
USACE / NAVFAC / AFCEA / NASA UFGS-03 31 29 (August 2012)

Preparing Activity: NAVFAC Superseding
UFGS-03 31 29 (February 2010)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated January 2013

SECTION TABLE OF CONTENTS

DIVISION 03 - CONCRETE

SECTION 03 31 29

MARINE CONCRETE

08/12

PART 1 GENERAL

- 1.1 REFERENCES
- 1.2 DEFINITIONS
- 1.3 SUBMITTALS
- 1.4 MODIFICATION OF REFERENCES
- 1.5 DELIVERY, PLACING, STORAGE, AND HANDLING OF CONCRETE
- 1.6 CONCRETE QUALITY CONTROL
 - 1.6.1 Quality Control Personnel
 - 1.6.1.1 Quality Manager Qualifications
 - 1.6.1.2 Field Testing Technician and Testing Agency
 - 1.6.2 Laboratory Qualifications for Concrete Qualification Testing
 - 1.6.3 Laboratory Accreditation
- 1.7 CONCRETE DURABILITY
 - 1.7.1 Concrete Mixture Proportions
 - 1.7.2 Concrete Design Requirements
 - 1.7.3 Concrete Mixture Qualifications
 - 1.7.3.1 Previously Approved Concrete Mixtures
 - 1.7.3.2 New Concrete Mixtures
 - 1.7.4 Project Environment
 - 1.7.4.1 Location Details
 - 1.7.4.2 Exposure Conditions by Element
 - 1.7.5 Concrete Qualification Program
 - 1.7.5.1 Fresh Concrete Properties
 - 1.7.5.2 Hardened Concrete Properties
 - 1.7.5.3 Reinforcing Steel Corrosion Properties
 - 1.7.5.4 Supplemental Corrosion Protection
 - 1.7.6 Mass Concrete Temperature Control Plans
- 1.8 CONCRETE
 - 1.8.1 Drawings
 - 1.8.1.1 Formwork
 - 1.8.1.2 Reinforcing Steel
 - 1.8.1.3 Precast Elements
 - 1.8.1.4 Joints
 - 1.8.2 Pre-Construction Submittals
 - 1.8.2.1 Curing Concrete Elements

- 1.8.2.2 Concrete Curing Plan
- 1.8.2.3 Form Removal Schedule
- 1.8.2.4 Concrete Placement and Compaction
- 1.8.2.5 Concrete Report
- 1.8.2.6 Coatings
- 1.8.2.7 Preconstruction Testing of Materials
- 1.8.2.8 Material Safety Data Sheets
- 1.8.2.9 Mixture Designs
- 1.8.3 Sampling
 - 1.8.3.1 Ingredient Material Sampling
- 1.8.4 Reporting
 - 1.8.4.1 Daily Inspection Reports
 - 1.8.4.2 Sampling Logs
 - 1.8.4.3 Quality Control Data
 - 1.8.4.4 Quality Team Meetings
 - 1.8.4.5 Non-conforming materials
- 1.8.5 Test Reports
 - 1.8.5.1 Concrete Mixture Requirements
 - 1.8.5.2 Complementary Cementing Materials
 - 1.8.5.2.1 Ground Granulated Blast-Furnace Slag
 - 1.8.5.2.2 Ultra Fine Fly Ash or Pozzolan
 - 1.8.5.3 Silica Fume
 - 1.8.5.4 Aggregates
 - 1.8.5.5 Admixtures
 - 1.8.5.6 Portland Cement
 - 1.8.5.7 Testing During Construction
 - 1.8.5.8 Test Section
 - 1.8.5.9 Acceptability of Work

PART 2 PRODUCTS

- 2.1 CEMENTITIOUS MATERIALS
 - 2.1.1 Portland Cement
 - 2.1.2 Blended Cements
 - 2.1.3 Pozzolan
 - 2.1.3.1 Fly Ash
 - 2.1.3.2 Raw or Calcined Natural Pozzolan
 - 2.1.3.3 Ultra Fine Fly Ash and Ultra Fine Pozzolan
 - 2.1.4 Ground Granulated Blast-Furnace (GGBF) Slag
 - 2.1.5 Silica Fume
 - 2.1.6 Complementary Cementing Materials (AKA Supplementary Cementitious Materials (SCM) Content (SCM))
- 2.2 AGGREGATES
- 2.3 WATER
- 2.4 ADMIXTURES
 - 2.4.1 Air Entraining
 - 2.4.2 Accelerating
 - 2.4.3 Retarding
 - 2.4.4 Water Reducing
 - 2.4.5 Corrosion Inhibitors
- 2.5 NON-SHRINK GROUT
- 2.6 MATERIALS FOR FORMS
 - 2.6.1 Form Ties and Form-Facing Material
- 2.7 REINFORCEMENT
 - 2.7.1 Prestressing Steel
 - 2.7.2 Reinforcing Bars
 - 2.7.2.1 Reinforcement and Protective Coating
 - 2.7.3 Mechanical Reinforcing Bar Connectors
 - 2.7.4 Welded Wire Fabric

- 2.7.5 Wire
- 2.8 ACCESSORY MATERIALS
 - 2.8.1 Polyvinylchloride Waterstops
 - 2.8.2 Materials for Curing Concrete
 - 2.8.2.1 Impervious Sheeting
 - 2.8.2.2 Pervious Sheeting
 - 2.8.2.3 Liquid Membrane-Forming Compound
 - 2.8.3 Liquid Chemical Sealer-Hardener Compound
 - 2.8.4 Expansion/Contraction Joint Filler
 - 2.8.5 Joint Sealants
 - 2.8.5.1 Horizontal Surfaces
 - 2.8.5.2 Vertical Surfaces

PART 3 EXECUTION

- 3.1 FORMS
 - 3.1.1 Coating
 - 3.1.2 Removal of Forms and Supports
 - 3.1.2.1 Special Requirements for Reduced Time Period
 - 3.1.3 Reshoring
- 3.2 PLACING REINFORCEMENT AND MISCELLANEOUS MATERIALS
 - 3.2.1 Coated Reinforcing
 - 3.2.2 Reinforcement Supports
 - 3.2.3 Splicing
 - 3.2.4 Future Bonding
 - 3.2.5 Cover
 - 3.2.6 Setting Miscellaneous Material and Prestress Anchorages
 - 3.2.7 Construction Joints
 - 3.2.8 Expansion Joints and Contraction Joints
 - 3.2.9 Waterstop Splices
 - 3.2.10 Pits and Trenches
- 3.3 BATCHING, MEASURING, MIXING, AND TRANSPORTING CONCRETE
 - 3.3.1 Measuring
 - 3.3.2 Mixing
 - 3.3.3 Transporting
- 3.4 PLACING CONCRETE
 - 3.4.1 Vibration
 - 3.4.2 Cold Weather
 - 3.4.3 Hot Weather
 - 3.4.4 Prevention of Plastic Shrinkage Cracking
 - 3.4.5 Mass Concrete
 - 3.4.6 Depositing Concrete Under Water
- 3.5 SURFACE FINISHES EXCEPT FLOOR, SLAB, AND PAVEMENT
 - 3.5.1 Defects
 - 3.5.2 Formed Surfaces
 - 3.5.2.1 Tolerances
 - 3.5.2.2 As-Cast Rough Form
 - 3.5.2.3 As-Cast Form
- 3.6 FINISHES FOR HORIZONTAL CONCRETE SURFACES
 - 3.6.1 Finish
 - 3.6.1.1 Scratched
 - 3.6.1.2 Floated
 - 3.6.1.3 Broomed
 - 3.6.1.4 Pavement
 - 3.6.1.5 Concrete Toppings Placement
- 3.7 CURING AND PROTECTION
 - 3.7.1 Wet Curing
 - 3.7.1.1 Ponding or Immersion
 - 3.7.1.2 Fog Spraying or Sprinkling

- 3.7.1.3 Pervious Sheeting
- 3.7.1.4 Impervious Sheeting
- 3.7.2 Liquid Membrane-Forming Curing Compound
 - 3.7.2.1 Application
 - 3.7.2.2 Protection of Treated Surfaces
- 3.7.3 Liquid Chemical Sealer-Hardener
- 3.7.4 Curing Periods
- 3.8 FIELD QUALITY CONTROL
 - 3.8.1 Fresh Concrete Properties
 - 3.8.1.1 Slump Tests
 - 3.8.1.2 Temperature Tests
 - 3.8.1.3 Air Content Tests
 - 3.8.1.4 Unit Weight Test
 - 3.8.2 Hardened Concrete Properties
 - 3.8.2.1 Compressive Strength Tests
 - 3.8.2.2 Transport Property Tests
 - 3.8.2.3 Chloride Ion Concentration
 - 3.8.2.4 Anti-Washout Admixture
 - 3.8.2.5 Non-Destructive Tests
 - 3.8.3 Core Samples and Compressive Strength Testing
 - 3.8.4 Acceptance of Concrete Strength
 - 3.8.4.1 Standard Molded and Cured Strength Specimens
 - 3.8.4.2 Non-Destructive Tests
 - 3.8.4.3 Extracted Core Tests
 - 3.8.5 Inspection
- 3.9 REPAIR, REHABILITATION AND REMOVAL
 - 3.9.1 Crack Repair
 - 3.9.2 Repair of Weak Surfaces
 - 3.9.3 Failure of Quality Assurance Test Results

-- End of Section Table of Contents --

USACE / NAVFAC / AFCESA / NASA UFGS-03 31 29 (August 2012)

Preparing Activity: NAVFAC Superseding
UFGS-03 31 29 (February 2010)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated January 2013

SECTION 03 31 29

MARINE CONCRETE
08/12

NOTE: This guide specification covers the requirements for reinforced concrete exposed to marine and chloride environments for projects with a defined service life. This approach mandates that the owner define the service life expectations of the structure (in years) prior to design. This document is a combination of prescriptive and performance based specifications. It contains specific requirements for quality control (actions taken by the contractor) and quality assurance (actions that may be taken by the owner). The performance based portion of this document includes requirements to predict the service life of the candidate concrete mixtures prior to proceeding with construction. During construction, concrete cylinders are made from the production concrete at intervals specified by the engineer of record to measure transport properties and for microscopic examination of the hardened concrete to verify that the concrete quality remains consistent and acceptable. Conventional requirements for compressive strength and slump remain the same. Service life modeling software is a tool that, when used in combination with other tools and good engineering judgment, enhances the Contractor's and Owner's confidence that the completed structure will perform for the defined service life. The only acceptable service life modeling tool is STADIUM[®]. STADIUM[®] is proprietary and a justification and approval (J&A) is required. A class J&A for other than full and open competition is on file at NAVFAC Headquarters, which allows for the use of this propriety software to predict the potential for the concrete mixture to deliver the service life if the Contractor properly executes placement and curing. TR-NAVFAC ESC-CI-1215, the "Navy User's Guide to Quality Assurance of New Concrete Construction" provides a commentary for the user of this methodology. Generally, this version of the marine concrete UFGS is for major projects. For smaller marine concrete projects and for projects without a

defined service life an alternate version of this UFGS is available that excludes service life modeling requirements and testing for transport properties during construction.

Adhere to [UFC 1-300-02](#) Unified Facilities Guide Specifications (UFGS) Format Standard when editing this guide specification or preparing new project specification sections. Edit this guide specification for project specific requirements by adding, deleting, or revising text. For bracketed items, choose applicable items(s) or insert appropriate information.

Remove information and requirements not required in respective project, whether or not brackets are present.

Comments, suggestions and recommended changes for this guide specification are welcome and should be submitted as a [Criteria Change Request \(CCR\)](#).

NOTE: Development team of this section considered the International Green Construction Code, which is "the first model code that includes sustainability measures for the entire construction project and its site - from design through construction, certificate of occupancy and beyond. The new code is expected to make buildings more efficient, reduce waste, and have a positive impact on health, safety and community welfare."

<http://www.iccsafe.org/cs/igcc/pages/default.aspx>

NOTE: The following information shall be shown on the project drawings:

1. Loading assumptions.
2. Assumed temperature range when temperature stresses are a factor in design.
3. Material strengths used in design, f'c.
4. Yield strength of reinforcement required (414 mPa 60,000 psi or other grade as available).
5. Details of concrete sections, showing dimensions, reinforcement cover, and required camber.
6. Joint details, showing locations and dimensions.
7. Details and locations of critical construction joints, including water stop locations and splices, keys, and dowels when required, and location of fiber-reinforced concrete elements.

PART 1 GENERAL

1.1 REFERENCES

NOTE: This paragraph is used to list the publications cited in the text of the guide specification. The publications are referred to in the text by basic designation only and listed in this paragraph by organization, designation, date, and title.

Use the Reference Wizard's Check Reference feature when you add a RID outside of the Section's Reference Article to automatically place the reference in the Reference Article. Also use the Reference Wizard's Check Reference feature to update the issue dates.

References not used in the text will automatically be deleted from this section of the project specification when you choose to reconcile references in the publish print process.

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

AMERICAN ASSOCIATION OF STATE HIGHWAY AND TRANSPORTATION OFFICIALS (AASHTO)

AASHTO M 182 (2005; R 2009) Standard Specification for Burlap Cloth Made from Jute or Kenaf and Cotton Mats

AMERICAN CONCRETE INSTITUTE INTERNATIONAL (ACI)

ACI 117 (2010; Errata 2011) Specifications for Tolerances for Concrete Construction and Materials and Commentary

ACI 121R (2008) Guide for Concrete Construction Quality Systems in Conformance with ISO 9001

ACI 201.2R (2008) Guide to Durable Concrete

ACI 211.1 (1991; R 2009) Standard Practice for Selecting Proportions for Normal, Heavyweight and Mass Concrete

ACI 214R (2011) Evaluation of Strength Test Results of Concrete

ACI 301 (2010; Errata 2011) Specifications for Structural Concrete

ACI 301M	(2010) Metric Specifications for Structural Concrete
ACI 304.2R	(1996; R 2008) Placing Concrete by Pumping Methods
ACI 304R	(2000; R 2009) Guide for Measuring, Mixing, Transporting, and Placing Concrete
ACI 305R	(2010) Guide to Hot Weather Concreting
ACI 306R	(2010) Guide to Cold Weather Concreting
ACI 308.1	(2011) Specification for Curing Concrete
ACI 309R	(2005) Guide for Consolidation of Concrete
ACI 311.4R	(2005) Guide for Concrete Inspection
ACI 318	(2011; Errata 2011; Errata 2012) Building Code Requirements for Structural Concrete and Commentary
ACI 318M	(2011; Errata 2011; Errata 2012) Building Code Requirements for Structural Concrete & Commentary
ACI 347	(2004; Errata 2008; Errata 2012) Guide to Formwork for Concrete
ACI 364.3R	(2009) Guide for Cementitious Repair Material Data Sheet
ACI SP-15	(2011) Field Reference Manual: Standard Specifications for Structural Concrete ACI 301-05 with Selected ACI References
ACI SP-2	(2007; Abstract: 10th Edition) ACI Manual of Concrete Inspection
ACI SP-66	(2004) ACI Detailing Manual
AMERICAN WELDING SOCIETY (AWS)	
AWS D1.4/D1.4M	(2011) Structural Welding Code - Reinforcing Steel
APA - THE ENGINEERED WOOD ASSOCIATION (APA)	
APA PS 1	(2009) Structural Plywood (with Typical APA Trademarks)
ASTM INTERNATIONAL (ASTM)	
ASTM A1035/A1035M	(2011) Standard Specification for Deformed and Plain, Low-carbon, Chromium, Steel Bars for Concrete Reinforcement

