Project C-4901A **Davidson County**

PROJECT SPECIAL PROVISIONS
STRUCTURE

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TERMS AND DEFINITIONS **(SPECIAL)**

Unless noted otherwise, the following terms and their associated definitions are applicable throughout these Project Special Provisions:

Terms	Definitions
Railway, Railway Company, Railroad, Railroad Company	Norfolk Southern Corporation
Railroad Engineer	The authorized representative of the Railway.
AREMA	American Railway Engineering and Maintenance-of-Way Association.
NCDOT, Department, Department of Transportation	North Carolina Department of Transportation.
Standard Specifications, Specifications	NCDOT Standard Specifications for Roads and Structures, January 2012.
Engineer, Department's Engineer Project Engineer, Highway Engineer	The authorized representative of the NCDOT.
Inspector, Department's Inspector	The authorized inspector of the NCDOT.

PLACING LOAD ON STRUCTURE MEMBERS (11-27-12)

The 2012 Standard Specifications shall be revised as follows:
In **Section 420-20 – Placing Load on Structure Members** replace the first sentence of the fifth paragraph 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 7 curing days.

TEMPORARY RAILROAD SHORING (3-6-09)

1.0 GENERAL

Provide temporary railroad shoring for each bent indicated in the plans in accordance with the Standard Specifications and this Special Provision.

2.0 ALTERNATE DESIGN AND PLANS

The submittal of an alternate design and plans for excavation and shoring is permitted in lieu of the excavation and shoring detailed on the plans. The alternate design shall be in accordance with the current railway design criteria. Have the alternate design computations and plans sealed by a North Carolina Registered Professional Engineer and submit them for review, comments and acceptance. After the appropriate State agency accepts them, they are submitted by the State agency to the Railroad for review, comments and acceptance. Allow a minimum of 30 days for the Railroad's review. Do not begin excavation at the excavation site or sites in question until the Engineer confirms that both the State and Railroad accept the alternate design and plans. No extension of intermediate completion dates and/or final completion dates will be allowed due to delays in review of alternate excavation and shoring design and plans.

3.0 BASIS OF PAYMENT

Payment for the temporary railroad shoring will be made at the lump sum price bid for "Temporary Railroad Shoring for Abutment 1, Sta. 7662+38.00 -M1-". Such lump sum price will be full compensation for all materials, equipment, tools, labor, and incidentals necessary to complete the work.

Payment for the temporary railroad shoring will be made at the lump sum price bid for "Temporary Railroad Shoring for Abutment 2, Sta. 7662+38.00 -M1-". Such lump sum price will be full compensation for all materials, equipment, tools, labor, and incidentals necessary to complete the work.

FALSEWORK AND FORMWORK (4-5-12)

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.

As an option for the Contractor, overhang falsework hangers may be uniformly spaced, at a maximum of 36 inches, provided the following conditions are met:

Member Type (PCG)	Member Depth, (inches)	Max. Overhang Width, (inches)	Max. Slab Edge Thickness, (inches)	Max. Screed Wheel Weight, (lbs.)	Bracket Min. Vertical Leg Extension, (inches)
II	36	39	14	2000	26
III	45	42	14	2000	35
IV	54	45	14	2000	44
MBT	63	51	12	2000	50
MBT	72	55	12	1700	48

Overhang width is measured from the centerline of the girder to the edge of the deck slab.

For Type II, III & IV prestressed concrete girders (PCG), 45-degree cast-in-place half hangers and rods must have a minimum safe working load of 6,000 lbs.

For MBT prestressed concrete girders, 45-degree angle holes for falsework hanger rods shall be cast through the girder top flange and located, measuring along the top of the member, 1'-2 ½" from the edge of the top flange. Hanger hardware and rods must have a minimum safe working load of 6,000 lbs.

The overhang bracket provided for the diagonal leg shall have a minimum safe working load of 3,750 lbs. The vertical leg of the bracket shall extend to the point that the heel bears on the girder bottom flange, no closer than 4 inches from the bottom of the member. However, for 72-inch members, the heel of the bracket shall bear on the web, near the bottom flange transition.

Provide adequate overhang falsework and determine the appropriate adjustments for deck geometry, equipment, casting procedures and casting conditions.

If the optional overhang falsework spacing is used, indicate this on the falsework submittal and advise the girder producer of the proposed details. Failure to notify the

Engineer of hanger type and hanger spacing on prestressed concrete girder casting drawings may delay the approval of those drawings.

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 ¾".

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. 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 above ground	Pressure, lb/ft^2 for Indicated Wind Velocity, mph				
	70	80	90	100	110
0 to 30	15	20	25	30	35
30 to 50	20	25	30	35	40
50 to 100	25	30	35	40	45
over 100	30	35	40	45	50

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

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. 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 (2-10-12)

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 (Paul Lambert)

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

jgaither@ncdot.gov (James Gaither)

jlbolden@ncdot.gov (James Bolden)

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) 707 – 6407
(919) 250 – 4082 facsimile
plambert@ncdot.gov

Secondary Structures Contacts: James Gaither (919) 707 – 6409
James Bolden (919) 707 – 6408

Eastern Regional Geotechnical Contact (Divisions 1-7):
K. J. Kim (919) 662 – 4710
(919) 662 – 3095 facsimile
kkim@ncdot.gov

Western Regional Geotechnical Contact (Divisions 8-14):
John Pilipchuk(704) 455 – 8902
(704) 455 – 8912 facsimile
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

Submittal	Copies Required by Structure Design Unit	Copies Required by Geotechnical Engineering Unit	Contract Reference Requiring Submittal [1]
Arch Culvert Falsework	5	0	Plan Note, SN Sheet & "Falsework and Formwork"
Box Culvert Falsework [7]	5	0	Plan Note, SN Sheet & "Falsework and Formwork"
Cofferdams	6	2	Article 410-4
Foam Joint Seals [6]	9	0	"Foam 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 [2] (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 [4,5]	7	0	Article 1072-8
Miscellaneous Metalwork [4,5]	7	0	Article 1072-8
Optional Disc Bearings [4]	8	0	"Optional Disc Bearings"
Overhead and Digital Message Signs (DMS) (metalwork and foundations)	13	0	Applicable Provisions
Placement of Equipment on Structures (cranes, etc.)	7	0	Article 420-20
Pot Bearings [4]	8	0	"Pot Bearings"
Precast Concrete Box Culverts	2, then 1 reproducible	0	"Optional Precast Reinforced Concrete Box Culvert at Station ___"
Prestressed Concrete Cored Slab (detensioning sequences) [3]	6	0	Article 1078-11
Prestressed Concrete Deck Panels	6 and	0	Article 420-3

	1 reproducible		
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 (precast items)	10	0	Article 1077-2 & "Sound Barrier Wall"
Sound Barrier Wall Steel Fabrication Plans [5]	7	0	Article 1072-8 & "Sound Barrier Wall"
Structural Steel [4]	2, then 7	0	Article 1072-8
Temporary Detour Structures	10	2	Article 400-3 & "Construction, Maintenance and Removal of Temporary Structure at Station ____"
TFE Expansion Bearings [4]	8	0	Article 1072-8

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 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 1072-8 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

Submittal	Copies Required by Geotechnical Engineering Unit	Copies Required by Structure Design Unit	Contract Reference Requiring Submittal [1]
Drilled Pier Construction Plans [2]	1	0	Subarticle 411-3(A)
Crosshole Sonic Logging (CSL) Reports [2]	1	0	Subarticle 411-5(A)(2)
Pile Driving Equipment Data Forms [2,3]	1	0	Subarticle 450-3(D)(2)
Pile Driving Analyzer (PDA) Reports [2]	1	0	Subarticle 450-3(F)(3)
Retaining Walls [4]	8 drawings, 2 calculations	2 drawings	Applicable Provisions
Temporary Shoring [4]	5 drawings, 2 calculations	2 drawings	"Temporary Shoring" & "Temporary Soil Nail Walls"

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. Subarticles refer to the *Standard Specifications*.

2. 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 appropriate Geotechnical Engineering Unit regional office. Electronic submission is preferred.

3. The Pile Driving Equipment Data Form is available from:
www.ncdot.org/doh/preconstruct/highway/geotech/formdet/
See second page of form for submittal instructions.

4. Electronic copy of submittal is required. See referenced provision.

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 9-30-11

1.0 DESCRIPTION

This special provision addresses grout for use in pile blockouts, grout pockets, shear keys, dowel holes and recesses for structures. This provision does not apply to grout placed in post-tensioning ducts for bridge beams, girders, or decks. Mix and place grout in accordance with the manufacturer's recommendations, the applicable sections of the Standard Specifications and this provision.

