Class A concrete. Use Class A concrete that meets the requirements listed in the Standard Specifications except that Field Compressive Strength Specimens are not required.

D. Manufacture

Precast box culverts may be manufactured by either the wet cast method or dry cast method.

1. Mixture – In addition to the requirements of Section 1077 of the Standard Specifications, do not proportion the mix with less than 564 lb/yd³ (335 kg/m³) of portland cement.
2. Strength – Make sure that all concrete develops a minimum 28-day compressive strength of 5000 psi (34.5 MPa). Movement of the precast sections should be minimized during the initial curing period. Any damage caused by moving or handling during the initial curing phase will be grounds for rejection of that precast section.
3. Air Entrainment – Air entrain the concrete in accordance with Section 1077 - 5(A) of the Standard Specifications. For dry cast manufacturing, air entrainment is not required.
4. Testing – Test the concrete in accordance with the requirements of Section 1077 - 5(B).
5. Handling – Handling devices or holes are permitted in each box section for the purpose of handling and laying. Submit details of handling devices or holes for approval and do not cast any concrete until approval is granted. Remove all handling devices flush with concrete surfaces as directed. Fill holes in a neat and workmanlike manner with an approved non-metallic non-shrink grout, concrete, or hole plug.

E. Physical Requirements

Acceptability of precast culvert sections is based on concrete cylinders made and tested in accordance with AASHTO T22 and AASHTO T23.

F. Permissible Variations

1. Flatness – All external surfaces shall be flat, true, and plumb. Irregularities, depressions, or high spots on all external surfaces shall not exceed 1/2 inch (12 mm) in 8 feet (2.5 meters).

2. Internal Dimensions – Produce sections so that the internal and haunch dimensions do not vary more than 1/4 inch (6 mm) from the plan dimensions.
3. Adjacent Sections - Internal, external, and haunch dimensions for connecting sections shall not vary more than 1/2 inch (12 mm).
4. Length of Tongue and Groove – The minimum length of the tongue shall be 4 inches (100 mm). The minimum length of the groove shall be 4 inches (100 mm). The dimensions of the tongue and groove shall not vary more than 1/4 inch (6 mm) from the plan dimensions.
5. Slab and Wall Thickness – Produce sections so that the slab and wall thickness are not less than that shown on the plans by more than 5% or 3/16 inch (5 mm), whichever is greater. A thickness more than that required on the plans is not a cause for rejection.
6. Length of Opposite Surfaces – Produce sections so that variations in laying lengths of two opposite surfaces of the box section meet the requirements of AASHTO M259, Section 11.3.
7. Length of Section – Produce sections so that the underrun in length of a section is not more than 1/2 inch (13 mm) in any box section.
8. Position of Reinforcement – Produce sections so that the maximum variation in the position of the reinforcement is $\pm 3/8$ " (± 10 mm) for slab and wall thicknesses of 5 inches (125 mm) or less and $\pm 1/2$ " (± 13 mm) for slab and wall thicknesses greater than 5 inches (125 mm). Produce sections so that the concrete cover is never less than 5/8 inch (16 mm) as measured to the internal surface or the external surface. The preceding minimum cover limitations do not apply at the mating surfaces of the joint.
9. Area of Reinforcement – Use the design steel shown on the plans for the steel reinforcement. Steel areas greater than those required are not cause for rejection. The permissible variation in diameter of any wire in finished fabric is prescribed for the wire before fabrication by either AASHTO M32 or M225.

G. Marking

1. Each section shall be match-marked in order of intended installation as indicated on the approved shop drawings. Ensure that pieces fit together neatly and in a workmanlike manner. In order to ensure a good, neat field fit, assemble adjacent sections at the producer's facility and match-mark the pieces. This will require that a minimum of three adjacent sections of the culvert be fitted at the production yard at a time and then match-marked. Once three sections have been match-marked, the first section may be removed for shipment and a fourth section set for marking. Continue in a progressive manner until all sections have been properly match-marked.

2. Clearly mark each section of the box culvert in accordance with AASHTO M259, Section 15.

H. Construction

1. Foundation – Foundation for precast box culvert shall meet the requirements of Section 414 of the Standard Specifications. In addition, Type VI foundation material shall be encapsulated in filter fabric conforming to Type 4 requirements in Section 1056 of the Standard Specifications. The filter fabric shall be placed perpendicular to the culvert barrel. Provide sufficient overhang beyond the excavation to allow a minimum lap of 3 feet (900 mm) when the foundation material is placed and fabric wrapped on top. Perpendicular sections of fabric shall be continuous. A minimum lap of 2 feet (600 mm) shall be provided between sections of fabric.
2. Installation – Sections shall be placed at the beginning of the outlet end of the culvert with the groove end being laid upgrade. Tongue sections shall be laid into the groove sections. Positive means shall be provided to pull each section firmly into the previously placed section so that the joints are tightly homed. Use a "come-along", box pullers or other approved methods to create a positive means of joining box sections. Construction equipment shall not have direct contact with the box section. The load of the box shall be suspended by lifting device during joining procedure.
3. Backfill – Complete backfill in accordance with Section 414 of the Standard Specifications.

Basis of Payment

The Precast Reinforced Concrete Box Culvert as described on the plans and in this Special Provision will be paid for at the contract lump sum price for "Precast Reinforced Concrete Box Culvert at -L- Station 49+24.11". Such price and payment will be full compensation for all work covered by this Special Provision, the plans and applicable parts of the Standard Specifications and will include, but not be limited to, furnishing all labor, materials (including all filter fabric), equipment and other incidentals necessary to complete this work. Such price and payment will also be full compensation for concrete, reinforcing steel, labor, equipment and all other related materials necessary for the completion of the barrel section, and the construction of the headwalls, end curtain walls, wings and wing footings. Culvert Excavation and Foundation Conditioning Material will be paid for in accordance with the Standard Specifications and will not be a part of this pay item.

Payment will be made under:

Pay Item	Pay Unit
Precast Box Culvert at -L- Station 49+24.11	Lump Sum