ASTM A1055/A1055M	(2010; E 2011) Standard Specification for Zinc and Epoxy Dual Coated Steel Reinforcing Bars
ASTM A185/A185M	(2007) Standard Specification for Steel Welded Wire Reinforcement, Plain, for Concrete
ASTM A276	(2010) Standard Specification for Stainless Steel Bars and Shapes
ASTM A416/A416M	(2012) Standard Specification for Steel Strand, Uncoated Seven-Wire for Prestressed Concrete
ASTM A496/A496M	(2007) Standard Specification for Steel Wire, Deformed, for Concrete Reinforcement
ASTM A497/A497M	(2007) Standard Specification for Steel Welded Wire Reinforcement, Deformed, for Concrete
ASTM A615/A615M	(2012) Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement
ASTM A706/A706M	(2009b) Standard Specification for Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement
ASTM A767/A767M	(2009) Standard Specification for Zinc-Coated (Galvanized) Steel Bars for Concrete Reinforcement
ASTM A775/A775M	(2007b) Standard Specification for Epoxy-Coated Steel Reinforcing Bars
ASTM A82/A82M	(2007) Standard Specification for Steel Wire, Plain, for Concrete Reinforcement
ASTM A882/A882M	(2004a; R 2010) Standard Specification for Filled Epoxy-Coated Seven-Wire Prestressing Steel Strand
ASTM A886/A886M	(2010) Standard Specification for Steel Strand, Indented, Seven-Wire Stress-Relieved for Prestressed Concrete
ASTM A934/A934M	(2007) Standard Specification for Epoxy-Coated Prefabricated Steel Reinforcing Bars
ASTM A955/A955M	(2012; E 2012) Standard Specification for Deformed and Plain Stainless-Steel Bars for Concrete Reinforcement
ASTM C1017/C1017M	(2007) Standard Specification for Chemical Admixtures for Use in Producing Flowing Concrete

ASTM C1064/C1064M	(2011) Standard Test Method for Temperature of Freshly Mixed Hydraulic-Cement Concrete
ASTM C1074	(2011) Standard Practice for Estimating Concrete Strength by the Maturity Method
ASTM C1077	(2011c) Standard Practice for Laboratories Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Laboratory Evaluation
ASTM C1107/C1107M	(2011) Standard Specification for Packaged Dry, Hydraulic-Cement Grout (Nonshrink)
ASTM C1152/C1152M	(2004; E 2006) Standard Test Method for Acid-Soluble Chloride in Mortar and Concrete
ASTM C1157/C1157M	(2011) Standard Specification for Hydraulic Cement
ASTM C1202	(2012) Standard Test Method for Electrical Indication of Concrete's Ability to Resist Chloride Ion Penetration
ASTM C1218/C1218M	(1999; R 2008) Standard Specification for Water-Soluble Chloride in Mortar and Concrete
ASTM C1231/C1231M	(2010a) Standard Practice for Use of Unbonded Caps in Determination of Compressive Strength of Hardened Concrete Cylinders
ASTM C1240	(2012) Standard Specification for Silica Fume Used in Cementitious Mixtures
ASTM C1260	(2007) Standard Test Method for Potential Alkali Reactivity of Aggregates (Mortar-Bar Method)
ASTM C138/C138M	(2012) Standard Test Method for Density ("Unit Weight"), Yield, and Air Content (Gravimetric) of Concrete
ASTM C143/C143M	(2010a) Standard Test Method for Slump of Hydraulic-Cement Concrete
ASTM C150/C150M	(2012) Standard Specification for Portland Cement
ASTM C1567	(2011) Standard Test Method for Potential Alkali-Silica Reactivity of Combinations of Cementitious Materials and Aggregate (Accelerated Mortar-Bar Method)
ASTM C157/C157M	(2008) Standard Test Method for Length

	Change of Hardened Hydraulic-Cement Mortar and Concrete
ASTM C1585	(2011) Standard Test Method for Measurement of Rate of Absorption of Water by Hydraulic-Cement Concretes
ASTM C1602/C1602M	(2012) Standard Specification for Mixing Water Used in Production of Hydraulic Cement Concrete
ASTM C1610/C1610M	(2010) Standard Test Method for Static Segregation of Self-Consolidating Concrete Using Column Technique
ASTM C1611/C1611M	(2009b; E 2010) Standard Test Method for Slump Flow of Self-Consolidating Concrete
ASTM C1621/C1621M	(2009b) Standard Test Method for Passing Ability of Self-Consolidating Concrete by J-Ring
ASTM C171	(2007) Standard Specification for Sheet Materials for Curing Concrete
ASTM C172/C172M	(2010) Standard Practice for Sampling Freshly Mixed Concrete
ASTM C173/C173M	(2010b) Standard Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method
ASTM C192/C192M	(2012) Standard Practice for Making and Curing Concrete Test Specimens in the Laboratory
ASTM C231/C231M	(2010) Standard Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method
ASTM C260/C260M	(2010a) Standard Specification for Air-Entraining Admixtures for Concrete
ASTM C294	(2012) Standard Descriptive Nomenclature for Constituents of Concrete Aggregates
ASTM C295/C295M	(2012) Petrographic Examination of Aggregates for Concrete
ASTM C309	(2011) Standard Specification for Liquid Membrane-Forming Compounds for Curing Concrete
ASTM C31/C31M	(2012) Standard Practice for Making and Curing Concrete Test Specimens in the Field
ASTM C311	(2011b) Sampling and Testing Fly Ash or Natural Pozzolans for Use as a Mineral Admixture in Portland-Cement Concrete

ASTM C33/C33M	(2011a) Standard Specification for Concrete Aggregates
ASTM C39/C39M	(2012) Standard Test Method for Compressive Strength of Cylindrical Concrete Specimens
ASTM C42/C42M	(2012) Standard Test Method for Obtaining and Testing Drilled Cores and Sawed Beams of Concrete
ASTM C469/C469M	(2010) Static Modulus of Elasticity and Poisson's Ratio of Concrete in Compression
ASTM C494/C494M	(2012) Standard Specification for Chemical Admixtures for Concrete
ASTM C496/C496M	(2011) Standard Test Method for Splitting Tensile Strength of Cylindrical Concrete Specimens
ASTM C595/C595M	(2012; E 2012) Standard Specification for Blended Hydraulic Cements
ASTM C618	(2012) Standard Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
ASTM C642	(2006) Density, Absorption, and Voids in Hardened Concrete
ASTM C666/C666M	(2003; R 2008) Resistance of Concrete to Rapid Freezing and Thawing
ASTM C78/C78M	(2010) Standard Test Method for Flexural Strength of Concrete (Using Simple Beam with Third-Point Loading)
ASTM C805/C805M	(2008) Rebound Number of Hardened Concrete
ASTM C856	(2011) Petrographic Examination of Hardened Concrete
ASTM C920	(2011) Standard Specification for Elastomeric Joint Sealants
ASTM C94/C94M	(2012) Standard Specification for Ready-Mixed Concrete
ASTM C989/C989M	(2012a) Standard Specification for Slag Cement for Use in Concrete and Mortars
ASTM D1179	(2010) Fluoride Ion in Water
ASTM D1751	(2004; R 2008) Standard Specification for Preformed Expansion Joint Filler for Concrete Paving and Structural Construction (Nonextruding and Resilient

Bituminous Types)

ASTM D1752	(2004a; R 2008) Standard Specification for Preformed Sponge Rubber Cork and Recycled PVC Expansion
ASTM D3867	(2009) Nitrite-Nitrate in Water
ASTM D512	(2012) Chloride Ion in Water
ASTM D516	(2011) Sulfate Ion in Water
ASTM D6690	(2007) Standard Specification for Joint and Crack Sealants, Hot Applied, for Concrete and Asphalt Pavements
ASTM D75/D75M	(2009) Standard Practice for Sampling Aggregates
ASTM E329	(2011c) Standard Specification for Agencies Engaged in the Testing and/or Inspection of Materials Used in Construction

CONCRETE REINFORCING STEEL INSTITUTE (CRSI)

CRSI 10MSP	(2009; 28th Ed) Manual of Standard Practice
------------	---

U.S. ARMY CORPS OF ENGINEERS (USACE)

COE CRD-C 39	(1981) Test Method for Coefficient of Linear Thermal Expansion of Concrete
COE CRD-C 572	(1974) Corps of Engineers Specifications for Polyvinylchloride Waterstops
COE CRD-C 61	(1989A) Test Method for Determining the Resistance of Freshly Mixed Concrete to Washing Out in Water

U.S. GENERAL SERVICES ADMINISTRATION (GSA)

FS SS-S-200	(Rev E; Am 1; Notice 1) Sealant, Joint, Two-Component, Jet-Blast-Resistant, Cold-Applied, for Portland Cement Concrete Pavement
-------------	---

U.S. NAVAL FACILITIES ENGINEERING COMMAND (NAVFAC)

TR-NAVFAC ESC-CI-1215	(2012) Navy User's Guide for Quality Assurance of New Concrete Construction
-----------------------	---

1.2 DEFINITIONS

- a. "Aging factor" is used to estimate the change in the ionic diffusion coefficient over time. The aging factor is defined as the ratio of the ultimate ionic diffusion coefficient (D_{oh}) to the 28-day D_{oh} .
- b. "Atmospheric zone" is any portion of the waterfront structure above the

splash zone.

- c. "Boundary Condition" is the environmental conditions in contact with the concrete. The service life modeling tool must account for short term and long-term changes in environmental conditions at the boundary interface between the specific concrete element and the environment, including wetting and drying due to daily tidal cycles and/or changes over its lifecycle.
- d. "Cementitious material" as used herein shall include portland cement and any pozzolanic material such as fly ash, natural pozzolans, ground granulated blast-furnace slag and silica fume.
- e. "Complementary cementing materials" (CCM) include coal fly ash, granulated blast-furnace slag, natural or calcined pozzolans, and ultra-fine coal ash when used in such proportions to replace the portland cement that result in considerable improvement to sustainability, durability and in some cases a reduction in initial cost.
- f. "Chloride threshold" (CTH) is the concentration of chloride ions in concrete that is generally assumed to be the minimum necessary to initiate corrosion of the reinforcing steel when all other necessary conditions are satisfied. The threshold value is expressed in parts per million (ppm) by mass of concrete.
- g. "Concrete System" is the term describing a structural element comprised of concrete, reinforcing steel and concrete cover.
- h. "Corrosion initiation period" (T_i) is the number of years assumed before the chloride ion reaches the chloride threshold for the reinforcing steel at the depth of the steel. The corrosion initiation period will be determined by STADIUM[®] software.
- i. "Corrosion Propagation period" (T_p) is the number of years after the corrosion initiation period before corrosion manifest as visible cracking and spalling of the concrete cover to a degree that will require extensive concrete repair. Based on evidence provided by the Contractor and reviewed by the agency's Subject Matter Expert in Concrete Materials, on a case-by-case basis the Contracting Officer may approve extension to the typical corrosion propagation period of 15 years. Use of supplemental corrosion protection methods and benign environmental conditions are two ways to extend the assumed propagation period.
- j. "Design strength" (f'_c) is the specified compressive strength of concrete at time(s) specified by Contracting Officer to meet structural design criteria. Typical duration is 28 days; however, the Contracting Officer and Engineer of Record are encouraged to consider specifying strength at 56 or 90 days. For high-volume fly ash concrete mixtures, the duration shall be a minimum of 56 days.
- k. "Effective Diffusion Coefficient" (D_{eff}) is a coefficient that combines the ionic diffusion coefficient D_{oh} and volume of permeable voids.
- l. "Exposure Conditions" are the environmental parameters used in service life modeling for each type of concrete element based on the structure location and anticipated boundary conditions.

- m. "Field test strength" (f_{cr}) is the required compressive strength of concrete to meet structural and durability criteria. Determine (f_{cr}) during mixture proportioning process.
- n. "High-volume fly ash concrete" has a minimum of 50 percent Class F fly ash as a partial replacement to portland cement.
- o. "Ionic Diffusion Coefficient" (D_{oh}) is the ionic diffusion coefficient as determined per the ionic diffusion coefficient migration testing for the service life modeling.
- p. "Marine concrete" is all concrete that will be in contact with seawater or brackish water, tidal variations, splash, or spray from water in navigable waterways. Piles driven on land that extend below the water table that contains saltwater or brackish water shall be designed as marine concrete. In addition, structures may need to be designed using these criteria even though they are not adjacent to the waterfront. For example, structures located several hundred yards from the waterfront often deteriorate prematurely due to salt spray and salt fog brought to the structure by prevailing winds. An assessment of existing structures near the construction site can be an excellent indicator for the Engineer of Record and Owner to decide if the proposed structure should follow the guidelines for marine concrete.
- q. "Mass Concrete" is any concrete system that approaches a maximum temperature of 70 degrees C 158 degrees F within the first 72 hours of placement. In addition, it includes all concrete elements with a section thickness of 1 meter 3 feet or more regardless of temperature.
- r. "Mixture proportioning" is the process of designing concrete mixture proportions to enable it to meet the strength, service life and constructability requirements and of the project while minimizing the initial and life-cycle cost.
- s. "Mixture proportions" are the masses or volumes of individual ingredients used to make a unit measure (cubic yard or meter) of concrete.
- t. "Moisture Transport Coefficient" (MTC) is the value determined per the moisture transport coefficient drying test.
- u. "Permeability" (K) is the intrinsic permeability of the concrete evaluated from the moisture transport coefficient drying test.
- v. "Pozzolan" is a siliceous or siliceous and aluminous material, which in itself possesses little or no cementitious value but will, in finely divided form and in the presence of moisture, chemically react with calcium hydroxide at ordinary temperatures to form compounds possessing cementitious properties.
- w. "Process control sampling" is sampling and testing conducted by the Contractor to monitor the quality of materials or processes. Process control sampling is intended to indicate the quality of materials at critical steps in production that allow intervention prior to using a material on the project.
- x. "Quality Acceptance Limit" (QAL) is the limiting value of a test result that indicates acceptable material quality. Quality acceptance limits are based on design criteria that may be either upper-bound limits

where smaller values indicate acceptable material, such as D_{oh} ; or lower-bound limits where larger values indicate acceptable material, such as compressive strength.

- y. "Quality acceptance sampling" is sampling and testing conducted by the Contractor, or an independent testing agency, to evaluate the quality of materials used on the project. Quality acceptance sampling is conducted at regular intervals identified as "lots" to represent the quality of that portion of the material used in the project.
- z. "Required compressive strength" (f'_{cr}) is the mean compressive strength of concrete required to meet structural criteria. The required strength is the mean concrete strength for tests of properly batched concrete at the age specified herein.
- aa. "Service life" is the Owner's stated expectation for the number of years that the structure will function without needing major concrete rehabilitation. A service life of 75 years for pile supported piers, wharves and bridges is a reasonable objective. Service life is defined as the number of years before major restoration is necessary given minimal maintenance to the structure during its life. Major restoration is defined as extensive areas that require extensive repairs using a jack hammer or other destructive means to prepare the concrete for rehabilitation. Service life is further defined as the summation of the corrosion initiation period (T_i) and the corrosion propagation period (T_p) for a given concrete system.
- bb. "Service Life Modeling" in the context of this document refers to a methodology using STADIUM[®] finite element software. It predicts the time before the chloride ion contamination will reach a level of reinforcing that is likely to result in the initiation of steel corrosion. It also predicts delayed ettringite reaction, sulfate attack and other chemical deterioration mechanisms.
- cc. "Specified Effective Diffusion Coefficient" (D_{spec}) is the calculated effective diffusion coefficient at which the chloride ion content is within 10 percent (50 ppm) of the chloride threshold, at the steel cover depth, for the given exposure.
- dd. "Splash zone" is the portion of the structure just above the tidal zone. This portion of the structure is predominantly dry, but is likely to intermittently wet by wave action and wind driven spray. For the purposes of this specification, the splash zone is defined as follows:
 - (1) for locations protected by seawalls or otherwise sheltered from open-ocean waves, the 2 meters 6 feet area just above the tidal zone;
 - (2) for unprotected locations, the 6 meters 20 feet area just above the tidal zone.
- ee. "Submerged zone" is defined as the submerged portion of the structure. For the purposes of this specification, any element or portion thereof that is located below Mean Lower Low Water (MLLW). In areas with minimal tides, it would be defined as that portion of the element below Mean Sea Level (MSL).
- ff. "Supplemental Corrosion Protection" includes (but not limited to)

fusion-bonded epoxy-coated steel reinforcing, galvanized steel reinforcing, stainless reinforcing, [corrosion inhibitors](#), barrier coatings to the concrete surface, and cathodic protection.