2.0 MATERIAL REQUIREMENTS

Use a Department approved pre-packaged, non-shrink, non-metallic grout. Contact the Materials and Tests Unit for a list of approved pre-packaged grouts and consult the manufacturer to determine if the pre-packaged grout selected is suitable for the required application.

When using an approved pre-packaged grout, a grout mix design submittal is not required.

The grout shall be free of soluble chlorides and contain less than one percent soluble sulfate. Supply water in compliance with Article 1024-4 of the Standard Specifications.

Aggregate may be added to the mix only where recommended or permitted by the manufacturer and Engineer. The quantity and gradation of the aggregate shall be in accordance with the manufacturer's recommendations.

Admixtures, if approved by the Department, shall be used in accordance with the manufacturer's recommendations. The manufacture date shall be clearly stamped on each container. Admixtures with an expired shelf life shall not be used.

The Engineer reserves the right to reject material based on unsatisfactory performance.

Initial setting time shall not be less than 10 minutes when tested in accordance with ASTM C266.

Test the expansion and shrinkage of the grout in accordance with ASTM C1090. The grout shall expand no more than 0.2% and shall exhibit no shrinkage. Furnish a Type 4 material certification showing results of tests conducted to determine the properties listed in the Standard Specifications and to assure the material is non-shrink.

Unless required elsewhere in the contract the compressive strength at 3 days shall be at least 5000 psi. Compressive strength in the laboratory shall be determined in accordance with ASTM C109 except the test mix shall contain only water and the dry manufactured material. Compressive strength in the field will be determined by molding and testing 4" x 8" cylinders in accordance with AASHTO T22. Construction loading and traffic loading shall not be allowed until the 3 day compressive strength is achieved.

When tested in accordance with ASTM C666, Procedure A, the durability factor of the grout shall not be less than 80.

3.0 SAMPLING AND PLACEMENT

Place and maintain components in final position until grout placement is complete and accepted. Concrete surfaces to receive grout shall be free of defective concrete, laitance, oil, grease and other foreign matter. Saturate concrete surfaces with clean water and remove excess water prior to placing grout.

Do not place grout if the grout temperature is less than 50°F or more than 90°F or if the air temperature measured at the location of the grouting operation in the shade away from artificial heat is below 45°F.

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.

The Engineer will determine the locations to sample grout and the number and type of samples collected for field and laboratory testing. 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.

4.0 BASIS OF PAYMENT

No separate payment will be made for "Grout for Structures". The cost of the material, equipment, labor, placement, and any incidentals necessary to complete the work shall be considered incidental to the structure item requiring grout.

PILES (1-17-12)

Revise the *Standard Specifications* as follows:

Replace Section 450 with the following:

SECTION 450
PILES

450-1 DESCRIPTION

Furnish and drive bearing piles as shown on the plans and as directed by the Engineer to the required bearing and penetration. Furnish, weld, and attach steel pile points, pipe pile plates, pile tips and splicers; provide collars, hardware, concrete, reinforcing steel, and all other materials; furnish all equipment, preauger through embankments, install piles vertically or on a batter; galvanize, cut off, splice, and build up piles; place concrete and reinforcing steel; construct pile trestles; furnish and place temporary bracing; remove any obstructions; wrap, bolt, or fasten timber fender piles; and abandon, remove, replace, and restrike or redrive piles as necessary.

450-2 MATERIALS

Refer to Division 10.

Item	Section
Portland Cement Concrete	1000
Reinforcing Steel	1070
Timber, Steel and Prestressed Concrete Piles	1084-1
Steel Pipe Pile Plates	1072

450-3 PREPARATION FOR DRIVING

If applicable, completely excavate for the cap and/or footing before installing piles. If applicable and unless noted otherwise on the plans, construct the embankment to the bottom of cap or footing elevation 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. If preaugering through an embankment is necessary before driving prestressed concrete piles, submit the preaugering and pile installation methods with the proposed pile driving methods and equipment for approval.

450-4 DETERMINATION OF PILE LENGTH

The estimated total pile lengths per structure shown on the plans are for bid purposes only. Determine pile lengths and furnish piling of sufficient length to obtain the required bearing and penetration and the required embedment into the cap or footing as shown on the plans. As an option and at no cost to the Department, make investigations as necessary to determine the required pile lengths.

450-5 DRIVING EQUIPMENT

Submit the proposed pile driving methods and equipment including the pile driving hammer, hammer cushion, pile helmet and cushion, if any. Do not submit more than two pile driving hammers per pile type per submittal. Submit this information for approval at least 20 working days before driving piles. All equipment is subject to satisfactory field performance.

Drive bearing piles with approved driving equipment using steam, air, or diesel hammers. Use pile driving hammers with an energy that will not overstress the piles during driving and provide the required driving resistance at blows per foot ranging from 36 to 96, unless otherwise approved. Use a variable energy hammer to drive prestressed concrete piles.

Operate steam, air, or diesel hammers at the length of stroke and number of blows per minute required by the Engineer. Operate air and steam hammers within 10% of the manufacturer's rated speed in blows per minute or the rate approved by the Engineer.

Provide 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. Use striking parts of air and steam hammers that weigh at least 1/3 the weight of the pile helmet and pile, with a minimum weight of 2,750 lb (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 allow the Engineer to visually determine hammer stroke at all times during pile driving operations.

Equip closed-end (double acting) diesel hammers with a calibrated bounce chamber pressure gauge, in good working order, mounted near ground level and easily read by the Engineer. Also, provide a current calibrated chart or graph equating bounce chamber pressure and gauge hose length to equivalent energy for the closed-end diesel hammer used. Submit this chart or graph with the proposed pile driving methods and equipment required above.

Protect and hold pile heads in position with an approved pile helmet. Make sure that the pile helmet closely fits the top of the pile and extends down the sides of the pile a sufficient distance to hold the pile in position. Protect the heads of concrete and timber piles from direct impact with an approved pile cushion. Provide collars or bands to protect timber piles against splitting or brooming where required.

450-6 ACCURACY OF DRIVING

Drive piles so that the axial alignment is within 1/4" (6 mm) per foot from the vertical or batter shown on the plans. Horizontally, keep the pile within 3" (75 mm) of the plan location longitudinally and transversely. Maintain pile embedment in the cap or footing to within 3" (75 mm) more or 2" (50 mm) less than that shown on the plans. No additional payment is made for increased cap or footing dimensions necessary due to piles driven out of position.

450-7 CONSTRUCTION METHODS

(A) General

Unless approved otherwise or directed by the Engineer, do not drive piles within 50 ft (15 m) of cast-in-place concrete until the concrete attains an age of at least 3 curing days. When approved by the Engineer, the Contractor may use vibratory hammers to install the initial portions of steel piles. The Engineer will approve the depth of pile installation with the vibratory hammer. Do not use vibratory hammers to install prestressed concrete piles.

The Engineer will inspect the capblock before beginning each pile driving project and periodically throughout the duration of the project, depending on driving conditions as

determined by the Engineer. Expose the hammer cushion for inspection as directed by the Engineer. Replace or repair any hammer cushion that is less than 25% of the original thickness.

Do not exceed the allowable pile driving stresses during the entire driving time. Allowable pile driving stresses are defined in the *AASHTO Standard Specifications for Highway Bridges*. Drive piles to the required tip elevation or penetration into natural ground, whichever is lower, in a continuous operation unless stopped due to exceeding the maximum blow count or the allowable pile driving stresses, insufficient pile length, or other reasons approved by the Engineer. Once the required embedment is achieved, the Engineer may require the Contractor to stop driving and wait before restriking to allow for soil setup.

Use a pile cushion made of pine plywood with a 4" (100 mm) minimum thickness for driving prestressed concrete piles. When using a pile cushion, provide a new cushion for each pile unless otherwise approved. Replace the pile cushion if, during the driving of any pile, the cushion is either compressed more than one-half the original thickness or begins to burn.

Redrive any pile raised or moved laterally by the driving of adjacent piles.

(B) Timber Piles

Store and handle timber piles by methods that do not damage the pile. Take care to avoid breaking the surface of treated piles. Do not use cant-hooks, dogs, or pike-poles. Treat cuts or breaks in the surface of treated piles in an approved manner.

Cut off the tops of all piles at the elevation shown on the plans. Except where a cast-in-place concrete cap or footing is constructed, cut off piles to a plane that provides true bearing on every pile without the use of shims. Withdraw any pile damaged during driving operations, driven out of its proper location or below the cut-off grade and replace with a new pile, or otherwise correct as directed by the Engineer.