- gg. "Test Section" is a slab or wall separate from the main structure and constructed prior to main construction as an all inclusive demonstration of methods and materials. The adequacy of the Test Section must be approved by the owner's representative prior to construction of the project.
- hh. "Tidal zone" is defined as the portion of the structure regularly wetted by wave action. For the purposes of this specification, any element or portion thereof that is located between Mean Lower Low Water (MLLW) and Mean Higher High Water (MHHW) is in the tidal zone. In areas with minimal tides, this would be defined as the area located between Mean Sea Level (MSL) and Mean High Water (MHW).
- ii. "Tolerance Limit" is defined for each transport parameter as the characteristic value that will be surpassed in 1 of 10 batches, at a 90 percent confidence level. This definition is provided for reference only, additional documentation and evaluation is needed prior to it being suggested as prescriptive criteria.
- jj. "Transport properties" refers to the properties that characterize the rate of chloride penetration into a concrete element. These properties include: volume of permeable voids (ϕ), ionic diffusion coefficient (D_{oh}), aging factor, and moisture transport coefficient (MTC).
- kk. "Transport property testing" refers to the testing procedures that characterize the rate of chloride penetration into a concrete element. These properties are used as input data for the service life modeling.
- ll. "Volume of Permeable Voids" (ϕ) is the porosity of the concrete as determined by [ASTM C642](#).
- mm. "50 percent Saturation water content" (S50 percent) is the degree of saturation of the saturated concrete after being allowed to come to equilibrium at 50 percent relative humidity. It is defined as the volume of the water in the concrete at equilibrium divided by the volume of permeable voids (ϕ) as determined by [ASTM C642](#).

1.3 SUBMITTALS

NOTE: Review Submittal Description (SD) definitions in Section 01 33 00 SUBMITTAL PROCEDURES and edit the following list to reflect only the submittals required for the project.

The Guide Specification technical editors have designated those items that require Government approval, due to their complexity or criticality, with a "G". Generally, other submittal items can be reviewed by the Contractor's Quality Control System. Only add a "G" to an item, if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army

projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

Choose the first bracketed item for Navy, Air Force and NASA projects, or choose the second bracketed item for Army projects.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are for Contractor Quality Control approval. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government. The following shall be submitted in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-01 Preconstruction Submittals

Concrete Curing Plan

Concrete Qualification Program[; G][; G, [____]]

Concrete Quality Control Program[; G][; G, [____]]

Concrete Placement and Compaction

Concrete Pumping

[Curing concrete elements

] Form Removal Schedule

Laboratory Qualifications[; G][; G, [____]]

Quality Control Personnel Qualifications[; G][; G, [____]]

SD-02 Shop Drawings

Construction and expansion joints[; G][; G, [____]]

Formwork

Precast elements[; G][; G, [____]]

Reinforcing steel[; G][; G, [____]]

Reproductions of contract drawings are unacceptable.

SD-03 Product Data

Admixtures[; G][; G, [____]]

Air Entraining[; G][; G, [____]]
Aggregates[; G][; G, [____]]
Corrosion Inhibitors[; G][; G, [____]]
Joint filler
Joint sealants
Materials for curing concrete
Material Safety Data Sheets
Mechanical Reinforcing Bar Connectors[; G][; G, [____]]
Non-shrink grout
Preformed joint filler
Prestressing Steel[; G][; G, [____]]
Reinforcing Bars[; G][; G, [____]]
Reinforcement and Protective Coating[; G][; G, [____]]
Reinforcement supports
Sealer-hardener
Waterstops
Welded Wire Fabric

SD-04 Samples

NOTE: Where flat surface finishing is important,
provide a sample installation to train the crew.

Mass Concrete Mock-up

Test Section

SD-05 Design Data

Concrete Mixture Requirements[; G][; G, [____]]

Mixture designs

Mass Concrete Temperature Control Plans[; G][; G, [____]]

SD-06 Test Reports

[Mass Concrete Mock-up

] Air Entraining

Aggregates
Admixtures
As-Built Report
Cement
Concrete mixture proportions
Concrete Test Reports
Complementary Cementing Materials
Durability Modeling (Using STADIUM®)
Fresh Concrete Properties
Hardened Concrete Properties
Mechanical Reinforcing Bar Connectors
Silica fume
Reinforcing Bars
Reinforcement and Protective Coating
Water

[
]

SD-07 Certificates

Admixtures
Cementitious Materials
Cementitious material mill certificates
Field testing technician and testing agency

SD-08 Manufacturer's Instructions

Coatings

SD-11 Closeout Submittals

Aggregate Moisture Content
Aggregate Sampling
As-built report including observed defects and transport property test results
Concrete Test Reports
Quality Control Charts
Daily inspection reports

Quality Team Meetings

Sampling logs

1.4 MODIFICATION OF REFERENCES

Accomplish work in accordance with ACI publications except as modified herein. Consider the advisory or recommended provisions to be mandatory, as though the word "shall" had been substituted for the words "should" or "could" or "may," wherever they appear. Interpret reference to the "Building Official," the "Structural Engineer," and the "Architect/Engineer" to mean the Contracting Officer.

1.5 DELIVERY, PLACING, STORAGE, AND HANDLING OF CONCRETE

Follow **ACI 301M** **ACI 301**, **ACI 304R**, and **ASTM A934/A934M** requirements and recommendations. Do not deliver concrete until vapor barrier, forms, reinforcement, embedded items, and chamfer strips are in place and ready for concrete placement. Store reinforcement of different sizes and shapes in separate piles or racks raised above the ground. Protect materials from contaminants such as grease, oil, and dirt. Ensure materials can be accurately identified after bundles are broken and tags removed.

1.6 CONCRETE QUALITY CONTROL

NOTE: Service Life Modeling

Use of service life modeling predicts the performance of the concrete mixture when placed and cured properly. Concrete sampling during production and (if necessary) from the completed structure provides additional data to predict the service life. This methodology enhances the Navy's confidence that the structure will perform without major repairs for the defined service life. It is recommended that every significant structure employ this section inclusive of service life modeling. The Owner and the Engineer of Record shall determine if this approach is applicable. Additional information is provided in TR-NAVFAC ESC-CI-1215.

The goal is to provide quality concrete with the specified concrete cover to protect the steel, which provides the primary protection mechanism against chemical deterioration and corrosion related damage. All other corrosion protection strategies are considered to be supplemental and include (but are not limited to): barrier coatings to the concrete surface, fusion-bonded epoxy-coated steel, corrosion inhibitors, galvanized, stainless, **MMFX**, Z-bar reinforcing and cathodic protection. All of which may provide some life extension but by how much is considered to be speculation for real structures exposed to chloride environments. If the available materials in the region of the project are inadequate to meet the requirements for shrinkage, compressive strength, constructability and service

life then the Contractor shall prepare a recommendation for review by the agency's Subject Matter Expert in Concrete Materials and approval by the Contracting Officer and Engineer of Record on a case-by-case basis to use supplemental corrosion protection to meet project requirements.

The Navy recognizes only one numerical modeling software program for predicting the service life of concrete structures, STADIUM[®]. The most current version of the software shall be used. Service life modeling is a tool to be used with engineering judgment to aid in the design, material selection and construction methods to produce a durable structure.

Where they are available, specify only ACI certified personnel. Check the American Concrete Institute (ACI) website for local availability: www.concrete.org/Certification.

The objective of the concrete quality control program is for the Contractor to outline the procedures that will be used to construct a structure that will obtain the design service life. The Contractor shall develop and submit for approval a concrete quality control program in accordance with the guidelines of ACI 121R and as specified herein. The plan shall include approved laboratories. The Contractor shall provide direct oversight for the concrete qualification program inclusive of service life modeling, associated sampling and testing. If concrete cylinders tested during production indicate inadequate strength, excessive ion-transport properties, or inadequate mixing, then the owner may require the Contractor to extract concrete core samples from the hardened concrete for analysis at Contractor's expense to assure that the quality of the concrete as placed and cured will satisfy the defined service life.

Develop and submit for approval a concrete quality control program in accordance with the guidelines of ACI 121R and able to meet the defined service life using the methodology herein. Maintain a copy of ACI SP-15 and CRSI 10MSP at the project site.

1.6.1 Quality Control Personnel

The contractor shall submit for approval an organizational chart defining the quality control hierarchy, the responsibilities of the various positions, including the names and qualifications of the individuals in those positions.

Submit American Concrete Institute certification for the following:

- a. CQC personnel responsible for inspection of concrete operations.
- b. Lead Foreman or Journeyman of the Concrete Placing, Finishing, and Curing Crews.
- c. Field Testing Technicians: ACI Concrete Field Testing Technician, Grade I.

- d. Laboratory Testing Technicians: ACI Concrete Strength Testing Technician and Laboratory Testing Technician, Grade I or II.
- e. STADIUM[®] certified laboratory and users of STADIUM[®] software.
- f. Petrographer: Bachelor of Science degree in geology or petrography, trained in petrographic examination of concrete aggregate according to [ASTM C294](#) and [ASTM C295/C295M](#) and trained in identification of the specific deleterious processes and tests identified in this specification. Resume shall detail the education, training and experience related to the project-specific test methods and deleterious materials and shall be submitted at least 20 days before petrographic and deleterious materials examination is to commence.
- g. Concrete Batch Plant Operator: National Ready Mix Concrete Association (NRMCA) Plant Manager Certification at the Plant Manager level.

1.6.1.1 Quality Manager Qualifications

The quality manager shall hold a current license as a professional engineer in a U.S. state or territory with experience on at least five (5) similar projects. Evidence of extraordinary proven experience may be considered by the Contracting Officer as sufficient to act as the Quality Manager.

1.6.1.2 Field Testing Technician and Testing Agency

Submit data on qualifications of proposed testing agency and technicians for approval by the Contracting Officer prior to performing testing on concrete.

- a. Work on concrete under this contract shall be performed by an ACI Concrete Field Testing Technician Grade 1 qualified in accordance with [ACI SP-2](#) or equivalent. Equivalent certification programs shall include requirements for written and performance examinations as stipulated in [ACI SP-2](#).
- b. Testing agencies that perform testing services on [reinforcing steel](#) shall meet the requirements of [ASTM E329](#).
- c. Testing agencies that perform testing services on concrete materials shall meet the requirements of [ASTM C1077](#).
- d. Testing agencies or engineering companies that characterize the transport properties of the concrete or conduct service life modeling analysis shall be STADIUM[®] certified or pre-approved by the Contracting Officer with concurrence of the agency's Subject Matter Expert in Concrete Materials.

1.6.2 Laboratory Qualifications for Concrete Qualification Testing

The concrete testing laboratory shall have the necessary equipment and experience to accomplish required testing. The laboratory shall meet the requirements of [ASTM C1077](#), be Cement and Concrete Reference Laboratory (CCRL) inspected, and be a STADIUM[®] certified laboratory.

1.6.3 Laboratory Accreditation

Laboratory and testing facilities shall be provided by and at the expense of the Contractor. The laboratories performing the tests shall be accredited in accordance with ASTM C1077, including [ASTM C78/C78M](#) and [ASTM C1260](#). The accreditation shall be current and shall include the required test methods, as specified.

- a. Aggregate Testing and Mix Proportioning: Aggregate testing and mixture proportioning studies shall be performed by an accredited laboratory and under the direction of a licensed/registered civil engineer in a U.S. state or territory, who shall sign all reports and designs.
- b. Acceptance Testing: Furnish all materials, labor, and facilities required for molding, curing, testing, and protecting test specimens at the site and in the laboratory. Furnish and maintain boxes or other facilities suitable for storing and curing the specimens at the site while in the mold within the temperature range stipulated by [ASTM C31/C31M](#).
- c. Contractor Quality Control: All sampling and testing shall be performed by an approved, onsite, independent, accredited laboratory.

1.7 CONCRETE DURABILITY

1.7.1 Concrete Mixture Proportions

At least 60 days prior to concrete placement, submit concrete mixture proportions, ingredient material certificates and test data, and trial batch test data for each class of concrete proposed for use on the project. Submittal shall clearly indicate where each mixture will be used when more than one mixture design is submitted. Obtain approval from Contracting Officer prior to placement.

1.7.2 Concrete Design Requirements

Proportion concrete mixtures to meet the requirements listed in Table 1 in accordance with the procedures outlined in [ACI 201.2R](#) and [ACI 211.1](#).

The mixture proportions for concrete shall be developed by the Contractor to produce the required compressive strength (f'_{cr}), drying shrinkage, and constructability for mixtures that have the potential to accomplish a structure with the design service life.

Table 1 - Concrete Design Requirements		
Prescriptive requirements	Minimum	Maximum
ASTM C666/C666M Method A Durability Factor at 300 cycles	90	--
Concrete ASTM C157/C157M Drying Shrinkage percent, as modified per ACI 364.3R at 28 days except for high volume fly ash (HVFA) at 56 days.	--	0.05 percent
Initial acid-soluble chloride content in cast-in-place concrete per ASTM C1152/C1152M , percent/cement	--	0.10

Table 1 - Concrete Design Requirements		
Prescriptive requirements	Minimum	Maximum
Initial acid-soluble chloride content in prestressed concrete determined following ASTM C1152/C1152M , percent/cement	--	0.06

1.7.3 Concrete Mixture Qualifications

1.7.3.1 Previously Approved Concrete Mixtures

For identical concrete mixtures previously approved for use within the past 12 months, the previous mixture qualification submittal may be re-submitted without further trial batch testing if accompanied by:

- a. A copy of the prior approvals indicating the project name, project number, and location.
- b. Ingredient material test data conducted within 6 months of the submittal date.
- c. Copies of the previously approved trial batch test data, including the volume of permeable voids (ϕ), ionic diffusion coefficient (D_{oh}), 50 percent saturation water content (S50 percent), permeability (K) and the specified effective diffusion coefficient (D_{spec}).
- d. A log containing at least fifteen sequential test results with the calculated mean and standard deviation of the production concrete for air content, compressive strength, volume of permeable voids (ϕ), ionic diffusion coefficient (D_{oh}) and the effective diffusion coefficient (D_{eff}).

If the Contractor changes material type, class, sources, or suppliers; chemical composition; and/or mix proportions, the Contractor shall provide a written opinion of the significance of the change(s). The change(s) may require additional testing at the discretion of the Contracting Officer in consultation with the agency's Subject Matter Expert in Concrete Materials.

1.7.3.2 New Concrete Mixtures

- a. Submit complete ingredient material test data, including applicable reference specifications. Submit additional data regarding concrete aggregates if the source of aggregate changes.
- b. Submit copies of test reports by independent test lab conforming to [ASTM C1077](#) showing that the mixture has been successfully tested to produce concrete with the properties specified and that mixture will be suitable for the job conditions as described. Test reports shall be submitted along with the concrete mixture proportions. Obtain approval before concrete placement.
- c. Test a minimum of three trial batches of production concrete to establish the tolerance limits and the specified effective diffusion coefficient (D_{spec}). If batching facilities are located such that the haul-time will exceed 30 minutes, a simulated haul time shall be included in the trial batch.

If the concrete mixture for construction is proposed to contain corrosion inhibitors then laboratory testing shall be accomplished and tested for transport properties with and without the corrosion inhibitor because they are known to distort the results of the service life modeling when compared to mixtures without corrosion inhibitors. The Contractor shall obtain approval from the Contracting Officer for use of corrosion inhibitors.

- (1) Test and report fresh concrete property tests of each trial batch as follows:
 - (a) Slump in accordance with [ASTM C143/C143M](#).
 - (b) Air content in accordance with [ASTM C231/C231M](#) or [ASTM C173/C173M](#).
 - (c) Unit weight in accordance with [ASTM C138/C138M](#).
 - (d) Temperature in accordance with [ASTM C1064/C1064M](#).
- (2) Cast specimens, test, and report hardened concrete property tests of each trial batch as follows:
 - (a) Compressive strength at 3, 7, 28, 56 and 90 days in accordance with [ASTM C39/C39M](#). Use of unbonded caps in accordance with [ASTM C1231/C1231M](#) is permitted.
 - (b) Drying shrinkage may be determined from one batch.
 - (c) Tensile strength (if required) may be determined using specimens cast from one batch.
 - (d) Freeze-thaw durability factor (if required) shall be determined as the mean of six test specimens comprised of at least two specimens cast from each batch.
 - (e) Initial chloride ion content may be determined from one batch.
- (3) Moist cure concrete intended for cast-in-place applications in accordance with the standard moist curing conditions described in [ASTM C192/C192M](#) unless otherwise specified. Moist cure concrete intended for precast applications in the manner proposed for use on the project.
- (4) Cast twelve 100 by 200 mm 4 by 8 inch cylinders, test and report ion transport properties as follows:
 - (a) Determine the porosity at 28-days and 90-days of standard moist curing. Calculate the mean porosity and standard deviation at each test age.
 - (b) Determine the D_{oh} at 28-days and 90-days of standard moist curing. Calculate the mean D_{oh} and standard deviation at each test age.
 - (c) Determine the MTC at 28-days of standard moist curing.
 - (d) Calculate the aging coefficient as the ratio of the mean 90-day, or longer, D_{oh} to the mean 28-day standard moist cure D_{oh} .

- (e) Retain unused specimens in storage. These specimens may be tested later to refine the actual aging factor. This is advisable in the event that any production concrete falls short of the service life as it will provide evidence to better predict the service life.
- (5) Special handling will be necessary for shipments of transport property specimens. These cylinders shall be wrapped completely with slightly damp paper towels with distilled water only. The wrapped cylinders shall be placed in either a vacuum package or double layers of sealed plastic bags. Package the test cylinders to prevent damage and ship to an approved testing laboratory.
- d. The Contractor shall forward a [Durability Modeling](#) report prepared by the STADIUM[®] certified laboratory that addresses the service life of the proposed concrete system for each concrete mixture. As a minimum, the report shall contain:
- (1) The [concrete mixture proportions](#).
 - (2) The mean, standard deviation, and characteristic values for the porosity, the 28-day D_{oh} , the MTC, aging factor determined by testing and the specified effective diffusion coefficient (D_{spec}).
 - (3) The concrete cover to reinforcing steel. The cover to all reinforcing bars shall be clearly delineated with allowance for placement tolerances per [ACI 117](#).
 - (4) The environmental exposure conditions used for each type of concrete element.
 - (5) The effective diffusion coefficient (D_{eff}) that, for given specified exposure conditions and characteristics MTC values, satisfies the minimum required service life of the structural element.
 - (6) A narrative describing the modeling process including assumptions and recommendations to accomplish the service life using quality concrete and specified cover. In the event that locally available materials cannot be shown to accomplish the service life then the Contractor shall prepare a proposal for review by the agency's Subject Matter Expert in Concrete Materials and approval by the Contracting Officer to use alternative sources of materials and/or supplemental corrosion protection methods.
 - (7) A signed and stamped cover letter certifying compliance with the required average compressive strength (f'_{cr}), drying shrinkage, and constructability for mixtures that have the potential to accomplish a structure with the design service life.
 - (8) Letter regarding the certificate of completion for the STADIUM[®] training and the UFGS Laboratory Certification letter for the accredited laboratory.
- e. For concrete mixtures that are proposed to contain corrosion inhibitors, the Contractor shall submit 28-day D_{oh} values from at least three batches of the mixture with and without the admixture making appropriate adjustments to maintain constant water to cementitious ratio. The purpose is to establish a correlation with respect to an

adjusted value for production D_{oh} .

- f. At the option of the Contractor, a revised service life submittal may be provided as a value engineering proposal using refined characteristic porosity and D_{oh} values calculated from production data. Extensions to corrosion propagation period may be reviewed by the agency's Subject Matter Expert in Concrete Materials and approved by the Contracting Officer based on evidence provided by the Contractor on a case-by-case basis.

1.7.4 Project Environment

1.7.4.1 Location Details

The values of Table 2 define the location and exposure conditions to be used in service life modeling. The Engineer of Record shall define these values or allow use of default values available within the STADIUM[®] program based on the closest major city to the project.

Table 2 - Environmental Design Conditions	
Latitude	[_____] degrees Y' Z" [N] [S]
Longitude	[_____] degrees Y' Z" [E] [W]
MLLW Elevation, meter feet	[_____] meter feet
MHHW Elevation, meter feet	[_____] meter feet
Salinity, ppt (Submerged zone)	[_____] ppt
Salinity, ppt (Tidal zone)	[_____] ppt
Salinity, ppt (Splash zone)	[_____] ppt
Salinity, ppt (Atmospheric zone)	[_____] ppt
Annual mean water temperature, C F	[_____] Degrees C F
Annual maximum ambient temperature, C F	[_____] Degrees C F
Annual mean ambient temperature, C F	[_____] Degrees C F
Annual minimum ambient temperature, C F	[_____] Degrees C F
Annual mean relative humidity, percent	[_____] percent

1.7.4.2 Exposure Conditions by Element

The Contractor shall use the service life model and exposure conditions listed above to provide concrete system(s) that meet or exceed the service life requirement. Evaluate the service life of each element for its severest service condition.

1.7.5 Concrete Qualification Program

1.7.5.1 Fresh Concrete Properties

- a. Air Content: Concrete that is air entrained shall conform to the air limits specified in **ACI 301M ACI 301** for exposure and the aggregate size used and tested in accordance with **ASTM C231/C231M**. Variations outside the limits specified shall not be reason to reject the concrete in locations not subject to freeze-thaw conditions.
- b. Slump: The concrete mixture shall be proportioned to have, at the point of deposit, a maximum slump of **100 mm 4 inches** as determined by **ASTM C143/C143M** when admixtures that affect slump are not used. Where an **ASTM C494/C494M**, Type F or G admixture is used, the slump after the addition of the admixture shall not exceed **200 mm 8 inches**. Slump tolerances shall comply with the requirements of **ACI 117**.
- c. Self-Consolidating Concrete: When self-consolidating concrete is proposed for use, the mixture shall be proportioned and tested for qualification using:
 - (1) **ASTM C1611/C1611M** slump flow shall not be greater than **609.6 mm 24 inches**, with visual stability index not greater than 1.
 - (2) **ASTM C1621/C1621M** Passing ability using the J-ring. Spread within **25.4 mm 1 inch** less than the slump flow.
 - (3) Passing ability using the L-Box between 4 and 8 seconds
 - (4) **ASTM C1610/C1610M**, static segregation shall be less than 4.0 percent.

For process control sampling, the slump flow limit as determined by **ASTM C1611/C1611M** shall be no greater than **609.6 mm 24 inches** and the visual stability index limit shall be no greater than 1.0.

- d. Underwater concrete: When the concrete is intended for placement under water using the tremie technique, the concrete shall be proportioned to be cohesive and flow with minimal out segregation. Viscosity modifying admixtures are permitted for underwater concrete. Proportioning guidance in **ACI 304R** shall be considered. Concrete mixtures shall be qualified for tremie placement methods based on a trial placement approved by the Contracting Officer.

1.7.5.2 Hardened Concrete Properties

NOTE: Navy waterfront structures typically take a year or more to complete. With time all concrete continues to gain strength. The Engineer of Record is encouraged to design the structural elements based on the compressive strength that will be achieved at 56 or 90 days rather than at 28 days. Doing so will better allow the Contractor to develop and place concrete mixtures with less portland cement. Excessive use of cement leads to more cracks and shorter-lived structures. Embracing this approach will result in structures that are less expensive, greener and more sustainable.

- a. Compressive Strength: The structural engineer shall specify the minimum compressive strength results at [28] [56] days. Determine compressive strength (f'_{cr}) for qualification of concrete mixtures and for quality acceptance testing. A compressive strength test result is defined as the mean of three properly conducted tests on 100 by 200 mm 4 by 8 inch cylinders in accordance with ASTM C39/C39M. Alternatively and for concrete mixtures containing a maximum size aggregate greater than 25.4 mm 1 inch, a strength test result shall be defined as the mean of two properly conducted 28-day tests on 150 by 300 mm 6 by 12 inch cylindrical specimens in accordance with ASTM C39/C39M. In addition:
- (1) Specified Compressive Strength: For structural concrete elements exposed in a marine environment, the minimum specified [28] [56] day design strength is denoted as (f'_c). Strength of concrete containing 50 percent or more fly ash shall be specified at a minimum of 56 days.
 - (2) Required Average Strength: The concrete shall be proportioned such that the minimum required average compressive strength (f'_{cr}) exceeds the specified design strength (f'_c) as per ACI 301M ACI 301.
 - (3) The average compressive strength may not exceed the specified strength at the same age by more than 20 percent unless approved by the Engineer of Record.
 - (4) Strength of any individual concrete placement shall be considered satisfactory if both the following requirements are met:
 - (a) The arithmetic mean of any three consecutive lot strength tests is between 1.0 and 1.2 f'_c , and;
 - (b) No individual strength test result is less than 0.90 f'_c .
 - (5) In the event that a placement is represented by single sampling lot, strength shall be considered satisfactory if either:
 - (a) The mean of the initial test is between 1.0 and 1.2 f'_c , or;
 - (b) The mean of the initial test and retest is between 1.0 and 1.2 f'_c , and neither strength test result is less than 0.90 f'_c .
 - (6) For underwater concrete, cast compressive strength samples by placing concrete in four 5-gallon buckets below water using similar placement as the project. Permanently mark buckets as "3 days," "7 days," "[28] [56] days," and "Extra." Include date and station. Provide specimen sets at every [76.5 cubic meters] [100 cubic yards] of concrete for the first [382.3 cubic meters] [500 cubic yards], then every [382.3 cubic meters] [500 cubic yards] thereafter with a minimum of one set per day of underwater concrete placement.
 - (a) Retrieve buckets at specified intervals and extract three cores from each bucket. Conduct compressive strength test in accordance with ASTM C42/C42M.
 - (b) Strength of underwater concrete shall be satisfactory if the compressive strength result from extracted cores at the age of the

specified strength is between 0.85 and 1.2 f'c with no individual strength test result less than 0.75 f'c.

- b. Drying Shrinkage: Determine drying shrinkage for qualification of concrete mixtures prior to the fabrication of the Test Section and from samples made during the fabrication of the Test Section (see the subpart entitled "Test Section"). All test results shall not exceed 0.05 percent. A drying shrinkage test result shall be the mean value from three or more individual specimens constituting a test set. If an individual specimen's measurements deviate from the mean value by more than 0.009 percent length change the specimen's measurements shall be discarded and a new average established. Casting more than three specimens for each set is permitted. Test procedures and test specimens shall conform to the following:

Drying shrinkage specimens, typically 75 by 75 by 285.8 mm 3 by 3 by 11.25 inch prisms for 25.4 mm 1 inch maximum size aggregate or smaller, shall be fabricated, cured, dried, and measured at 28 days in the manner delineated in ASTM C157/C157M except as modified by ACI 364.3R. Mixtures containing 50 percent or more complementary cementing materials shall meet the shrinkage criteria at 56 days.

- [c. Tensile strength: Determine splitting-tensile strength of concrete only for qualification of concrete mixtures. Determine and report the splitting-tensile strength result of each class of concrete in accordance with ASTM C496/C496M as the mean of three properly conducted tests at the age specified for f'c and again at 90-days age for information only.
-] [d. Elastic Modulus: Determine the elastic modulus of concrete only for qualification of concrete mixtures, per ASTM C469/C469M at the age specified for f'c if required by the Engineer of Record. Additional test ages should be specified for mass concrete.
-] e. Freeze-thaw durability: Determine the freeze-thaw durability factor of concrete for qualification of concrete mixtures, if required by environmental conditions. Determine and report the freeze-thaw durability factor of each class of concrete in accordance with ASTM C666/C666M Method-A. Start testing after [28] days of moist curing. The minimum acceptable durability factor after 300 cycles of rapid freezing and thawing is 90 percent.
- f. Water Soluble Chloride Ion Content: Determine the chloride ion content only for qualification of concrete mixtures. Determine water soluble chloride ion content in accordance with ASTM C1218/C1218M. The limits for allowable water-soluble chloride ion concentrations in hardened concrete are listed in Table 3.

Table 3 - Maximum water soluble Chloride Ion Content for Corrosion Protection	
Type of Member	Maximum water soluble chloride ion in concrete, percent by weight of cement
Prestressed concrete	0.06 percent

Table 3 - Maximum water soluble Chloride Ion Content for Corrosion Protection	
Type of Member	Maximum water soluble chloride ion in concrete, percent by weight of cement
Reinforced concrete exposed to chloride in service	0.08 percent
Reinforced concrete that will be dry or protected from moisture in Service	0.15 percent
Other reinforced concrete construction	0.30 percent

- g. The use of silica fume is discouraged. Silica fume shall only be used for OCONUS projects where Class F fly ash and GGBF slag are not available, and when approved by the Contracting Officer. If justified by service life modeling the mixture may contain a maximum of 7 percent silica fume by mass. Concrete mixtures containing any percentage of silica fume shall be evaluated at every [76.5] cubic meters [100] cubic yards of concrete for the first [382.3] cubic meters [500] cubic yards, then every [382.3] cubic meters [500] cubic yards thereafter to ensure that the silica fume is properly dispersed in hardened concrete samples. A qualified laboratory shall microscopically examine a sectioned sample and document the results. Provide at the Contractor's expense the services of a manufacturer's technical representative, experienced in mixing, proportioning, placement procedures, and curing of concrete containing silica fume.
- h. Ion Transport Properties: Determine ion transport properties of the concrete in accordance with test procedures outlined by SIMCO, maker of STADIUM[®] software. Ion Transport properties are required as inputs for service life modeling and include: the volume of permeable voids (porosity); the ion diffusion coefficient (D_{oh}); the moisture transport coefficient (MTC), and an aging factor. A brief description of the test procedures is provided below. See TR-NAVFAC ESC-CI-1215 for further details.
- (1) Porosity: The volume of permeable voids (porosity) of concrete is determined in accordance with ASTM C642. Porosity is determined for qualification of concrete mixtures and for quality acceptance testing.
 - (2) Ion Diffusion Coefficient (D_{oh}): This test is a modified version of ASTM C1202 and uses an electrical field to migrate chloride ions through a vacuum saturated concrete specimen for approximately 14 days. The electrical charge flowing through the concrete is related to the diffusion coefficient of ionic species in cementitious materials. A test is defined as the average of two specimens run together and whose results are analyzed together to produce a single D_{oh} value. The service life modeling software uses the cementitious materials proportions and porosity measurements to analyze the electrical measurements and determine the D_{oh} . The D_{oh} is determined for qualification of concrete mixtures and for quality acceptance testing.
 - (3) Moisture Transport Test: This modified version of the ASTM C1585

test determines the drying rate of pre-saturated cementitious materials by measuring the evaporative mass loss of concrete slices with different thickness exposed to constant temperature and relative humidity environment. The moisture transport coefficient (MTC) is then determined by analyzing the mass loss data using the service life modeling software.

This test is only used for qualification of concrete mixtures, not for production concrete.

- (4) Aging factor: The aging factor is a necessary value to estimate the change in diffusion coefficient over time. The aging factor is defined as the ratio of the ultimate D_{oh} to the 28-day D_{oh} per [TR-NAVFAC ESC-CI-1215](#). Since we cannot wait for two or more years to characterize project concrete, a surrogate aging factor is used in this specification. This surrogate aging factor is calculated as the ratio of 90-day, or longer, D_{oh} to the 28-day D_{oh} . The aging factor is determined only for qualification of concrete mixtures in compliance with [TR-NAVFAC ESC-CI-1215](#).