Thoroughly brush-coat the sawn surface of all timber piles not encased in concrete with 3 applications of approved preservative treatment and then cover with a coat of hot roofing pitch or other approved hot bituminous material. Place a sheet of galvanized iron or aluminum upon each pile head, bend it down over the sides of the pile, neatly trim and firmly secure to the pile with large headed galvanized roofing nails. Use sheets of iron that are 24 gauge and 24" (600 mm) by 24" (600 mm) in size. If using aluminum, use the same size as specified for galvanized iron sheets with a minimum thickness of 0.032" (0.81 mm).

(C) Prestressed Concrete Piles

Handle, transport, and store prestressed concrete piles by methods that do not damage the pile and support the piles at the pick-up points shown on the plans or along their full length. Replace piles damaged in handling or driving unless they are repaired to an acceptable condition.

When driving or cutting off piles below the elevation shown on the plans, build up the pile section to the plan elevation as shown on the plans unless otherwise directed by the Engineer.

Cut off piles not driven to grade perpendicular to the axis of the pile by means that do not result in spalling or other damage to the pile. Use steel pile tips with prestressed concrete piles when shown on the plans. Use pile splicers for splicing steel pile tips. Contact the Materials and Tests Unit for a list of approved pile splicers. Submit pile splicer specifications with the manufacturer's attachment detail to the Engineer for approval before installation.

(D) Steel Piles

Handle and store steel piles by methods that do not damage the pile. Store the piles above ground upon platforms, blocks, or other supports and keep the piles free from dirt, grease, and other foreign matter, and protect insofar as is practicable from corrosion. Do not damage coatings on steel piles. Protect coatings when driving piles through templates in an approved manner.

When shown on the plans, galvanize steel piles in accordance with Section 1076. Prepare the pile surface and provide materials in accordance with the applicable portions of this section.

Use pile points for steel piles when shown on the plans or as directed by the Engineer. Contact the Materials and Tests Unit for a list of approved pile points. Weld pile points to piles in accordance with the manufacturers' details as approved by the Engineer. The minimum weld length is twice the width of the flange.

Furnish plates for pipe piles when shown on the plans or as directed by the Engineer. Weld plates to the bottom of pipe piles as shown on the plans. Use pipe pile plates with a thickness as shown on the plans and that meets the requirements of ASTM A709, Grade 50.

Cut off piles at the required elevations along a plane normal to the axis of the pile. Use approved methods for cutting off piles.

Use welded butt splices for steel piles as shown on the plans. Do not use more than 3 pieces (2 splices) of steel pile in making up one full-length pile.

(E) Redriving Piles

Once the required pile embedment has been achieved, the Contractor may choose to or the Engineer may require restriking or redriving piles. If the Contractor chooses to stop driving and then restrike or redrive piles, no payment will be made for restrikes or redrives. If the Engineer requires the Contractor to stop driving and then restrike or redrive piles, the payment will be made in accordance with Article 450-9. When the Engineer requires restrikes or redrives, the Engineer will determine the time to wait after stopping driving and the number of restrikes or redrives. However, the maximum number of restrikes or redrives per pile during any 48 hour period will not exceed three. The minimum time separation between redrives required by the Engineer is 4 hours.

Use the same approved pile driving methods, equipment and compressed pile cushion from the previous drive to restrike or redrive the pile unless the cushion is unacceptable due to deterioration, in which case use another acceptable cushion. Do not use a cold diesel hammer for a restrike or redrive, unless in the opinion of the Engineer, it is impractical to do otherwise. In general, warm up the hammer by applying at least 20

blows to a previously driven pile or timber mats on the ground.

450-8 PENETRATION AND WAVE EQUATION

When no tip elevation is shown on the plans, drive piles to the required bearing capacity and a penetration of at least 10 ft (3 m) into natural ground unless otherwise directed by the Engineer. When a tip elevation is shown on the plans, drive piles to the required bearing capacity and the specified tip elevation. When noted on the plans, drive piles to additional capacity to account for downdrag or negative skin friction and scour.

Natural ground within an area of new embankment is defined as the bottom of the embankment or bottom of footing on piles, whichever is lower.

The Engineer will use the wave equation analysis to evaluate the suitability of the proposed pile driving methods and equipment to evaluate pile driving stresses and estimate the driving resistance in order to achieve the required bearing capacity. The required driving resistance in blows per foot or any equivalent set is based upon the bearing capacity shown on the plans with a minimum safety factor of 2 plus any additional capacity to account for downdrag or negative skin friction and scour, when applicable. The Engineer will provide the required driving resistance based upon the wave equation analysis and pile driving analyzer results, if applicable, using the approved pile driving methods and equipment.

Stop driving piles when practical refusal is reached, unless otherwise directed by the Engineer. Practical refusal is defined as 180 blows per foot (0.3 m) or any equivalent set.

450-9 MEASUREMENT AND PAYMENT

Piles (Treated Timber Piles, _____ Prestressed Concrete Piles, _____ Steel Piles or _____ Galvanized Steel Piles) will be measured and paid as the actual number of linear feet (meters) of piles incorporated into the completed and accepted structure. This quantity is measured as the length of pile before driving minus any pile cut-offs. No payment will be made for pile cut-offs or cutting off piles. However, once the required bearing and penetration has been achieved, the Contractor may drive the remaining portion of a pile to grade in lieu of cutting off the pile provided the remaining portion does not exceed 5 ft (1.5 m) and the pile can be driven without damaging the pile or reaching the maximum blow count or practical refusal. When this occurs, the additional length of pile driven will be measured as described above.

For prestressed concrete piles that are built up, the quantity of piles to be paid for will also include the actual number of linear feet (meters) added to the original pile length by the build-up. Steel pile tips are not included in the quantity of prestressed concrete piles. No payment will be made for steel pile tips or pile splicers and any associated hardware or welding. The cost for these items will be considered incidental to the cost of the prestressed concrete pile.

Pile points will be measured and paid for per each for the actual number of pile points incorporated into the completed and accepted structure.

Pipe pile plates will be measured and paid for per each for the actual number of plates incorporated into the completed and accepted structure.

Pile redrives will be measured and paid for per each as the actual 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.

No payment will be made for any defective or rejected piles or any piles driven for falsework, bracing, or temporary work bridges.

The prices and payments will be full compensation for all items required to provide bearing piles including but not limited to those items contained in Article 450-1.

Payment will be made under:

Pay Item	**Pay Unit**
____ Prestressed Concrete Piles	Linear Foot
____ Steel Piles	Linear Foot
____ Galvanized Steel Piles	Linear Foot
Steel Pile Points	Each
Pipe Pile Plates	Each
Pile Redrives	Each

PILE EXCAVATION (1-17-12)

1.0 GENERAL

This special provision governs installing piles using pile excavation in accordance with the plans and as directed by the Engineer. Pile excavation is necessary when piles cannot be installed to the required bearing capacity and tip elevation with conventional driving equipment due to vibration concerns or the presence of rock, boulders, debris or very dense soils. Install piles in accordance with Section 450 of the Standard Specifications and this provision.

2.0 PILE EXCAVATION

Perform pile excavation to the required elevation shown on the plans or otherwise required by the Engineer. Excavate a hole with a diameter that will result in at least 3 in (75 mm) of clearance around the entire pile. Use equipment of adequate capacity and capable of drilling through soil and non-soil including rock, boulders, debris, man-made objects and any other materials encountered. Blasting is not permitted to advance the excavation. 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 material including water removed from the excavation either by pumping or drilling tools.

If unstable, caving or sloughing soils are anticipated or encountered, the Engineer may require the Contractor to stabilize the excavation with steel casing. Steel casing may be 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 or backfill. Use steel casings with an outside diameter equal to the hole size and a minimum wall thickness of 1/4 in (7 mm).

3.0 CONCRETE PLACEMENT

Before placing concrete, center the pile in the excavation and drive to the required bearing capacity and specified tip elevation, if applicable, as shown on the plans or as directed by the Engineer. Check the water inflow rate in the excavation after any pumps have been removed. If the inflow rate is less than 6 in (150 mm) per half hour, remove any water and free fall the concrete into the excavation. Ensure that concrete flows completely around the pile. If the water inflow rate is greater than 6 in (150 mm) per half hour, propose a concrete placement procedure to the Engineer. The Engineer shall approve the concrete placement procedure before placing concrete.

Fill the excavation with Class A concrete in accordance with Section 1000 of the Standard Specifications except as modified herein. Provide concrete with a slump of 6 to 8 in (150 to 200 mm). Use an approved high-range water reducer to achieve this slump. Place concrete in a continuous manner and remove all casings.

4.0 MEASUREMENT AND PAYMENT

A. Method of Measurement

1. Pile Excavation in Soil

The quantity of "Pile Excavation in Soil" to be paid for will be the linear feet (meters) of pile excavation exclusive of the linear feet (meters) of "Pile Excavation Not in Soil" computed from elevations and dimensions as shown on the plans or from revised dimensions authorized by the Engineer.

2. Pile Excavation Not in Soil

The quantity of "Pile Excavation Not in Soil" to be paid for will be the linear feet (meters) of pile excavation in non-soil as determined by the Engineer. Non-soil is defined as material that cannot be cut with a rock auger and requires excavation by coring, air tools, hand removal or other acceptable methods. Top of non-soil elevation is that elevation where the rock auger penetration rate is less than 2 in (50 mm) per 5 minutes of drilling at full crowd force and coring, air tools, etc. are used to advance the excavation. For pay purposes, after non-soil is encountered, earth seams, rock fragments and voids in the excavation less than 3 ft (0.9 m) in total length will be considered "Pile Excavation Not in Soil". If the non-soil is discontinuous, payment will revert to "Pile Excavation in Soil" at the elevation where non-soil is no longer encountered.

B. Basis of Payment

1. Pile Excavation in Soil

Payment will be made at the contract unit price per linear foot (meter) for "Pile Excavation in Soil". Such payment will include, but is not limited to, furnishing all labor, tools, equipment, materials including concrete complete and in place and all incidentals necessary to excavate and complete the work as described in this provision. The cost for the pile will be paid for separately in accordance with the Standard Specifications and will not be part of the unit bid price for "Pile Excavation in Soil".

2. Pile Excavation Not in Soil

Payment will be made at the contract unit price per linear foot (meter) for "Pile Excavation Not in Soil". Such payment will include, but is not limited to, furnishing all labor, tools, equipment, materials including concrete complete and in place and all incidentals necessary to excavate and complete the work as described in this provision. The cost for the pile will be paid for separately in accordance with the Standard Specifications and will not be part of the unit bid price for "Pile Excavation Not in Soil".

DRILLED PIERS (1-17-12)

Revise the *Standard Specifications* as follows:

Replace Section 411 with the following:

SECTION 411
DRILLED PIERS

411-1 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, penetration tests, integrity testing and assistance with the shaft inspection device as noted in the plans. Construct drilled piers with the required capacities 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 Article 411-7 for measurement and payment of drilled piers.

411-2 MATERIALS

Refer to Division 10.

Item	Section
Grout, Nonshrink	1003
Portland Cement Concrete, Class Drilled Pier	1000
Reinforcing Steel	1070

Provide Type 3 material certifications in accordance with Article 106-3 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.

(F) 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" (10 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 Table 411-1.

TABLE 411-1
MINIMUM PERMANENT CASING WALL THICKNESS

Casing Diameter	Nominal Wall Thickness
< 48" (1220 mm)	0.375" (10 mm)
48" - 78" (1220 mm - 1980 mm)	0.500" (13 mm)
> 78" (1980 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.

(G) 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 Table 411-2.

TABLE 411-2
BENTONITE SLURRY REQUIREMENTS[a]

Property	ANSI/API RP[b] 13B-1	Requirement
Density[c] (Mud Weight)	Section 4	64.3 - 72.0 lb/cf (1030 - 1150 kg/m^3)
Viscosity	Section 6.2 Marsh Funnel	28 - 50 sec/qt (28 - 50 sec/0.95 liter)
Sand Content	Section 9	≤ 4 %[d]
		≤ 2 %[e]
pH	Section 11 Glass Electrode pH Meter[f]	8 - 11

a. Slurry temperature of at least 40°F (4.4°C) required
b. American National Standards Institute/American Petroleum Institute Recommended Practice
c. Increase density requirements by 2 lb/cf (32 kg/m^3) in saltwater
d. In tanks before pumping slurry into excavations
e. In excavations immediately before placing concrete
f. 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 the Department's website or the Geotechnical Engineering Unit.

Provide polymer slurry that meets Table 411-3.

TABLE 411-3
POLYMER SLURRY REQUIREMENTS[a]

Property	ANSI/API RP[b] 13B-1	Requirement
Density[c] (Mud Weight)	Section 4	≤ 64 lb/cf (≤ 1025 kg/m^3)
Viscosity	Section 6.2 Marsh Funnel	32 - 135 sec/qt (32 - 135 sec/0.95 liter)
Sand Content	Section 9	≤ 0.5 %[d,e]
pH	Section 11 Glass Electrode pH Meter[f]	8 - 11.5

a. Slurry temperature of at least 40°F (4.4°C) required
b. American National Standards Institute/American Petroleum Institute Recommended Practice
c. Increase density requirements by 2 lb/cf (32 kg/m^3) in saltwater
d. In tanks before pumping slurry into excavations
e. In excavations immediately before placing concrete
f. pH paper is also acceptable for measuring pH

(H) 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 in 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 in the plans.

(I) 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.

411-3 PRECONSTRUCTION REQUIREMENTS

(A) Drilled Pier Construction Plan

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;

(10) Approved packaged grout or grout mix design that meets Section 1003;

(11) CSL Consultant including Field and Project Engineer; and

(12) Other information shown in 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.

411-4 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.

Construct drilled piers with the minimum required diameters shown in 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 in the plans.

Install drilled piers with tip elevations no higher than shown in the plans or approved by the Engineer. Provide piers with the minimum required end bearing capacity and, when noted in 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 in the plans, whichever is greater. Drilling below pier tip elevations shown in the plans may be required to attain sufficient capacity.

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. 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 in 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 in the plans. Install permanent casings with tip elevations no deeper than shown in 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 in 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 in 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 Drilled Pier 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) Bearing Capacity

If the Engineer determines that the material below an excavation does not provide the minimum required end bearing capacity, 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 in 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 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 in 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 in 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 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 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 bearing capacity 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 in Subarticle 411-4(D)(2), 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 in 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. 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 (24.4 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 (24.4 m), place concrete with a tremie or pump pipe down the center of excavations so length of free fall is less than 80 ft (24.4 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. 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.

411-5 INTEGRITY TESTING

Define "integrity testing" as crosshole sonic logging (CSL) and pile integrity testing (PIT). Integrity testing may be required as noted in the plans or by the Engineer. 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" (63.5 mm) or less from the bottom of CSL tubes to top of piers.

(2) CSL Testing

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

(a) Title Sheet

(i) Department's TIP number and WBS element number

(ii) Project description

(iii) County

(iv) Bridge station number

(v) Pier location

(vi) Personnel

(vii) Report date

(b) Introduction

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

(d) Pier Details

(i) Pier and casing diameters, lengths and elevations

(ii) Drilled Pier concrete compressive strength

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

(e) CSL Results

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

(f) Summary/Conclusions

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

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

(g) Attachments

(i) Boring log(s)

(ii) Field inspection forms and concrete curves (from Engineer)

(iii) CSL tube locations, elevations, lengths and identifications

(iv) CSL hardware model and software version information

(v) 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 Table 411-4.

TABLE 411-4
DRILLED PIER FURTHER INVESTIGATION CRITERIA
(For Initial CSL Testing)

Velocity Reductions	Further Investigation Required?
< 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 that meet Subarticle 411-5(A)(2). 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 integrity testing. Questionable piers with only CSL testing will be considered defective if any velocity reductions between any tube pairs are greater than 30%.

411-6 DRILLED PIER ACCEPTANCE

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

(A) Temporary casings and drilling tools are removed from the drilled pier excavation or the Engineer determines that a temporary casing may remain in the excavation.

(B) Drilled Pier concrete is properly placed and does not have any evidence of segregation, intrusions, contamination, structural damage or inadequate consolidation

(honeycombing).

(C) 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 in the plans or approved by the Engineer.

(D) 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 in the plans or approved by the Engineer.

(E) Drilled pier is not defective or the Engineer determines the defective pier is satisfactory. A pier will be considered defective based on Subarticle 411-5(D).

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 drilled pier is accepted, dewater and grout CSL tubes and core holes, and backfill around the pier with approved material to finished grade. 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. 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 or post repair testing.

411-7 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 in 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 in 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 in 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.

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 in 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 in 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. No payment will be made for remediation of unacceptable drilled piers or post repair testing.