1.7.5.3 Reinforcing Steel Corrosion Properties

The corrosion properties of the reinforcing steel used for service life modeling shall be as follows unless otherwise approved by the Contracting Officer after review by the agency's Subject Matter Expert in Concrete Materials:

Table 4 -Chloride Threshold Level and Corrosion Propagation Time				
Description	UNS Alloy	EN No.	Chloride Threshold (CTH), ppm	Corrosion Propagation Period (Tp) max, years
ASTM A706/A706M (Low alloy carbon steel)	[_____]	[_____]	500	15
ASTM A615/A615M (Carbon steel)	[_____]	[_____]	500	15
ASTM A416/A416M (carbon steel 7-wire strand)	[_____]	[_____]	500	15
ASTM A882/A882M (indented 7-wire strand)*	[_____]	[_____]		
ASTM A886/A886M (epoxy-filled 7-wire strand)*	[_____]	[_____]		
ASTM A934/A934M (Purple Epoxy)*	[_____]	[_____]		
ASTM A775/A775M (Green Epoxy) Not allowed	[_____]	[_____]		
ASTM A767/A767M (Galvanized Class 1)*	[_____]	[_____]		

Table 4 -Chloride Threshold Level and Corrosion Propagation Time				
Description	UNS Alloy	EN No.	Chloride Threshold (CTH), ppm	Corrosion Propagation Period (Tp) max, years
ASTM A1035/A1035M (MMFX2 bars)*	[_____]	[_____]		
ASTM A1055/A1055M (Z bars)*	[_____]	[_____]		
ASTM A955/A955M (as applicable) XM Stainless Grades				
XM-28 (Nitronic 32)	S24100		500	15
XM-29 (Nitronic 33)	S24000		500	15
XM-19 (Nitronic 50)	S20910		500	15
ASTM A276 Austenitic Stainless 304L	S30403	1.4307	3000	15
ASTM A276 Duplex Stainless 2304	S32304	1.4362	4000	15
ASTM A955/A955M Austenitic Stainless 316L	S31603	1.4404	5000	15
ASTM A955/A955M Austenitic Stainless 316LN	S31653	1.4429	5000	15
ASTM A276 Duplex Stainless 2205	S31803 S32205	1.4462	5000	15
*See TR-NAVFAC ESC-CI-1215				
** All other reinforcement not listed require approval of agency's Subject Matter Expert in Concrete Materials				

1.7.5.4 Supplemental Corrosion Protection

If the available materials in the region of the project cannot practically be made to meet the service life based on testing and service life modeling without the use of supplemental corrosion protection, then the Contractor shall prepare a recommendation on how to accomplish the service life using imported materials and/or supplemental corrosion protection. With input from the agency's Subject Matter Expert in Concrete Materials, the Contracting Officer shall consider approval of the Contractor's recommendation on a case-by-case basis.

1.7.6 Mass Concrete Temperature Control Plans

- a. Thirty days minimum prior to concrete placement, submit for approval a mass concrete temperature control plan that includes:

- (1) Location and identification of temperature monitoring sensors.
- (2) Product data for automated temperature sensors and recording equipment.
- (3) Cooling pipe layout diagram with sizes and materials, if used.
- (4) Proposed insulation materials and associated R-values.
- (5) Anticipated form removal schedule and curing procedures.
- (6) Maximum allowable concrete placement temperature for the range of anticipated ambient temperatures based on thermal modeling.
- (7) Monitoring procedures and contingency plans.

Concrete placement temperature shall be based on results of thermal modeling for the element incorporating: the heat of hydration and specific heat capacity for the concrete mixture, solar gain, and heat transfer to the environment through formwork, insulation, and cooling techniques.

Mass concrete temperature control shall be monitored using automated temperature recording devices that allow wireless transmission of data to an on-site host computer for real-time monitoring of temperatures.

Temperature control sensor layout for each placement shall be provided with individual sensor ID identified.

Minimum sensor requirements include at least two sensors for each placement located as follows:

- (1) The geometric center of the element cross-section.
- (2) Within 76.2 mm 3 inches of the side forms at mid-height.
- (3) Within 76.2 mm 3 inches of the top surface located directly above the center sensors.
- (4) Within 76.2 mm 3 inches from the top corner at the intersection of side forms.
- (5) Ambient temperature sensors placed in a shaded location.

Procedures for installing, protecting sensors during placement, and testing sensors a minimum of 24 hours prior to concrete placement shall be provided. Initiate sensor recording at least 2 hours prior to placement. Verify function of all sensors prior to and upon completion of concrete placing operations. Provide additional sensors for placements greater than 305.8 cubic meters 400 cubic yards at each location.

Submit procedures for controlling concrete temperatures within the following limits:

- (1) Maximum temperature shall be less than 70 degrees C 158 degrees F.
- (2) Maximum temperature differential between the mean of all functioning center sensor temperatures to any individual surface or corner sensor shall be less than 20 degrees C 68 degrees F.

(3) Temperature control procedures shall remain in effect until the differential between the ambient low temperature and mean of all functioning center sensor temperatures is less than 20 degrees C 68 degrees F.

(4) An additional submittal shall be provided for the Contracting Officer's approval in the event the Contractor fails to control temperatures within the limits listed above. The submittal shall include documentation of any cracks that develop, identify revisions to control procedures to prevent future cracking, and procedures to seal or otherwise mitigate defects.

b. **Mass Concrete Mock-up:** For concrete mixtures intended for mass concrete, cast thirty-one (31) 100 by 200 mm 4 by 8 inch cylinder specimens in accordance with ASTM C192/C192M, three 75 by 75 by 285.8 mm 3 by 3 by 11.25 inch concrete prisms in accordance with ASTM C157/C157M, and at least one semi-adiabatic cube from a trial batch.

The semi adiabatic cube shall have a minimum dimension of 3 feet per side, and shall be insulated all sides with a minimum R-value of 30. Install pairs of thermocouples at the center of mass, the middle of each side, the top surface, and the top corner. Automatically record the temperature of each sensor hourly for one week. Additional cubes may be cast to calibrate active cooling system performance.

(1) Conduct compressive strength development testing at 3, 7, [28] [56], and 90 days age using three specimens per age in accordance with ASTM C39/C39M, and develop a compressive strength prediction equation for the concrete mixture in accordance with ASTM C1074.

(2) Conduct tensile strength tests at 3, 7, [28] [56], and 90 days on two specimens per age in accordance with ASTM C496/C496M, and develop a tensile strength prediction equation for the concrete mixture in accordance with ASTM C1074.

(3) Conduct elastic modulus tests at 3, 7, [28] [56], and 90 days on two specimens per age in accordance with ASTM C469/C469M, and develop an elastic modulus prediction equation for the concrete mixture in accordance with ASTM C1074.

Conduct coefficient of thermal expansion testing in accordance with COE CRD-C 39 after 28 days of moist curing. Test specimens in a saturated condition.

Report all test results and predictive equations in the mock-up submittal. The predictive equations may be used by the Contractor to establish the duration of temperature control and form removal based on the allowable temperature differential between the concrete core and ambient low temperature.

1.8 CONCRETE

1.8.1 Drawings

Fabrication Drawings for concrete formwork, reinforcement materials, precast elements, wall forms, and bulkhead forms must indicate concrete pressure calculations with both live and dead loads, along with material types. Provide design calculations by a registered Civil or Structural Engineer for the formwork.

1.8.1.1 Formwork

Prior to commencing work submit drawings for approval showing details of formwork including, but not limited to: joints, supports, studding and shoring, and sequence of form and shoring removal. Reproductions of contract drawings are unacceptable.

Design, fabricate, erect, support, brace, and maintain formwork so that it is capable of supporting without failure all vertical and lateral loads that may reasonably be anticipated to be applied to the formwork.

ACI 347. Include design calculations indicating arrangement of forms, sizes, species, and grades of supports (lumber), panels, and related components. Indicate placement schedule, construction, and location and method of forming control joints. Include locations of inserts, pipe work, conduit, sleeves, and other embedded items. Furnish drawings and descriptions of shoring and reshoring methods proposed for slabs, beams, and other horizontal concrete members.

1.8.1.2 Reinforcing Steel

ACI SP-66. Provide bending and cutting diagrams, assembly diagrams, splicing placement and laps of bars, shapes, dimensions, and details of bar reinforcing, accessories, and concrete cover. Do not scale dimensions from structural drawings to determine lengths of reinforcing bars. Only complete drawings will be accepted.

1.8.1.3 Precast Elements

NOTE: Modify requirements based on the scope of the project.

Submit drawings and design calculations indicating complete information for the fabrication, handling, and erection of the precast elements. Drawings shall not be reproductions of contract drawings.

1.8.1.4 Joints

Submit a plan indicating the type and location of each expansion and construction joint. Final joint locations are subject to Government approval.

1.8.2 Pre-Construction Submittals

1.8.2.1 Curing Concrete Elements

Submit proposed materials and methods for curing concrete elements.

1.8.2.2 Concrete Curing Plan

Submit proposed materials, methods, and duration for curing and cooling concrete elements in accordance with ACI 308.1.

Minimum moist curing duration shall be seven days.

Begin curing immediately after placement. Protect concrete from premature

drying, excessively hot temperatures, and mechanical injury; and maintain minimal moisture loss at a relatively constant temperature for the period necessary for hydration of the cement and hardening of the concrete. The materials and methods of curing are subject to approval by the Contracting Officer.

1.8.2.3 Form Removal Schedule

Submit schedule for form removal indicating element and minimum length of time for form removal. Submit technical literature of forming material or liner, form release agent, form ties, and gasketing to prevent leakage at form and construction joints. Provide a full description of materials and methods to be used to patch form-tie holes.

1.8.2.4 Concrete Placement and Compaction

- a. Submit technical literature for equipment and methods proposed for use in placing concrete. Include [concrete pumping](#) or conveying equipment including type, size and material for pipe, valve characteristics, and the maximum length and height concrete will be pumped. No adjustments shall be made to the mixture design to facilitate pumping.
- b. Submit technical literature for equipment and methods proposed for vibrating and compacting concrete. Submittal shall include technical literature describing the equipment including vibrator diameter, length, frequency, amplitude, centrifugal force, and manufacturer's description of the radius of influence under load. Where flat work is to be cast, provide similar information relative to the proposed compacting screed or other method to ensure dense placement.

1.8.2.5 Concrete Report

Provide a Report inclusive of materials and methods used, test results, and the field test strength (fcr) for concrete that shows compliance with the structural and service life requirements.

1.8.2.6 Coatings

Coatings are considered to be "supplemental Corrosion Protection". Surface preparation and installation of any coatings on concrete shall be conducted in strict compliance with written manufacturer instructions. Submit the product data and written manufacturer instructions. A manufacturer representative shall train installers, witness initial installation, and certify that the installation was conducted in accordance with the instructions.

1.8.2.7 Preconstruction Testing of Materials

All sampling and testing shall be performed by, and at the expense of, the Contractor. Use an approved commercial laboratory or, for cementitious materials and chemical admixtures, a laboratory maintained by the manufacturer of the material. No material shall be used until notice of acceptance has been given. The Contractor will not be entitled to any additional payment or extension of time due to failure of any material to meet project requirements, or for any additional sampling or testing required. Additional tests may be performed by the Government at the discretion of the Contracting Officer; such Government testing will not relieve the Contractor of any testing responsibilities.

1.8.2.8 Material Safety Data Sheets

Submit Material Safety Data Sheets (MSDS) for all materials that are regulated for hazardous health effects. Prominently post the MSDS at the construction site.

1.8.2.9 Mixture Designs

Provide a detailed report of materials and methods used, test results, and the field test strength (fcr) for marine concrete required to meet structural and durability requirements.

1.8.3 Sampling

The Contractor shall be responsible for conducting concrete production process control sampling and testing in compliance with this specification.

1.8.3.1 Ingredient Material Sampling

- a. [Cementitious material mill certificates](#) and test reports shall be provided for each shipment. Record the date delivered and quantity of material represented by the certificate.
- b. Conduct and log [aggregate moisture content](#) at a minimum frequency of twice daily for each day's production. Use of moisture sensors in storage bins is recommended practice, but does not satisfy this requirement.
- c. [Aggregate sampling](#) for gradation and dry-rodded unit weight shall be conducted for each 100 tons delivered for use on the project, or portion thereof.

1.8.4 Reporting

1.8.4.1 Daily Inspection Reports

Contractor shall prepare daily inspection reports for all inspection activities such as base preparation, formwork preparation, reinforcement installation, concrete placement log, and temperature control activities. Submit sample forms and describe the procedure used to organize, archive, and retrieve inspection records in the Quality Program submittal.

1.8.4.2 Sampling Logs

Contractor shall maintain a concrete placement log as an electronic spreadsheet or database identifying each placement date, placement location, volume of concrete, batch ticket numbers, lot identification code, fresh concrete properties, compressive strength results, transport properties, inspection comments, and acceptance status. Contractor shall provide/transmit the concrete testing log to the Contracting Officer weekly. The Contractor shall provide copies of supporting documents for any placement requested by the Contracting Officer immediately upon request.

1.8.4.3 Quality Control Data

The Contractor shall prepare, maintain, and report separate [quality control charts](#) illustrating the slump, temperature, air content, compressive strength test results, 28-day porosity, and D_{oh} test results for each lot of each concrete mixture used on the project.

1.8.4.4 Quality Team Meetings

The contractor shall conduct regular quality control team meetings to review plans for future placements, review test results, and discuss dispensation of non-conforming materials. The quality team shall include the Contractor's quality manager, the project manager, the project superintendent, the Contracting Officer, and representatives of the testing agency and concrete producer, or approved substitutes. It is recommended that the meetings be held on a weekly or bi-weekly basis during the service life modeling submittal phases and then monthly, as the construction progresses. The transition from the weekly or bi-weekly meetings to the monthly meetings shall be with the Contracting Officer's approval.

The Contractor shall prepare quality control team meeting minutes for each meeting. The minutes shall include the date of each meeting, attendees, key discussion points, findings, recommendations, assigned tasks, assigned personnel, task completion dates and status of each task.

1.8.4.5 Non-conforming materials

The exact location of non-conforming concrete as placed shall be identified and the Contracting Officer and Engineer of Record shall be notified immediately. There are numerous possible indicators that the as-placed concrete is non-conforming including (but not limited to) excessive compressive strength, inadequate compressive strength, excessive slump, transport properties out of limits, excessive voids and honeycombing, and concrete delivery records that indicate excessive time between mixing and placement and/or excessive water was added to the mixture during delivery and placement. Any of these indicators alone are sufficient reason for the Contracting Officer to request additional sampling, testing and service life modeling to quantify the concrete properties. If justified, cores may be extracted for testing, and an investigation into the cause for non-conformance shall be conducted. The investigation may include statistical analysis of the test data collected to date; appropriateness of the pre-defined QAL based on statistical analysis of production data; the impact of the non-conforming material on the structure strength and/or service life; and recommendations for concrete production process improvements, mitigation, or remediation, as appropriate.

Investigations into non-conforming materials shall be conducted at the Contractor's expense. The Contractor shall be responsible for the investigation and shall make written recommendations to adequately mitigate or remediate the non-conforming material. The Contracting Officer may accept, accept with reduced payment, require mitigation, or require removal and replacement of non-conforming material at no additional cost to the Government.

1.8.5 Test Reports

Concrete Test Reports shall be identified by a sequential report identification code. Each report shall identify the placement date, placement location, weather, name of testing technician, time of sampling, batch ticket number, fresh concrete test results, and hardened concrete test results.

1.8.5.1 Concrete Mixture Requirements

- a. Submit copies of test reports conforming to ASTM C1077 showing that the

mixture has been successfully tested to produce concrete with the properties specified and that mixture will be suitable for the job conditions. Test reports shall be submitted along with the concrete mixture proportions. Obtain approval before concrete placement.

- b. Fully describe the processes and methodology whereby mixture proportions were developed and tested and how proportions will be adjusted during progress of the work to achieve, as closely as possible, the designated levels of relevant properties.
- c. Submit copies of reports from STADIUM[®] analysis with laboratory analysis and modeling results indicating contract-goal service life will be met.

1.8.5.2 Complementary Cementing Materials

Submit test results in accordance with [ASTM C618](#) and the physical and chemical analysis in accordance with applicable ASTM standards such as [ASTM C311](#) for fly ash. Submit test results performed within 6 months of submittal date. Update this report during construction as necessary to assure that the complementary cementing materials used on the projects meets the ASTM criteria and the report on file is never older than 6 months.

1.8.5.2.1 Ground Granulated Blast-Furnace Slag

Submit test results in accordance with [ASTM C989/C989M](#) for ground granulated blast-furnace slag. Submit test results performed within 6 months of submittal date. Update this report during construction as necessary to assure that the report on file is never older than 6 months.

1.8.5.2.2 Ultra Fine Fly Ash or Pozzolan

Submit test results in accordance with [ASTM C618](#) as a Class F fly ash or Class N pozzolan with the following additional requirements:

- a. The strength activity index at 28 days shall be at least 95 percent of the control.
- b. The average particle size shall not exceed 6 microns.
- c. The sum SiO_2 plus Al_2O_3 plus Fe_2O_3 shall be greater than 77 percent.

Submit test results performed within 6 months of submittal date. Update this report during construction as necessary to assure that the report on file is never older than 6 months.

1.8.5.3 Silica Fume

Submit test results in accordance with [ASTM C1240](#) for silica fume. Data shall be based upon tests performed within 6 months of submittal. Update this report during construction as necessary to assure that the report on file is never older than 6 months.

1.8.5.4 Aggregates

Aggregate samples shall be obtained in accordance with [ASTM D75/D75M](#) and shall be representative of the materials to be used for the project. Submit test results for aggregate quality in accordance with [ASTM C33/C33M](#), and the combined gradation curve proposed for use in the work and used in the mixture qualification, and [ASTM C295/C295M](#) for results of petrographic

examination. Confirm that the potential for alkali-silica reaction are within allowable limits by conducting tests in accordance with ASTM C1260. Submit results of all tests during progress of the work in tabular and graphical form as noted above, describing the cumulative combined aggregate grading and the percent of the combined aggregate retained on each sieve.

1.8.5.5 Admixtures

Submit test results in accordance with ASTM C494/C494M and ASTM C1017/C1017M for concrete admixtures, ASTM C260/C260M for air-entraining admixture, and manufacturer's literature and test reports for corrosion inhibitors and anti-washout admixture. Submitted data shall be based upon tests performed within 6 months of submittal. Submit certified copies of test results for the specific lots or batches to be used on the project. Test results shall be not more than 6 months old prior to use in the work. Chemical admixtures that have been in storage at the project site for longer than 6 months or that has been subjected to freezing will be retested at the expense of the Contractor.

1.8.5.6 Portland Cement

Portland cement[,ground granulated blast furnace (GGBF) slag,] [and pozzolan] will be accepted on the basis of manufacturer's certification of compliance, accompanied by mill test reports showing that the material in each shipment meets the requirements of the specification under which it is furnished. Mill test reports shall be no more than 1 month old, prior to use in the work. No cementitious material shall be used until notice of acceptance has been given by the Contracting Officer. Cementitious material may be subjected to check testing by the Government from samples obtained at the mill, at transfer points, or at the project site. If tests prove that a cementitious material that has been delivered is unsatisfactory, it shall be promptly removed at Contractor's expense from the site of the work. Cementitious material that has not been used within 6 months after testing shall be retested at the Contractor's expense and shall be rejected if test results are not satisfactory. Submit test results in accordance with ASTM C150/C150M portland cement and/or ASTM C595/C595M and ASTM C1157/C1157M for blended cement.

1.8.5.7 Testing During Construction

During construction, the Contractor is responsible for sampling and testing aggregates, cementitious materials, and concrete as specified herein. The Government will sample and test concrete and ingredient materials as considered appropriate. Provide facilities and labor as may be necessary for procurement of representative test samples. Testing by the Government will in no way relieve the Contractor of the specified testing requirements.

1.8.5.8 Test Section

- a. Horizontal Placements. No more than 90 days prior to construction, construct a Test Section 3048 mm by 3048 mm by 203.2 mm 10 by 10 feet by 8 inches thick near the job site, but not as part of the structure. The Test Section shall meet all specification requirements and be acceptable to the Contracting Officer in all respects, including but not limited to delivery time, placement, consolidation, curing and surface texture. Use the Test Section to develop and demonstrate to the satisfaction of the Contracting Officer the proposed techniques of mixing, hauling, placing, consolidating, finishing, curing, initial saw cutting, start-up procedures, testing methods, plant operations, and

the preparation of the construction joints. The mixing plant shall be operated and equipment calibrated prior to start of placing the Test Section. Use the same equipment, materials, and construction techniques on the Test Section as will be used in all subsequent work. Concrete production, placing, consolidating, curing, construction of joints, and all testing shall be in accordance with applicable provisions of this specification. At a minimum of three days after completion of the Test Section, extract a sufficient number of concrete cores 100 by 200 mm 4 by 8 inch to conduct tests to evaluate; strength, homogeneity, consolidation, segregation and transport properties. Test Results that are unacceptable Test Section will necessitate construction of an additional Test Section at no additional cost to the Government

- b. Vertical Placements. No more than 90 days prior to construction, construct a Test Section that represents the vertical placements, (if applicable) near the job site, but not as part of the structure. Test Section shall meet all specification requirements and being acceptable to the Contracting Officer in all respects, including but not limited to delivery time, placement, consolidation, curing and surface texture. Use the Test Section to develop and demonstrate to the satisfaction of the Contracting Officer the proposed techniques of mixing, hauling, placing, consolidating, finishing, curing, initial saw cutting, start-up procedures, testing methods, plant operations, and the preparation of the construction joints. The mixing plant shall be operated and equipment calibrated prior to start of placing the Test Section. Use the same equipment, materials, and construction techniques on the Test Section as will be used in all subsequent work. Concrete production, placing, consolidating, curing, construction of joints, and all testing shall be in accordance with applicable provisions of this specification. At a minimum of three days after completion of the Test Section, extract a sufficient number of concrete cores to evaluate homogeneity, consolidation, segregation and transport properties. If any of the test results are unacceptable, the Contracting Officer may require that a new Test Section be accomplished at no additional cost to the Government.

1.8.5.9 Acceptability of Work

The materials and the structure itself will be accepted on the basis of tests made by the Contractor and shall be in compliance with the criteria herein. The Government may make check tests at its expense to validate the results of the Contractor's testing. Testing performed by the Government will in no way relieve the Contractor from the specified testing requirements.

PART 2 PRODUCTS

NOTE: Delete any reference to any products which are not to be used on the project. Coordinate all product requirements with the appropriate agency's Contracting Officer.

2.1 CEMENTITIOUS MATERIALS

NOTE: Edit these paragraphs as appropriate for the particular project. Guidance for use of cementitious

materials should be sought from the agency's Subject Matter Expert in Concrete Materials. Consideration should be given to the use of fly ash or GGBF slag for partial replacement of portland cement up to 50 percent. Type III cement should not be specified. Laboratory mixtures, proportioning studies, and tests during the design stage of the project should be inclusive of service life modeling.

NOTE: Complementary Cementing Materials (AKA Supplementary Cementitious Materials (SCM))

When granulated slag, coal fly ash, and natural pozzolans are used as cementing materials for replacement of portland cement in a concrete mixture, and if by doing so the sustainability, durability and the initial cost of the concrete mixture show considerable improvement then it is improper to call these materials "supplementary cementitious materials" (SCM). As the concrete industry moves forward and takes better advantage of this proven technology, it is appropriate to introduce the term "complementary cementing material" (CCM) to describe these mixtures. When lesser amounts of these materials are used to produce concrete mixtures that do not show these benefits then the term SCM remains applicable.

The Engineer of Record is encouraged to specify the use of complementary cementing materials. For example 50 percent replacement of the portland cement using Class F fly ash has been successfully demonstrated to offer the required compressive strength (f'cr), drying shrinkage, lower permeability, constructability, and the potential to accomplish a structure with the design service life while being less expensive with a smaller carbon footprint.

Cementitious materials shall be portland cement or cement blended with complementary cementing materials. New submittals are required when the cementitious materials change sources or types.

The Contractor shall provide cementitious materials meeting the requirements of the applicable specification, and as modified herein. Provide mill certificates and test results conducted within six-months of the submittal date as part of the concrete mixture qualification submittal.

Provide a single manufacturer of cementitious material for each type of cement and complementary cementing materials supplied to the project.

2.1.1.1 Portland Cement

Provide portland cement conforming to **ASTM C150/C150M**, Type [I] [II] [V], low alkali [including false set requirements] with tri-calcium

aluminates (C3A) content less than 10 percent and a maximum cement-alkali content of 0.80 percent Na₂O_e (sodium oxide) equivalent. Type III cement shall be used only with concurrence of the agency's Subject Matter Expert in Concrete Materials. When HVFA mixtures are specified they should be blended with Type II portland cement. HVFA is encouraged instead of using Type V cement in high-sulfate areas. Low alkali cement may be required if the proposed aggregates are found to be expansive.

ASTM C150/C150M cements shall be combined with complementary cementing materials in the concrete mixture.

2.1.2 Blended Cements

Blended cement shall conform to ASTM C595/C595M, Type IP or IS, including the optional requirement for mortar expansion [and sulfate soundness] and consist of a mixture of ASTM C150/C150M Type I, or Type II cement and a complementary cementing material. The slag added to the Type IS blend shall be ASTM C989/C989M ground granulated blast-furnace slag. The pozzolan added to the Type IP blend shall be ASTM C618 Class F and shall be interground with the cement clinker. The manufacturer shall state in writing that the amount of pozzolan in the finished cement will not vary more than plus or minus 5 mass percent of the finished cement from lot-to-lot or within a lot. The percentage and type of mineral admixture used in the blend shall not change from that submitted for the aggregate evaluation and mixture proportioning.

2.1.3 Pozzolan

2.1.3.1 Fly Ash

NOTE: Class C fly ash is not permitted.

Use loss on ignition not exceeding 3 percent for frost areas to reduce carbon interference with air entraining admixture.

Fly ash shall conform to ASTM C618, Class F, including the optional requirements for uniformity and effectiveness in controlling Alkali-Silica reaction and shall have a loss on ignition not exceeding [3][6] percent. Class F fly ash for use in mitigating Alkali-Silica Reactivity shall have a Calcium Oxide (CaO) content of less than 8 percent and a total equivalent alkali content less than 1.5 percent. Add with cement.

2.1.3.2 Raw or Calcined Natural Pozzolan

Natural pozzolan shall be raw or calcined and conform to ASTM C618, Class N, including the optional requirements for uniformity and effectiveness in controlling Alkali-Silica reaction and shall have an on ignition loss not exceeding 3 percent. Class N pozzolan for use in mitigating Alkali-Silica Reactivity shall have a Calcium Oxide (CaO) content of less than 13 percent and total equivalent alkali content less than 3 percent.

2.1.3.3 Ultra Fine Fly Ash and Ultra Fine Pozzolan

Ultra Fine Fly Ash (UFFA) and Ultra Fine Pozzolan (UFP) shall conform to ASTM C618, Class F or N, and the following additional requirements:

- a. The strength activity index at 28 days of age shall be at least 95 percent of the control specimens.
- b. The average particle size shall not exceed 6 microns.
- c. The sum of SiO2 + Al2O3 + Fe2O3 shall be greater than 77 percent.

2.1.4 Ground Granulated Blast-Furnace (GGBF) Slag

Ground Granulated Blast-Furnace Slag shall conform to **ASTM C989/C989M**, [Grade 100 or Grade 120]. Add with cement.

2.1.5 Silica Fume

NOTE: Silica Fume shall only be used for OCONUS projects where Class F fly ash and GGBF slag are not available, and when approved by the Contracting Officer. Guidance for use of silica fume should be sought from the agency's Subject Matter Expert in Concrete Materials.

Silica fume shall conform to **ASTM C1240**, including the optional limits on reactivity with cement alkalis. Silica fume may be furnished as a dry, densified material or as slurry. Proper mixing is essential to accomplish proper distribution of the silica fume and avoid agglomerated silica fume which can react with the alkali in the cement resulting in premature and extensive concrete damage. Supervision at the batch plant, finishing, and curing is essential. Provide at the Contractor's expense the services of a manufacturer's technical representative, experienced in mixing, proportioning, placement procedures, and curing of concrete containing silica fume. This representative must be present on the project prior to and during at least the first 4 days of concrete production and placement using silica fume. A High Range Water Reducer (HRWR) shall be used with silica fume. Finishing may be more difficult. Proper curing is essential because there is a tendency for plastic shrinkage cracking.

2.1.6 Complementary Cementing Materials (AKA Supplementary Cementitious Materials (SCM) Content (SCM))

The concrete mix shall always contain complementary cementing materials whether or not the aggregates are found to be reactive in accordance with the subpart entitled "Aggregates". Concrete mixtures shall be designed and proportioned to meet the requirements for strength, constructability, shrinkage, and service life.

NOTE: This specification requires that the structural requirements (f'c) be met and concrete strength is between 1.0 f'c and 1.2 f'c. If the prequalified mixture as approved by the Engineer of Record should produce a higher design strength (fcr), that strength shall be used instead of f'c. Maintain required w/cm ratio regardless of strength requirements.

2.2 AGGREGATES

Comply with [ASTM C33/C33M](#) Class 4S, except as modified herein.

The quantities to be retained on each sieve may be adjusted only where available aggregates are elongated or slivered and cause interference with mix mobility, or available aggregate gradations do not comply with the 18-8 requirement. When necessary to satisfy local conditions and when permitted, the combined aggregate percentages may be changed to not more than 22 percent nor less than 6 percent retained on any individual sieve. The combined aggregates in the mixture (coarse, intermediate, and fine) shall be well graded with no more than 18 percent nor less than 8 percent of the combined aggregate retained on any individual sieve, unless satisfactory performance can be demonstrated. The [300 micrometers No. 50](#) sieve may have less than 8 percent retained; sieves finer than [300 micrometers No. 50](#) shall have less than 8 percent retained, and the coarsest sieve may have less than 8 percent retained. Use intermediate sizes for blending where necessary, to provide a well graded combined aggregate.

- a. Provide gradation of individual aggregate sizes using standard concrete aggregate sieves including [37.5 mm 1-1/2 inches](#), [25 mm one inch](#), [19 mm 3/4 inch](#), [12.5 mm 1/2 inch](#), [9.5 mm 3/8 inch](#), [4.75 mm No. 4](#), [2.36 mm No. 8](#), [1.18 mm No. 16](#), [600 micrometers No. 30](#), [300 micrometers No. 50](#), and [150 micrometers No. 100](#).
- b. Provide aggregates for exposed concrete from one source. Aggregate reactivity shall be limited per the subpart entitled "Aggregates". Provide aggregate containing no deleterious material properties as identified by [ASTM C295/C295M](#).
- c. Where a size designation is indicated, that designation indicates the nominal maximum size of the coarse aggregate.
- d. Aggregate tests shall be conducted within 6 months from the date of concrete mixture submittal.
- e. Provide [ASTM C1260](#) or [ASTM C1567](#) test results conducted with 6 months of the submittal date showing the proposed coarse and fine aggregates are either: innocuous to alkali silica reaction; or that reactivity has been mitigated by the proposed cementitious materials as modified herein. Conduct [ASTM C1260](#) tests on each aggregate source separately. Fine and coarse aggregates to be used in all concrete shall be evaluated and tested for alkali-aggregate reactivity. Both coarse aggregate size groups shall be tested. Test results of the individual aggregates shall have a measured expansion equal to or less than 0.08 percent after 28 days of immersion in a [1N 1M](#) NaOH solution at 176 degrees.
- f. Should the test data indicate an expansion of greater than 0.08 percent, the aggregate(s) shall be rejected or additional testing shall be performed as follows: utilize the Contractor's proposed low alkali portland cement, blended cement, and/or complementary cementing materials, in combination with each individual aggregate. If SCMs are being evaluated, the testing shall be in accordance with [ASTM C1567](#). Determine the quantity that will meet all the requirements of these specifications and that will lower the expansion equal to or less than 0.08 percent after 28 days of immersion in a 1N NaOH solution. Mixture proportioning shall be based on the highest percentage of SCM required

to mitigate ASR-reactivity.