Payment will be made under:

Pay Item	**Pay Unit**
____ 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

EPOXY MORTAR REPAIRS (12-5-12)

1.0 MATERIAL PROPERTIES

Use a two-component paste epoxy bonding agent for the epoxy mortar conforming to the following requirements:

Density, lbs/gal	10.5
Specific Gravity	1.3
Minimum Application Temperature, °F	50
Application Temperature Range, °F	60 to 105
Shelf Life	1 year (min.)

	@ 60°F	@ 85°F	@ 105°F
Potlife, hr., 1 gallon	2½	1	½
Open Time[1], minimum: hr.	4	1¾	¾
Non-sag Thickness, inches (ASTM D2730)	1	¾	½
Initial Cure[2], days (AASHTO T237)	10	6	3
Cure Time[3], days (ASTM D695)	20	10	7

Typical Mechanical Properties[4]	
Tensile Strength, psi Elongation at Break (ASTM D638)	1,500 4%
Compressive Yield Strength, psi Compressive Modulus, psi (ASTM D695)	8,000 4.0×10^5
Heat Deflection Temperature[5], °F (ASTM D648)	105
Slant Shear Strength, psi Damp to Damp Concrete (AASHTO T237)	5,000 100% Concrete Failure

1. From start of mixing to completion of repair
2. 5,000 psi minimum
3. Isothermal cure to eliminate effect of exotherm
4. Cure schedule 7 days @ 77°F, test temperature 77°F
5. 128°F after 28 day cure

2.0 SURFACE PREPARATION

Prior to the application of epoxy mortar, thoroughly clean surfaces to be repaired and remove all loose materials. Remove grease, wax, and oil contaminants by scrubbing with an industrial grade detergent or degreasing compound followed by a mechanical cleaning. Remove weak or deteriorated concrete to sound concrete by bush hammering, gritblasting, scarifying, waterblasting, or other approved methods. Remove dirt, dust, laitance and curing compounds by gritblasting, sanding, or etching with 15% hydrochloric acid.

Acid etch only if approved by the Engineer. Follow acid etching by scrubbing and flushing with copious amounts of clean water. Check the cleaning using moist pH paper. Water cleaning is complete when the paper reads 10 or higher.

Follow all mechanical cleaning with vacuum cleaning.

3.0 APPLICATION

When surface preparation is completed, apply epoxy mortar to the areas specified in the contract plans and established by the Engineer. Repair deep surface irregularities such as severe spalling with a 1:1 sand-epoxy mix. Use graded silica sand that is washed, kiln-dried, and bagged. Repair shallow surface irregularities with the epoxy bonding agent. The finishing of those areas receiving the sand-epoxy mix with the epoxy bonding agent is permitted.

Apply epoxy mortar to damp surfaces only when approved. In such instances, remove all free water by air-blasting.

After applying the epoxy mortar, remove excessive material and provide a smooth, flush surface. Remove the epoxy material in accordance with the supplier's instructions.

4.0 MEASUREMENT AND PAYMENT

Payment for Epoxy Mortar Repairs will be at the contract unit price per square foot for "Epoxy Mortar Repairs". Such payment will be full compensation for furnishing all material, labor, tools and equipment necessary for performing this work complete in place and accepted. For repairs of edge or corner areas, the surface to be measured for payment will be the largest surface and the other surfaces will not be measured.

WATERPROOFING **(SPECIAL)**

Waterproof the top surface of the bridge deck and all construction joints which will be covered by fill with a cold liquid-applied elastomeric membrane to the limits shown in the contract plans. Waterproofing membrane shall be a two coat, rapid cure, seamless, cold liquid spray applied membrane such as the "Eliminator" system manufactured by Stirling Lloyd Products, Inc., or the "Bridge Deck Membrane" system manufactured by Bridge Preservation L.L.C. (R.J. Watson, Inc.) or approved equal. Apply waterproofing in strict accordance with manufacturer's recommendations. Immediately prior to application of membrane, clean the surfaces to be waterproofed per the manufacturer's recommendations. Membrane protection is not required, i.e. ballast may be placed directly on top of the fully cured membrane waterproofing.

The entire cost of the waterproofing complete in place will be paid for at the contract unit price per square yard for "Waterproofing".

PORTLAND CEMENT **(SPECIAL)**

Portland Cement shall meet the requirements of the Standard Specifications for the type specified for the work. In addition, in order to minimize alkali content, the total percentage of sodium oxide (Na_2O) present plus 0.658 times the total percentage of potassium oxide (K_20) present shall not exceed 0.60 percent. The Contractor shall furnish the Engineer with two (2) copies of certified mill test reports from the manufacturer stating that all cement meets the above requirements.

Flyash may be substituted for cement in the amounts shown in Section 1024-1 of the Standard Specifications provided that the minimum cement requirement as shown on the Plans has been satisfied. In no case shall the substitution of flyash or other admixtures approved by the Engineer be in lieu of the minimum cement requirements.

FINE AND COARSE AGGREGRATE **(SPECIAL)**

The fine and coarse aggregates used in all concrete on the railway structure shall be non-reactive in accordance with the "Method of Test for Potential Reactivity of Aggregates (Chemical Method)", ASTM Designation C289-81. The Contractor shall furnish the Engineer two (2) copies of the above test reports certifying that the fine and coarse aggregates are non-reactive and will not cause an alkali reaction.

WATERSTOPS **(SPECIAL)**

Waterstops shall be made of an approved flexible polyvinyl-chloride plastic conforming to U.S. Corps of Engineers Specification CRD-C-572-74 or rubber conforming to U.S. Corps of Engineers Specification CRD-C-513-75. Waterstops shall be made in the shape and of the material specified on the Plans. The material shall form a continuous waterstop across the slab and up the parapets of bridge decks, abutment wings, or other locations as shown on the Plans. Waterstops shall be fabricated in continuous units without splices, using material of the longest length available. Where

bonded joints are necessary, like materials shall be bonded together by experienced men in accordance with the manufacturer's instructions. The entire cost of the waterstop complete in place shall be included in the unit contract price bid for "Reinforced Concrete Deck Slab."

ELASTOMERIC FLASHING **(SPECIAL)**

The elastomeric flashing at the expansion joint between deck slabs shall be a continuous sheet of synthetic rubber 1/16" thick by 10" wide or equal based on polychloroprene having properties specified by the following test data:

Tensile Strength, ASTM D-412-80	2,000 psi minimum
Elongation, ASTM D-412-80	300% minimum
Hardness, ASTM D-2240-81	60 ± 10
Water Absorption, ASTM D-471-79	10% maximum

The adhesive for use with the flashing shall be as recommended by the manufacturer of the synthetic rubber furnished and shall be applied according to the manufacturer's instructions.

The entire cost of the elastomeric flashing, complete in place, shall be included in the unit contract price bid for "Reinforced Concrete Deck Slab."

RUBBER JOINT COMPOUNDS **(SPECIAL)**

Expansion joints shall be sealed with a two component elastomeric polymer type cold-applied synthetic joint sealer, manufactured with Thiokol polysulfide liquid polymers. The material shall be grey polysulfide rubber base caulking compound conforming to Specification ANSI A-116.1. Pouring type compound shall be used for horizontal joints and non-sag type for other joints. The mixing and application of the joint sealing compound shall be performed with the equipment recommended and in strict accordance with the manufacturer's instructions. The entire cost of rubber joint compounds shall be included in the unit contract price bid for "Reinforced Concrete Deck Slab."

STRUCTURE DRAINAGE SYSTEM (SPECIAL)

Materials

Ductile iron pipe (D.I.P) drains shall be as detailed and specified on the Plans. Perforated pipe drains behind the abutments shall be corrugated steel pipe as detailed on the Plans. French drain material behind abutments shall be No. 467M crushed stone or gravel conforming to Table 1005-1, Aggregate Gradation.

Installation

Deck drains shall be located as shown on the Plans. The D.I.P. drains shall be installed as detailed and specified on the Plans.

Perforated pipe drains behind the abutments shall be laid with perforations turned down and bedded on a layer of compacted impervious clay. The perforations shall be kept open and free from the clay bedding course, asphalt coating, or other material. The French drain material shall be placed concurrently with the backfill and shall be kept separate with a thin timber slide or burlap bag. Perforated pipe behind abutments and outfall pipes shall be laid on a grade of at least one percent (1%) and shall be located as shown on the Plans.

Grades of pipe drains shall be set by the Engineer. Copies of shop drawings showing details of the drainage system shall be submitted by the Contractor to the Engineer for approval. The drainage system must be approved prior to fabrication.