2.3 WATER

Water shall comply with the requirements of [ASTM C94/C94M](#) and [ASTM C1602/C1602M](#), except that the chloride and sulfate limits as tested in accordance with [ASTM D512](#) and [ASTM D516](#) shall not exceed 500 parts per million chloride ion and not more than 1000 parts per million of sulfate ion as SO₄. Water shall be free from injurious amounts of oils, acids, alkalis, salts, and organic materials. Where non-potable water or water from reprocessed concrete is proposed for use in the work, submit results of tests in accordance with [ASTM C1602/C1602M](#). Submit test results in accordance with [ASTM D512](#) and [ASTM D516](#).

2.4 ADMIXTURES

- a. Provide certifications that chemical admixtures comply with the requirements shown in Table 5 and are compatible with each other. Use admixtures in accordance with manufacturer's recommendations, as appropriate for the climatic conditions and construction needs.
- b. Do not use calcium chloride or admixtures containing chloride ion content in more than trace amounts from impurities in admixture ingredients or potable water. Provide maximum concentrations of corrosion-inducing chemicals as shown in Table 5. For concrete that may be in contact with prestressing steel tendons, the concentration shall not exceed 60 percent of the limits given in Table 5. For the concentration in grout for prestressing ducts, do not exceed 25 percent of the limits in Table 5.

Chemical*	Limits, Percent**	Test Method
Chlorides	0.10	ASTM D512
Fluorides	0.10	ASTM D1179
Nitrates	0.17	ASTM D3867
* Limits refer to water-soluble chemicals		
** Limits are expressed as a percentage of the mass of the total cementitious materials.		

- c. Provide anti-washout or viscosity modifying admixtures for underwater concrete placement. Provide certification that the admixture is compatible with the cementitious materials and other chemical admixtures in the proposed concrete mixture. The anti-washout or viscosity modifying admixture shall require approval by the Contracting Officer and have a proven record of performance with a minimum of five similar projects. Test per [COE CRD-C 61](#) to determine cumulative mass loss shall be performed once for each [267.6 cubic meters](#) [350 cubic yards](#) of underwater concrete and results submitted to Contracting Officer for approval prior to continued use.
- d. The total alkali contribution of chemical admixtures shall not increase

the total sodium-oxide equivalent content of the concrete mixture by more than 0.3 kg/m³ 0.5 lb/yd³.

2.4.1 Air Entraining

Provide air entraining admixtures conforming to ASTM C260/C260M

2.4.2 Accelerating

ASTM C494/C494M, Type C.

2.4.3 Retarding

ASTM C494/C494M, Type B, D, or G.

2.4.4 Water Reducing

ASTM C494/C494M, Type A, E, or F.

High Range Water Reducer (HRWR) shall be ASTM C494/C494M, Type F and ASTM C1017/C1017M.

2.4.5 Corrosion Inhibitors

Corrosion inhibitors are considered "supplemental corrosion protection". Adjust the quantity of concrete mixing water for the mass of water in the admixture. Accelerating and set adjusted versions are acceptable. Concrete setting time and mixture workability shall be evaluated. The use of supplemental corrosion protection shall not be used in lieu of the fundamental requirement to meet the defined service life using quality concrete with specified concrete cover over the steel reinforcing. Changes to the corrosion propagation period that is calculated for quality concrete due to the use of supplemental corrosion protection materials may be approved by the Contracting Officer based on evidence provided by the Contractor and reviewed by the agency's Subject Matter Expert in Concrete Materials on a case-by-case basis.

2.5 NON-SHRINK GROUT

ASTM C1107/C1107M.

2.6 MATERIALS FOR FORMS

Provide wood, plywood, or steel. Use plywood or steel forms where a smooth form finish is required. Lumber shall be square edged or tongue-and-groove boards, free of raised grain, knotholes, or other surface defects.

Plywood: APA PS 1, B-B concrete form panels or better. Steel form surfaces shall not contain irregularities, dents, or sags.

2.6.1 Form Ties and Form-Facing Material

- a. Provide a form tie system that does not leave mild steel after break-off or removal any closer than 50 mm 2 inches from the exposed surface. Do not use wire alone. Form ties and accessories shall not reduce the effective cover of the reinforcement.
- b. Form-facing material shall be structural plywood or other material that can absorb air and some of the high water-cementitious materials ratio

surface paste that may be trapped in pockets between the form and the concrete. Maximum reuse is three times. Provide forms with a form treatment to prevent bond of the concrete to the forms. Use a controlled permeability form liner in strict accordance with the manufacturer's recommendations.

2.7 REINFORCEMENT

2.7.1 Prestressing Steel

NOTE: Use prestressing in fender and bearing piles, deck soffits, and wherever possible. Post-tensioning of pile caps and decks is recommended where feasible. Do not mix coated prestressing strands and plain prestressing strands. This will produce a large corrosion cell between the plain strand and any defect in the coated strand.

Use seven-wire stress-relieved or low-relaxation strand conforming to ASTM A416/A416M, Grade 270. Use of indented seven-wire stress-relieved or low-relaxation strand conforming to ASTM A882/A882M, Grade 270; or epoxy-filled seven-wire stress-relieved or low-relaxation strand conforming to ASTM A886/A886M, Grade 270 shall be permitted in lieu of prestressing steel conforming to ASTM A416/A416M. Use prestressing steel free of grease, oil, wax, paint, soil, dirt, and loose rust. Do not use prestressing strands or wire having kinks, bends, or other defects.

2.7.2 Reinforcing Bars

NOTE: It is intended that plain steel rebar with specified concrete cover of 75 mm 3.0 inches shall normally be specified according to applicable codes. Predictive modeling can confirm that the candidate concrete mixture, type of steel and concrete cover will yield the required service life for the particular structural element under consideration. For the purpose of predicting the service life of the concrete, the design shall meet the owner's design life without relying on a barrier such as epoxy or zinc coating of the steel rebar or passive cathodic protection for additional life extension. The use of galvanized rebar and epoxy-coated rebar are acceptable for use, but it is difficult to justify a specific life extension from either without conclusive research data.

ASTM A706/A706M bars are mainly used in seismic design or for welding. Do not mix coated rebar and plain reinforcing bars. This may produce a large corrosion cell between the plain bar and any defect in the coated bar.

ACI 301M ACI 301 unless otherwise specified and shall meet the design yield strength and ductility requirements. Deformed reinforcing bars meeting the

requirements of [ASTM A615/A615M](#) with the bars marked A, Grade [ASTM A276](#) stainless steel bars; [ASTM A767/A767M](#) Class 1 galvanized; prefabricated epoxy coated, [ASTM A934/A934M](#); [ASTM A955/A955M](#) stainless steel bars; [ASTM A1035/A1035M](#) MMFX2 bars; [ASTM A1055/A1055M](#) Z bars; or other approved reinforcing material shall be permitted for use in the cast-in-place concrete system.

The reinforcing selected shall match the structural properties of the reinforcing specified. Alternative reinforcing bars shall have similar structural properties to the specified reinforcing and may be used with the Contracting Officers approval.

2.7.2.1 Reinforcement and Protective Coating

Provide coating manufacturer's and coating applicator's test data sheets certifying that applied coating meets the requirements of the concrete system. Extensions to the corrosion propagation period may be approved by the Contracting Officer based on evidence provided by the Contractor and reviewed by the agency's Subject Matter Expert in Concrete Materials on a case-by-case basis.

2.7.3 Mechanical Reinforcing Bar Connectors

[ACI 301M ACI 301](#). Provide 125 percent minimum yield strength of the reinforcement bar. Coat connectors in accordance with the requirements of the reinforcing bars.

2.7.4 Welded Wire Fabric

Comply with [ASTM A185/A185M](#) or [ASTM A497/A497M](#) carbon steel. Provide flat sheets of welded wire fabric for slabs and toppings.

2.7.5 Wire

Comply with [ASTM A82/A82M](#) or [ASTM A496/A496M](#) carbon steel.

2.8 ACCESSORY MATERIALS

2.8.1 Polyvinylchloride Waterstops

[COE CRD-C 572](#).

2.8.2 Materials for Curing Concrete

2.8.2.1 Impervious Sheeting

[ASTM C171](#); waterproof paper, clear or white polyethylene sheeting, or polyethylene-coated burlap.

2.8.2.2 Pervious Sheeting

[AASHTO M 182](#) or carpet covering the free surface and kept continuously wet throughout the curing period..

2.8.2.3 Liquid Membrane-Forming Compound

Comply with [ASTM C309](#), white-pigmented, Type 2, Class B.

2.8.3 Liquid Chemical **Sealer-Hardener** Compound

Provide magnesium fluosilicate compound which when mixed with water seals and hardens the surface of the concrete. Do not use on exterior slabs exposed to freezing conditions. Compound shall not reduce the adhesion of resilient flooring, tile, paint, roofing, waterproofing, or other material applied to concrete.

2.8.4 Expansion/Contraction **Joint Filler**

Comply with **ASTM D1751** or **ASTM D1752**, 13 mm 1/2 inch thick unless otherwise indicated.

2.8.5 **Joint Sealants**

2.8.5.1 Horizontal Surfaces

NOTE: For horizontal surfaces subject to jet fuel, specify section 32 01 19 FIELD MOLDED SEALANTS FOR SEALING JOINTS IN RIGID PAVEMENTS.

Horizontal surfaces are defined as all surfaces with a 3 percent maximum slope. **ASTM D6690** or **ASTM C920**, Type M, Class 25, Use T.

2.8.5.2 Vertical Surfaces

NOTE: Specify ASTM C920 for vertical surfaces greater than 3 percent slope and not subject to jet fuel, gasoline, fuel oil, etc. For vertical surfaces greater than 3 percent slope and subject to jet fuel, specify FS SS-S-200, no sag.

Vertical surfaces are defined as all surfaces with a slope greater than 3 percent. **ASTM C920**, Type M, Grade NS, Class 25, Use T. **FS SS-S-200**, no sag.

PART 3 EXECUTION

3.1 FORMS

- a. Provide formwork with clean-out openings to permit inspection and removal of debris. Formwork shall be gasketed or otherwise rendered sufficiently tight to prevent leakage of paste or grout under heavy, high-frequency vibration. Use a release agent that does not cause surface dusting. Limit reuse of plywood to no more than three times. Reuse may be further limited by the Contracting Officer if it is found that the pores of the plywood are clogged with paste so that the wood does not absorb air and some of the high water-cementitious materials ratio paste that may be trapped in pockets between the form and the concrete.
- b. Comply with **ACI 301M ACI 301**. Concrete for footings may be placed in excavations without forms upon inspection and approval by the Contracting Officer. Excavation width shall be a minimum of 100 mm 4 inches greater than indicated. Set forms rigidly, mortar-tight, and true to line and grade. Chamfer above grade exposed joints, edges, and

external corners of concrete 20 mm 0.75 inch unless otherwise indicated. Forms submerged in water shall be watertight.

- c. Patch form tie holes with a no shrink patching material in accordance with the manufacturer's recommendations and subject to approval.

3.1.1 Coating

Before concrete placement, coat the contact surfaces of forms with a no staining mineral oil, no staining form coating compound, or two coats of nitrocellulose lacquer. Do not use mineral oil on forms for surfaces to which adhesive, paint, or other finish material is to be applied.

3.1.2 Removal of Forms and Supports

After placing concrete, forms shall remain in place for the time periods specified in ACI 347, except for concrete placed underwater, forms shall remain in place a minimum of 48 hours. Prevent concrete damage during form removal.

3.1.2.1 Special Requirements for Reduced Time Period

Forms may be removed earlier than specified if ASTM C39/C39M test results of field-cured samples from a representative portion of the structure or other approved and calibrated non-destructive testing techniques show that the concrete has reached a minimum of 85 percent of the design strength.

3.1.3 Reshoring

Do not allow construction loads to exceed the superimposed load which the structural member, with necessary supplemental support, is capable of carrying safely and without damage. Reshore concrete elements where forms are removed prior to the specified time period. Do not permit elements to deflect or accept loads during form stripping or reshoring. Forms on columns, walls, or other load-bearing members may be stripped after 2 days if loads are not applied to the members. After forms are removed, slabs and beams over 3 meters 10 feet in span and cantilevers over 1.2 meters 4 feet shall be reshored for the remainder of the specified time period in accordance with subpart entitled "Removal of Forms and Supports." Perform reshoring operations to prevent subjecting concrete members to overloads, eccentric loading, or reverse bending. Reshoring elements shall have the same load-carry capabilities as original shoring and shall be spaced similar to original shoring. Firmly secure and brace reshoring elements to provide solid bearing and support.

3.2 PLACING REINFORCEMENT AND MISCELLANEOUS MATERIALS

ACI 301M ACI 301. Remove rust, scale, oil, grease, clay, or foreign substances from reinforcing that would reduce the epoxy coating bond from reinforcing. Do not tack weld. Inspect and verify proper reinforcement grade, quantity, spacing, and clearance requirements prior to concrete placement. Inspect placed steel reinforcing for coating damage prior to placing concrete. Repair all visible damage.

3.2.1 Coated Reinforcing

The use of supplemental corrosion protection shall not be used in lieu of the fundamental requirement to meet the defined service life. Extensions to corrosion propagation period may be approved by the Contracting Officer

based on evidence provided by the Contractor and reviewed by the agency's Subject Matter Expert in Concrete Materials on a case-by-case basis.

Record coating lot on each shipping notice and carefully identify and re-tag bar bundles from bending plant. Provide systems for handling coated bars which have padded contact areas, nylon slings, etc., to keep bars free of dirt and grit. Carefully handle and install bars to minimize job site patching including lifting and supporting bundled coated bars with strong back, multiple supports, or platform bridge to prevent sagging and abrasion. When possible, assemble reinforcement as tied cages prior to final placement into the forms. Bundling bands shall be padded where in contact with bars. Do not drop or drag bars or bundles. Store coated bars both in shop and in field, aboveground, on wooden or padded cribbing with adequate protective blocking between layers. Schedule deliveries of coated bars to the job site to avoid the need for long term storage. Protect from direct sunlight and weather. Bars to be stored longer than 12 hours at the job site shall be covered with opaque polyethylene sheeting or other suitable equivalent protective material. Inspect for defects and provide required repairs prior to assembly. After assembly, reinspect and provide final repairs. Excessive nicks and scrapes which expose steel shall be cause for rejection.

- a. Immediately prior to application of the patching material, any rust and debonded coating shall be manually removed from the reinforcement by suitable techniques employing devices such as wire brushes and emery paper. Care shall be exercised during this surface preparation so that the damaged areas are not enlarged more than necessary to accomplish the repair. Damaged areas shall be clean of dirt, debris, oil, and similar materials prior to application of the patching material.
- b. Repair and patching shall be done in accordance with the patching material manufacturer's recommendations. These recommendations, including cure times, shall be available at the job site at all times.
- c. Allow adequate time for the patching materials to cure in accordance with the manufacturer's recommendation prior to concrete placement.
- d. Rinse placed reinforcing bars with **ASTM C1602/C1602M** compliant water to remove chloride contamination prior to placing concrete.

3.2.2 Reinforcement Supports

Place reinforcement and secure with non-corrodible chairs, spacers, and hangers. Metal hangers may be used, but shall be of similar material to the reinforcing. Support reinforcement on the ground with concrete or other non-corrodible material, having a compressive strength equal to or greater than the concrete being placed and having permeability equal or less than the concrete being placed.

Coated reinforcing bars supported from formwork shall rest on coated wire bar supports, or on bar supports made of dielectric material or other acceptable material. Wire bar supports shall be coated with dielectric material, compatible with concrete, for a minimum distance of **50 mm 2 inches** from the point of contact with the coated reinforcing bars. Reinforcing bars used as support bars shall be coated with the same material as the reinforcing. Spreader bars, where used, shall be coated. Non-coated combination bar clips and spreaders used in construction with coated reinforcing bars shall be made corrosion resistant or coated with dielectric material. Coated bars shall be tied with plastic-coated tie

wire; or other materials acceptable to the Contracting Officer.