Basis of Payment

Payment for the Structure Drainage System will be made at the contract lump sum price bid for "Structure Drainage System at Sta. _____". Such lump sum price shall be full compensation for furnishing all materials and labor to install the drainage system complete, including ductile iron pipe, deck drains, fittings, excavation, perforated pipe drains, French drain material, other backfill and outfall pipes.

BACKFILLING AROUND STRUCTURES **(SPECIAL)**

Backfill material behind abutments (except No. 467M crushed stone or gravel for French drains over perforated drain pipes) shall be Type A Aggregate Base Course (ABC) in accordance with the Standard Specifications. Placing and compacting shall be as provided for in Section 410-8 of the Standard Specifications.

Backfill around structures, except as specified above, shall be suitable material available from the excavations. In the event material excavated is not approved for use as backfill by the Engineer, the Contractor will be required to furnish and haul to the structure site the necessary suitable backfill material. Placing and compacting shall be as provided in Section 410-8 of the Standard Specifications.

Disposal of surplus excavated material shall be as specified in Section 410-1 of the Standard Specifications.

Payment for furnishing ABC backfill material and any suitable material to replace excavated material and for placing and compacting all backfill material shall be included in the contract unit price for the several other pay items.

SELF-LUBRICATING EXPANSION BEARING ASSEMBLIES (SPECIAL)

Description

The self-lubricating expansion bearing assemblies each consist of an oilless self-lubricating copper alloy plate, a sole plate, a sliding plate with keeper bars, a masonry plate, any necessary fill plates, a bearing pad, an anchor bolt assembly which includes anchor bolts, nuts, and washers, pipe sleeves, a closure plate, grout, various sizes of standard pipe, and any other necessary material as detailed on the Plans. These bearing assemblies are located at the expansion ends of applicable spans as shown on the Plans.

Requirements

Use self-lubricating copper alloy bearing plates that are an approved article of standard production by an established manufacturer of such equipment installed in accordance with the manufacturer's recommendations and conforming to the following requirements:

- Copper alloy conforming to AASHTO M107 Alloy 911 or AASHTO M108 Alloy 510.
- Lubricant of the solid type and consisting of graphite, metallic substances having lubricating properties and a lubricating binder. Do not use materials without lubricating qualities or that promote chemical or electrolytic reactions. Use lubricant that is integrally molded and compressed into the lubrication recesses to form a dense, non-plastic lubricant.
- Recesses arranged in a geometric pattern so that successive rows overlap in the direction of motion and the distance between extremities of recesses is closer in the direction of motion than that perpendicular to motion. Lubricate the entire bearing area of all surfaces that have provision for motion by means of these lubricant filled recesses. Provide a total area of these recesses between 25% and 35% of the total bearing area of the plate.
- Furnish bearing plates in sizes specified on the drawings. Machine finish the bearing surfaces and make sure that the surface roughness does not exceed 125 micro inches (3.18 microns) when measured in accordance with ASA Standard B46.1-1955. Also finish the bearing surfaces of the opposing steel plates as above. Align the tool marks in the direction of motion. Finish the bearing surfaces so that all machine surfaces are flat within 0.0005 inch per inch of length and width.
- For mating curved surfaces of steel and copper alloy, the maximum positive tolerance for the concave surface is 0.010 inch and the maximum negative tolerance for the convex surface is 0.010 inch.
- The coefficient of friction between the copper alloy self-lubricating plates and the steel plates in contact with them does not exceed 0.10 when subjected to the designed unit loading and at twice the designed unit loading.

Basis of Payment

Payment for the bearing assemblies will be at the contract lump sum price bid for "Self-lubricating Expansion Bearing Assemblies." Such lump sum price will be full compensation for all materials, tools, equipment, labor and incidentals necessary to furnish and install the self-lubricating bearing assemblies.

Payment for the Fixed Bearing Assemblies as shown on the Plans will be included in the lump sum price bid for "Approx. _____ Lbs. Structural Steel".

CONDUIT IN PARAPETS **(SPECIAL)**

Conduit in the parapets shall be 4" diameter PVC conduit conforming to applicable Underwriters Laboratory specifications and shall be located as shown on the Plans. Provisions shall be made for expansion between the deck slab and abutment backwalls and between deck slabs at expansion joints. Couplings shall be provided behind backwalls for connection to the 4" diameter rigid pipe. If non-PVC fittings, couplings, or other incidental items are required, they must be fully compatible with PVC conduit. Details and material data shall be submitted by the Contractor to the Engineer for approval by the Railway Company of all materials required for this work. The entire cost of furnishing and installing all conduit, expansion fittings, couplings and incidental items required for this work shall be included in the unit contract price bid for "Concrete Parapet".

CONCRETE PARAPET **(SPECIAL)**

Concrete Parapet shall be as shown on the plans and shall comply with Section 460 of the Standard Specifications. The quantity of concrete parapet to be paid for will be measured and paid as the number of linear feet of concrete parapet provided in the plans. Full compensation for the work shall include, but is not limited to, falsework and formwork, concrete, reinforcing steel, admixtures, all other materials and placing, finishing and curing the concrete. The quantity of concrete parapet as measured above will be paid for at the contract unit price per linear foot for "Concrete Parapet".

METAL RAIL (ALUMINUM) **(SPECIAL)**

The Metal Handrail shall be as shown on the Plans. The quantity of handrail to be paid for will be the actual number of linear feet of handrail measured continuously along the top bar of the rail from end to end which has been completed and accepted. Full compensation for the work shall include, but is not limited to, furnishing posts, rails, fittings and all other materials and fabricating and erecting the metal rail. The quantity of metal rail as measured above will be paid for at the contract unit price per linear foot for "Metal Rail (Aluminum)".

STRUCTURAL STEEL **(SPECIAL)**

I. STRUCTURAL STEEL

A. Scope

This Special Provision shall cover the furnishing, fabrication, preparation, assembly, welding, painting, and erection of all structural steel shown on the Plans.

B. General Specifications

1. Except as otherwise specified hereinafter, the current AREMA Specifications, Chapter 15, Steel Structures, apply to all work under this section.

C. Structural Steel

1. Fracture Critical Members

a. All fracture critical members are identified on the Plans.

b. All fracture critical members will be fabricated in accordance with the Fracture Control Plan stated in the AREMA Specifications, Chapter 15, Section 1.14.

c. Fabricator shall be certified under the AISC Quality Certification Program as follows:

Welded Plate Girders Category III
Rolled Beam Bridges Category I.

d. Structural steel shall meet the current requirements of the ASTM Specifications for Structural Steel, Designation A-709, Grade 50, S84-F2, S91, S93.

S84-F2	(Fracture Critical – Charpy Test Zone 2)
S91	(Fine Austenitic Grain Size)
S93	(Limitation on Weld Repairs)

Except as noted in the AREMA Fracture Control Plan.

2. Non-Fracture Critical Members

a. All primary members or components requiring improved notch toughness are identified on the Plans.

b. Fabricator shall be certified under the AISC Quality Certification Program as follows:

Welded Plate Girders	Category III
Rolled Beam Bridges	Category I

c. Structural steel shapes and plates used as primary members or components shall meet the current requirements of the ASTM Specifications for Structural Steel, Designation A-709, Grade 50, S83-T2, S91.

S83-T2	(Non-Fracture Critical – Charpy Test Zone 2)
S91	(Fine Austenitic Grain Size)

3. Other Structural Steel

a. It is preferred that the Fabricator be certified under the AISC Quality Certification Program, Category I.

b. All structural steel shall meet the current requirements of the Specification for ASTM Designation A-709, Grade 50, unless specified otherwise in this Special Provision or on the Plans.

D. Other Materials

1. High strength bolts shall meet the current requirements of the ASTM Specifications for High Strength Bolts for Structural Steel Joints, Designation A 325.

2. Anchor bolts shall be threaded rods with heavy hex nut meeting the current requirements of ASTM specification for fasteners, Designation A-449.

3. Welding electrodes for arc welding shall meet the current requirements of the Specifications for mild steel arc-welding electrodes Series E70, AWS 5.1, Low Hydrogen Classification for SMAW and AWS 5.17 for SAW.

4. Preformed fabric bearing pads shall be Shock Pad Style No. 15175 as manufactured by Alert Manufacturing and Supply Company, Chicago, Illinois, or FABREEKA Pads as manufactured by Fabreeka Products Company, 1190 Adams Street, Boston, Massachusetts, or SORBTREX Pads as manufactured by Voss Engineering, Inc., Chicago, Illinois, or approved equal.

E. Welding Processes

Only submerged arc welding (SAW) or shielded metal arc welding (SMAW) may be used. No other process will be allowed.

F. Bolted Connections

Permanent bolted connections using High Strength Bolts shall be installed and tightened using the Turn-of-the-Nut Method.

G. Paint

All steel preparation and painting shall be in accordance with the Special Provision PAINTING STRUCTURAL STEEL.

H. Shop Drawings

1. The Contractor's attention is called to the requirements for shop drawings, Chapter 15, Article 1.1.3 Shop Drawings, AREMA Specifications.

2. The Contractor's shall furnish three (3) complete sets of detailed shop drawings to the Company for approval prior to starting fabrication. Unchecked drawings shall not be submitted for approval. After approval of shop drawings, the Contractor shall supply the Company with one set of reproducibles of the approved drawings.

3. The rejection of or the procedure for the correction of shop drawings will not be considered as cause for delay.

4. Approval by the Engineer of the shop drawings shall not relieve the Contractor from furnishing material of proper dimensions, quantity, and quality, nor will such approval relieve the Contractor from the responsibility for errors of any sort in the shop drawings.

5. Original drawings or photographic reproducibles on mylar, or equivalent film, shall be furnished at the completion of the Contract in accordance with Chapter 15, Article 1.1.3, AREMA Specifications. Reproducibles made by the diazo process are not acceptable. The plans shall be sent to:

Chief Engineer – Bridges & Structures
Norfolk Southern Corporation
99 Spring Street, SW, Box 142
Atlanta, GA 30303

II. SHOP INSPECTION & TESTING

1. The Company may arrange for inspection by an independent inspection firm under a separate contract. This inspection will be in addition to the Fabricator's Quality Control Program.

2. The Fabricator shall notify the Company and it's inspector of the scheduled date for beginning fabrication and shall not begin fabrication until the Company's Inspector is present.

3. The Fabricator shall furnish copies of certified mill inspection reports to the Company for all structural steel requiring improved notch toughness.

4. The Fabricator shall meet the requirements of the AREMA Fracture Control Plan described in Chapter 15, Section 1.14 for all members and components designated as fracture critical.

5. Welding Inspection shall verify that all welds and welding procedures meet the requirements of the American Welding Society (A.W.S.) Bridge Welding Code, D1.5, current edition.

6. All welds shall be inspected visually and by use of nondestructive testing. All nondestructive testing shall be performed by the Fabricator and witnessed by the Company's Inspector.

7. Witnessing of weld inspection shall be done in a timely manner without disruption of normal shop operations. Copies of all weld inspections and nondestructive testing reports shall be furnished to the Company.

8. The Fabricator shall perform the following weld inspection and testing:

   (a) All transverse tension groove welds in FCM members, when allowed by the Engineer, shall be RT and UT tested 100%. In non-FCM components of FCM's all transverse groove welds shall be RT or UT tested 100%.

   (b) All flange to web welds shall be tested on both sides as follows:

      1. Top flange to web welds will be UT tested 100% over 10% of the length from each end and the remaining length of weld will be UT tested 10%.

      2. Bottom flange to web welds will be UT 100%.

   (c) All flange to web fillet welds, when allowed by the Engineer, are to be magnetic particle tested 100%.

   Ten percent (10%) of all welds not mentioned above shall be magnetic particle tested.

III. MEASUREMENT AND PAYMENT

Payment will be made at the contract lump sum price for the bid item "Approx. _____ Lbs. Structural Steel" and shall constitute full payment for all costs of plant, superintendent, labor, material, and equipment necessary to furnish, fabricate, shop paint, and shop assemble and deliver all the structural steel required for the project in accordance with the Plans, Specifications, and Special Provisions, including furnishing the fabric bearing pads, the fixed bearing assemblies and anchor bolts.

PAINTING STRUCTURAL STEEL **(SPECIAL)**

Plans and Specifications

This work consists of furnishing all labor, material, plant and equipment, and performing all operations in connection with Shop Painting (prime coat, wash coat, and top coat applied in the fabricators plant or unless otherwise specified by the Railway). All painting shall be in accordance with AREMA Specifications, Chapter 15, Section 3.4, and recommendations of the Steel Painting Council Specifications with the following specific requirements.

The paint thickness will be measured according to "SSPC-PA2" Method for Measurement of Dry Paint Thickness with Magnetic Gages.

In addition to the requirements specified herein, all structural steel shall receive a stripe coat of paint per the Standard Specifications.

Surface Preparation

The surface preparation shall be in accordance with Steel Structures Painting Council Specifications SP 10 (NEAR WHITE BLAST) latest revision and Visual Standard NACE No. 2. Average surface profile to be 2 mils.

Application: The paint shall be applied in accordance with SSPC Specifications for Paint Application – PA1.

The Prime Coat shall be applied in the shop promptly after blast cleaning, but in no case shall the Prime Coat be applied more than 8 hours after blast cleaning or after visible or detrimental rusting occurs.

Steel shall be cleaned by washing or other mechanical means to remove all residue (loose zinc dust and foreign matter) prior to applying Wash and Top Coat.

Surfaces damaged during shipment and handling shall be repaired using the same paint system as applied in the shop except that the Prime Coat shall be repaired using an ***Organic Zinc Primer*** when the Prime Coat is repaired in the field.

Welded Areas and Faying (Contact) Surfaces

No paint shall be applied to areas to be welded in the field. No acrylic paint (wash or top coat) shall be applied to any faying surfaces.

Paint Systems

The fabricator will be given the option of using one of the following paint systems ***(Prime Coat, Intermediate and Top Coats shall be applied in the fabricator's plant unless otherwise specified by the Railway)***. If the Intermediate Coat and Top Coat are applied in the field, the

steel shall be solvent wiped to remove all grease and oil and a ***"High Pressure Power Washing" with clean water (3500 psi minimum)*** shall be used to clean all mud and dirt off prior to applying the touch-up Primer or Intermediate and Top Coats. The Chief Engineer Bridges and Structures is to be notified of the fabricator's choice. Priming of the contact surfaces with ***Inorganic Zinc-Rich Primer*** is required.

If approved or further specified by the Railway, the Wash Coat and Top Coat shall be applied in the shop. Intermediate Coat color shall be White and Stripe Coat color shall be Light Gray. Top Coat color shall be Light Gray, Paint Code: 26306 (Federal Standard 595B).

SYSTEM #1 (DAVIS-FROST)

Prime Coat: P-139 LOW V.O.C. Inorganic Zinc Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Intermediate Coat: W-112 Water Guard Metal Primer applied at 3.0 – 4.0 mils Dry Film Thickness.

Finish (Top) Coat: W-195 Water-Tuff DTM Finish applied at 3.0 – 4.0 mils Dry Film Thickness.

Touch Up Primer: P-281 (3 component) Epoxy Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Suggested Supplier: Davis-Frost, Inc.
P.O. Box 11405
Lynchburg, VA 24506
Telephone: (804) 846-5277

SYSTEM #2 (ELITE)

Prime coat: Elite 1312 Inorganic Zinc Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Intermediate Coat: Elite 156 Exterior Acrylic Latex applied at 3.0 – 4.0 mils Dry Film Thickness.

Finish (Top) Coat: Elite 156 Exterior Acrylic Latex applied at 3.0 – 4.0 mils Dry Film Thickness.

Touch Up Primer: Elite 305 Organic Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Suggested Supplier: Elite Coatings Company, Inc.
P.O. Box 130
Gordon, GA 31031
Telephone: (912) 628-2111

SYSTEM #3 (DEVOE)

Prime Coat: Cata-Coat 301 Inorganic Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Intermediate Coat: DEVRAN 646 Water Based Epoxy primer applied at 3.0 – 4.0 mils Dry Film Thickness.

Finish (Top) Coat: DEVFLEX 604-S-9903 Water Based Gloss Enamel applied at 3.0 – 4.0 mils Dry Film Thickness.

Touch Up Primer: Cata-Coat 303H Organic Zinc-Rich Epoxy applied at 4.0 – 5.0 mils Dry Film Thickness.

Suggested Supplier: Devoe Coatings Company
1519 West Liberty Avenue
Pittsburgh, PA 15226
Telephone: (412) 561-8930
Attn: Joe Basile

SYSTEM #4 (SHERWIN-WILLIAMS)

Prime Coat: ZINC CLAD II HS-(B69VZ1 B69VZ3 B69D11) Inorganic Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness

Intermediate Coat: B66 Series DTM ACRYLIC GLOSS applied at 3.0 – 4.0 mils Dry Film Thickness.

Finish (Top) Coat: B66 Series DTM ACRYLIC GLOSS applied at 3.0 – 4.0 mils Dry Film Thickness.

Touch Up Primer: ZINC CLAD IV-(B69 A8/B69 V8) applied at 4.0 – 5.0 mils Dry Film Thickness.

Suggested Supplier: The Sherwin-Williams Company
765 North Avenue, NE
Atlanta, GA 30306
Telephone: (404) 873-6723

SYSTEM #5 (VALSPAR)

Prime Coat: Valspar MZ-7 Inorganic Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Intermediate Coat: #61 Series Water-Acrylic Lo Sheen applied at 3.0 – 4.0 mils Dry Film Thickness.

Finish (Top) Coat: #61 Series Water-Acrylic Lo Sheen applied at 3.0 – 4.0 mils Dry Film Thickness.

Touch Up Primer: MZ-4 Epoxy Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Suggested Supplier: Corrosion Specialties, Inc.
3897 Stephens Court
P.O. Box 146
Tucker, GA 30085-0146
Telephone: (404) 938-7263
Attn: Andy Steinmann

SYSTEM #6 (AMERON)

Prime Coat: Amercoat 21-5 Inorganic Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Intermediate Coat: Amercoat 148 Waterborne Acrylic primer applied at 3.0 – 4.0 mils Dry Film Thickness.

Finish (Top) Coat: Amercoat 220 Waterborne Acrylic applied at 3.0 – 4.0 mils Dry Film Thickness.

Touch Up Primer: Amercoat 68HS Zinc-Rich Primer applied at 4.0 – 5.0 mils Dry Film Thickness.

Suggested Supplier: Ameron Protective Coatings Division
11605 Vimy Ridge Road
Little Rock, AK 72209
Telephone: 1-800-283-6627

Post-Painting Requirements

a) Steel shall be cleaned by washing or other mechanical means to remove all residue (loose zinc dust and foreign matter) prior to applying Wash and Top Coat. An ***"M.E.K. Rub Test"*** shall be used to assure proper cure of the inorganic zinc primer prior to applying the next coat.
b) **The Intermediate Coat may have to be thinned to prevent gassing.**

Painting Materials Requirements

a) Packaging and Shipping.

All paint shall be received at the point of use in original containers and carefully stored. All paint to be used shall be freshly mixed and shall be ordered only a sufficient length of time in advance of its use to insure an adequate supply being on hand at all times so as not to delay the work.

Paint shipped to the job shall arrive in sealed containers clearly marked with the type of paint and specifications controlling its manufacture.

There shall be no modification of the paint except upon, and in accordance with, express written stipulation by an authorized representative of the paint manufacturer and with specific approval of the Engineer.

b) Storage.

Paint in storage at the shop or in the field shall have the position of the containers reversed at least once a week to prevent settlement and separation of the pigment from the vehicle. There shall be suitable devices maintained at the point of storage and used for agitation and thorough mixing of the paint prior to its use on this work.

c) Sample Panel.

If directed by the Engineer, a sample panel shall be made up. The panel shall be used as a basis of comparison of the work on this contract. The panel shall be of size designated by the Engineer and shall be prepared and painted in all respects in the same manner as the work will be done.

Workmanship

a) Weather Conditions.

Paint shall not be applied when the temperature of the air is less than 40 degrees F, the surface of the metal is not dry, the relative humidity is above 85%, or when, in the opinion of the Engineer, conditions are otherwise unsatisfactory for such work. Paint shall not be applied upon damp or frosted surfaces. Material painted under cover in damp or cold

weather shall remain under cover until dry or until weather conditions permit its exposure in the open. Painting shall not be done when the metal is hot enough to cause the paint to blister and produce a porous paint film.

b) Application.

Paint shall be applied in accordance with SSPC Specifications for Paint Application-PA1 and in accordance with manufacturer's recommendations.

All blast cleaned steel surfaces shall be primed before completion of the work day.

Steel shall be cleaned by washing, brushing or other mechanical means of all residue (loose foreign matter) prior to applying the finish coat (Top Coat)

c) Removal of Unsatisfactory Paint.

If the Prime Coat "mud-cracks", the Top Coat wrinkles or shows evidence of having been applied under unfavorable conditions, or if the workmanship is poor, the Engineer may order it removed and the metal thoroughly cleaned and repainted. Any "Blushing" of the Acrylic Top Coat shall be corrected by solvent wiping and/or recoating before final acceptance by the Railway Company.

d) Thinning.

No thinner shall be used if the paint can be applied in a neat workmanlike manner without thinning. If the paint is too thick to spray, only the manufacturer's specified thinner (in hot weather, acrylic paint shall be thinned with M.I.B.K. to reduce the chances of "Blushing" occurring) may be added to the paint up to 25% by volume or as otherwise specified by the manufacturer. Thinning shall not relieve the contractor from applying the specified coating Dry Film Thickness.

e) Paint Touch-Up.

After erection, all damaged areas shall be cleaned of mud and dirt by ***High Pressure Power Washing with clean water (3500 psi minimum)***; grease and oil by ***solvent wiping***; and rusted areas shall be cleaned by ***sand blasting*** or ***power tool cleaning*** with non-woven abrasives prior to touch-up or Top coating. The paint used for touch-up shall be the same system used in the shop. The contractor and/or fabricator shall be responsible for cleaning all damaged surfaces and applying all field touch-up coatings in accordance with all manufacturer's recommendations. The Zinc Primer shall be touched up with only ***Organic Zinc Primer*** when applied in the field.

f) Warranty.

The fabricator and/or contractor will be required to guarantee his work against defective workmanship or the use of defective materials for a period of one (1) year from completion of the contract.

g) Handling Shop Primed Steel.

Only nylon web slings or padded lifting points shall be used to move shop primed steel to prevent damage to the coating.

Air Quality Requirements

Abrasive blasting operations shall be conducted in full compliance with all current ***National primary and secondary ambient air quality standards 40 CFR 50*** (for Particulate matter – 40 CFR 50.6; Lead – 40 CFR 50.12; and nuisance dust). Abrasive blasting operations shall also be compliant with any and all local state and air quality requirements.

Environmental Protection Statement

"All collection, containment, disposal and transportation for disposal must be compliant with all applicable State, Federal and Local air pollution, water pollution, solid waste and hazardous waste regulations, ordinances or statutes."

Compensation

All work covered by this section except for shop painting will be paid for at the contract lump sum price for "Painting of Structural Steel." Payment at the contract lump sum price for "Approx. _____ Lbs. Structural Steel" will be full compensation for the work of shop painting.

The above prices and payments will be full compensation for all work including but not limited to furnishing all paint, cleaning abrasives, cleaning solvents, and all other materials; protecting the work; protecting traffic and property; preparing and cleaning surfaces to be painted; applying paint in the shop and field; and furnishing blast cleaning equipment, paint spraying equipment, brushes, rollers, and any other hand or power tools, and any other equipment.

METAL RAIL AND WALKWAY **(SPECIAL)**

The Metal Rail and Walkway shall be as shown on the Plans. The quantity of Metal Rail and Walkway to be paid for will be the actual number of linear feet of Metal Rail and Walkway measured continuously along the top bar of the metal rail from end to end which has been completed and accepted. Full compensation for the work shall include, but is not limited to, furnishing posts, rails, fittings and all other materials and fabricating and erecting the metal rail. The quantity of metal rail as measured above will be paid for at the contract unit price per linear foot for "Metal Rail and Walkway".

Payment for wingwall handrails shall be included in the contract unit price per linear foot for "Metal Rail and Walkway".

TIE ROD SYSTEM **(SPECIAL)**

The Tie Rod System shall be installed as shown on the plans. Tie Rods shall be 1 3/8" diameter, 150 ksi bar as manufactured by Williams Form Engineering Corp. or approved equal. Washers, walers and miscellaneous steel shall be ASTM A709, Grade 50. Tie rods and hex nuts shall be galvanized in accordance with ASTM A153 and ASTM A143. Mechanical cleaning shall be utilized in the galvanizing process for the tie rods and nuts. Washers, walers and miscellaneous steel shall be galvanized in accordance with ASTM A153.

The quantity of Tie Rods to be paid for will be the actual number of Tie Rods installed. Full compensation for the work shall include, but is not limited to, furnishing steel conduit, tie rods, walers, washers, nuts, hardware and all other materials, fabrication and erection of the tie rod system and all other incidentals necessary to complete the work as shown on the plans. The quantity of Tie Rods, measured as provided herein, will be paid for at the contract unit price per each for "Tie Rods".