3.2.3 Splicing

As indicated. For splices not indicated, comply with **ACI 301M ACI 301**. Do not splice at points of maximum stress. Overlap welded wire fabric the spacing of the cross wires, plus **50 mm 2 inches**. Welded splices shall comply with **AWS D1.4/D1.4M** and be approved prior to use.

3.2.4 Future Bonding

Plug exposed, threaded, mechanical reinforcement bar connectors with a greased bolt. Bolt threads shall match the connector. Countersink the connector in the concrete. Caulk the depression after the bolt is installed.

3.2.5 Cover

NOTE: Uniform, high quality concrete cover over the steel reinforcement is critically important for long-term durability.

As a minimum, comply with **ACI 318M ACI 318** for concrete cover over the steel reinforcement. The cover may be greater than that required by **ACI 318M ACI 318** based on the results from service life modeling. Use **ACI 117** to determine allowable tolerances for the placement of the steel. When predicting service life, use the effective value of concrete cover after subtracting the allowable placement tolerances for the reinforcing. For example a specified **76.2 mm 3 inch** cover will result in about **63.5 mm 2.5 inches** of effective concrete cover for predicting service life.

3.2.6 Setting Miscellaneous Material and Prestress Anchorages

Place and secure anchors, bolts, pipe sleeves, conduits, and other such items in position before concrete placement. Plumb anchor bolts and check location and elevation. Temporarily fill voids in sleeves with readily removable material to prevent the entry of concrete. Electrically isolate exposed steel work and its anchor systems from the primary steel reinforcement with at least **50 mm 2 inches** of concrete. Coat exposed steel work to reduce corrosion. Take particular care to ensure against corrosion on edges and horizontal surfaces. Use epoxy coatings for protection of carbon steel plates and fittings.

3.2.7 Construction Joints

Locate joints to least impair strength. Continue reinforcement across joints unless otherwise indicated. Final joint locations are subject to Government approval or substantiating calculations from the Contractor.

3.2.8 Expansion Joints and Contraction Joints

Provide expansion joint at edges of interior floor slabs on grade abutting vertical surfaces, and as indicated. Make expansion joints **13 mm 1/2 inch** wide unless indicated otherwise. Fill expansion joints not exposed to weather with **preformed joint filler** material. Completely fill joints exposed to weather with joint filler material and joint sealant. Do not extend reinforcement or other embedded metal items bonded to the concrete

through any expansion joint unless an expansion sleeve is used. Place contraction joints, either formed or saw cut or cut with a jointing tool, to the indicated depth after the surface has been finished. Sawed joints shall be completed within 4 to 12 hours after concrete placement. Protect joints from intrusion of foreign matter.

3.2.9 Waterstop Splices

Fusion weld in the field.

3.2.10 Pits and Trenches

Place bottoms and walls monolithically or provide waterstops and keys.

3.3 BATCHING, MEASURING, MIXING, AND TRANSPORTING CONCRETE

ASTM C94/C94M, ACI 301M ACI 301, and ACI 304R, except as modified herein. Batching equipment shall be such that the concrete ingredients are consistently measured within the following tolerances: 1 percent for cement and water, 2 percent for aggregate, and 3 percent for admixtures. Furnish mandatory batch tickets imprinted with mix identification, batch size, batch design and measured weights, moisture in the aggregates, and time batched for each load of ready mix concrete. When a pozzolan is batched cumulatively with the cement, it shall be batched after the cement has entered the weight hopper.

3.3.1 Measuring

Make measurements at intervals as specified in subparts entitled "Sampling" and "Testing."

Adjust batch proportions to replicate the mixture design using methods provided in the approved quality assurance plan. Base the adjustments on results of tests of materials at the batch plant for use in the work. Maintain a full record of adjustments and the basis for each.

3.3.2 Mixing

Comply with ASTM C94/C94M and ACI 301M ACI 301. If time of discharge exceeds time required by ASTM C94/C94M, submit a request along with description of precautions to be taken.

3.3.3 Transporting

Comply with ACI 304R.

3.4 PLACING CONCRETE

Comply with ACI 304R and ACI 304.2R. Place concrete as soon as practicable after the forms and the reinforcement have been inspected and approved. Do not place concrete when weather conditions prevent proper placement and consolidation; in uncovered areas during periods of precipitation; or in standing water. Prior to placing concrete, remove dirt, construction debris, water, snow, and ice from within the forms. Deposit concrete as close as practicable to the final position in the forms. Do not exceed a free vertical drop of one m 3 feet from the point of discharge. Place concrete in one continuous operation from one end of the structure towards the other or lifts for vertical construction. Position grade stakes on 6 m 20 foot centers maximum for exterior slabs.

3.4.1 Vibration

NOTE: The requirement for vibrator spacing shall be considered in the reinforcing steel design by the engineer of record. ACI SP-66 requires that bar bundling be done by the design engineer. It is very important to provide space for placement and consolidation of concrete.

Comply with the requirements of **ACI 309R** [and **ASTM A934/A934M** for epoxy-coated bar] using vibrators with a minimum frequency of 9000 vibrations per minute (VPM). Use only high cycle or high frequency vibrators. Motor-in-head 60 cycle vibrators may not be used. For walls and deep beams, use a minimum of two vibrators with the first to melt down the mixture and the second to thoroughly consolidate the mass. Provide a spare vibrator at the casting site whenever concrete is placed. Place concrete in **500 mm 18 inch** maximum vertical lifts. Insert and withdraw vibrators approximately **500 mm 18 inches** apart. Penetrate at least **200 mm 8 inches** into the previously placed lift with the vibrator when more than one lift is required. Extract the vibrator using a series of up and down motions to drive the trapped air out of the concrete and from between the concrete and the forms.

For slab construction use vibrating screeds designed to consolidate the full depth of the concrete. Where beams and slabs intersect, use an internal vibrator to consolidate the beam. Do not vibrate concrete placed with anti-washout admixtures. Vibrators shall be equipped with rubber vibrator heads.

3.4.2 Cold Weather

Comply with **ACI 306R**. Do not allow concrete temperature to decrease below **10 degrees C 50 degrees F**. Obtain approval prior to placing concrete when ambient temperature is below **4 degrees C 40 degrees F** or when concrete is likely to be subjected to freezing temperatures within 24 hours. Placement of concrete shall be halted whenever the ambient temperature drops below **5 degrees C 40 degrees F**. When the ambient temperature is less than **10 degrees C 50 degrees F** the temperature of the concrete when placed shall be not less than **10 degrees C 50 degrees F** or more than **25 degrees C 75 degrees F**. Heating of the mixing water or aggregates may be necessary to regulate the concrete placing temperature. An accelerating admixture may be used when the ambient temperature is below **10 degrees C 50 degrees F**. Covering and other means shall be provided for maintaining the concrete at a temperature of at least **10 degrees C 50 degrees F** for not less than 7 days after placing, and at a temperature above freezing for the remainder of the curing period..

3.4.3 Hot Weather

Comply with **ACI 305R**. Maintain required concrete temperature using Figure 2.1.5, "Effect of Concrete Temperatures, Relative Humidity, and Wind Velocity on the Rate of Evaporation of Surface Moisture From Concrete" in **ACI 305R** to prevent the evaporation rate from exceeding **one kg per square meter 0.2 pound of water per square foot** of exposed concrete per hour. If necessary, cool ingredients before mixing or use other suitable means to control concrete temperature and prevent rapid drying of newly placed

concrete. Shade the fresh concrete as soon as possible after placing. Start curing when the surface of the fresh concrete is sufficiently hard to permit curing without damage. If the evaporation rate exceeds 0.5 kg per square meter 0.1 pound of water per square foot per hour, fog spray the exposed concrete surfaces until active moist curing is applied. Provide water hoses, pipes, spraying equipment, and water hauling equipment, where job site is remote to water source, to maintain a moist concrete surface throughout the curing period. Provide burlap cover or other suitable, permeable material with fog spray or continuous wetting of the concrete when weather conditions prevent the use of either liquid membrane curing compound or impervious sheets. For vertical surfaces, protect forms from direct sunlight and add water to top of structure once concrete is set.

3.4.4 Prevention of Plastic Shrinkage Cracking

During weather with low humidity, and particularly with high temperature and appreciable wind, develop and institute measures to prevent plastic shrinkage cracks from developing. If plastic shrinkage cracking occurs, halt further placement of concrete until protective measures are in place to prevent further cracking. Periods of high potential for plastic shrinkage cracking can be anticipated by use of Figure 2.1.5 of ACI 305R. In addition to the protective measures concrete placement shall be further protected by erecting shades and windbreaks and by applying fog sprays of water, the addition of monomolecular films, or wet covering. When such water treatment is stopped, curing procedures shall be immediately commenced. The methods and materials to remove or repair areas affected by plastic shrinkage cracks shall be suggested by the Contractor, reviewed by the agency's Subject Matter Expert in Concrete Materials, and approved by the Contracting Officer. Cracks shall never be troweled over or filled with cement slurry.

3.4.5 Mass Concrete

All mass concrete elements shall be placed per the requirements of the Mass Concrete Temperature Control Plan.

3.4.6 Depositing Concrete Under Water

ACI 301M ACI 301 methods and equipment used shall prevent the washing of the cement from the mixture, minimize the formation of laitance, prevent the flow of water through the concrete before it has hardened, and minimize disturbance to the previously placed concrete. Tremies, if used, shall be watertight and sufficiently large to permit a free flow of concrete. Keep the discharge end continuously submerged in fresh concrete. Keep the shaft full of concrete to a level well above the water surface. Discharge and spread the concrete by raising the tremie to maintain a uniform flow. Place concrete without interruption until the top of the fresh concrete is at the required height.

3.5 SURFACE FINISHES EXCEPT FLOOR, SLAB, AND PAVEMENT

3.5.1 Defects

Repair formed surfaces by removing minor honeycombs, pits greater than 600 square mm one square inch surface area or 6 mm 0.25 inch maximum depth, or otherwise defective areas. Provide edges perpendicular to the surface and patch with non-shrink grout. Patch tie holes and defects when the forms are removed. Concrete with extensive honeycomb including exposed steel reinforcement, cold joints, entrapped debris, separated aggregate, or other

defects which affect the serviceability or structural strength will be rejected, unless correction of defects is approved. Obtain approval of corrective action prior to repair. The surface of the concrete shall not vary more than the allowable tolerances of ACI 347. Exposed surfaces shall be uniform in appearance and finished to a smooth form finish unless otherwise indicated.

3.5.2 Formed Surfaces

3.5.2.1 Tolerances

Comply with ACI 117 and as indicated.

3.5.2.2 As-Cast Rough Form

Provide for surfaces not exposed to public view. Patch holes and defects and level abrupt irregularities. Remove or rub off fins and other projections exceeding 6 mm 0.25 inch in height.

3.5.2.3 As-Cast Form

Provide form facing material producing a smooth, hard, uniform texture on the concrete. Arrange facing material in an orderly and symmetrical manner and keep seams to a practical minimum. Support forms as necessary to meet required tolerances. Material with raised grain, torn surfaces, worn edges, patches, dents, or other defects which will impair the texture of the concrete surface shall not be used. Patch tie holes and defects and completely remove fins.

3.6 FINISHES FOR HORIZONTAL CONCRETE SURFACES

3.6.1 Finish

Comply with ACI 301M ACI 301. Place, consolidate, and immediately strike off concrete to obtain proper contour, grade, and elevation before bleedwater appears. Permit concrete to attain a set sufficient for floating and supporting the weight of the finisher and equipment. If bleedwater is present prior to floating the surface, drag excess water off or remove by absorption with porous materials. Do not use dry cement to absorb bleedwater.

3.6.1.1 Scratched

Use for surfaces intended to receive bonded applied cementitious applications. After the concrete has been placed, consolidated, struck off, and leveled, the surface shall be roughened with stiff brushes or rakes before final set.

3.6.1.2 Floated

Exterior slabs where not otherwise specified. After the concrete has been placed, consolidated, struck off, and leveled, do not work the concrete further, until ready for floating. Whether floating with a wood, magnesium, or composite hand float, with a bladed power trowel equipped with float shoes, or with a powered disc, float shall begin when the surface has stiffened sufficiently to permit the operation.

3.6.1.3 Broomed

Perform a floated finish, then draw a broom or burlap belt across the surface to produce a coarse scored texture. Permit surface to harden sufficiently to retain the scoring or ridges. Broom transverse to traffic or at right angles to the slope of the slab.

3.6.1.4 Pavement

Screed the concrete with a template advanced with a combined longitudinal and crosswise motion. Maintain a slight surplus of concrete ahead of the template. After screeding, float the concrete longitudinally. Use a straightedge to check slope and flatness; correct and refloat as necessary. Obtain final finish by a burlap drag. Drag a strip of clean, wet burlap from 900 to 3000 mm wide and 600 mm longer 3 to 10 feet wide and 2 feet longer than the pavement width across the slab . Produce a fine, granular, sandy textured surface without disfiguring marks. Round edges and joints with an edger having a radius of 3 mm 1/8 inch.

3.6.1.5 Concrete Toppings Placement

Remove dirt, laitance, and loose aggregate by means of a stiff wire broom. Keep the base wet for a period of 12 hours preceding the application of the topping. Remove excess water prior to the topping placement. Do not allow temperature differential between the completed base and the topping to exceed 6 degrees C 10 degrees F at the time of placing. Place the topping and finish as specified for pavement.

3.7 CURING AND PROTECTION

Comply with ACI 301M ACI 301 and ACI 308.1 unless otherwise specified. Prevent concrete from drying by misting surface of concrete. Begin curing immediately following final set. Avoid damage to concrete from vibration created by blasting, pile driving, movement of equipment in the vicinity, disturbance of formwork or protruding reinforcement, by rain or running water, adverse weather conditions, and any other activity resulting in ground vibrations. Protect concrete from injurious action by sun, rain, flowing water, frost, mechanical injury, tire marks, and oil stains. Do not allow concrete to dry out from time of placement until the expiration of the specified curing period. Do not use membrane-forming compound on surfaces where appearance would be objectionable, on any surface to be painted, where coverings are to be bonded to the concrete, or on concrete to which other concrete is to be bonded. If forms are removed prior to the expiration of the curing period, provide another curing procedure specified herein for the remaining portion of the curing period. Provide moist curing for those areas receiving liquid chemical sealer-hardener or epoxy coating.

NOTE: When the use of alkali-reactive aggregates is permitted, add the following paragraph.

[Furnish ASTM C39/C39M test results to verify the anticipated rate of strength development for the proposed concrete design mixture. Submit an increased curing period and minimum time to strip formwork based upon the reduced rate of strength development.]

3.7.1 Wet Curing

Wet cure marine concrete using ASTM C1602/C1602M compliant water for a minimum of 7 days. Do not allow construction loads to exceed the superimposed load which the structural member, with necessary supplemental support, is capable of carrying in current condition safely and without damage.

Leaving the forms in place for seven days is a suitable alternative to wet curing.

3.7.1.1 Ponding or Immersion

Continually immerse the concrete throughout the seven-day curing period. Water shall not be 11 degrees C 20 degrees F less than the temperature of the concrete. For temperatures between 4 and 10 degrees C 40 and 50 degrees F, increase the curing period by 50 percent.

3.7.1.2 Fog Spraying or Sprinkling

Apply water uniformly and continuously throughout the curing period. For temperatures between 4 and 10 degrees C 40 and 50 degrees F, increase the curing period by 50 percent.

3.7.1.3 Pervious Sheeting

Completely cover surface and edges of the concrete with two thicknesses of wet sheeting. Overlap sheeting 150 mm 6 inches over adjacent sheeting. Sheeting shall be at least as long as the width of the surface to be cured. During application, do not drag the sheeting over the finished concrete or over sheeting already placed. Wet sheeting thoroughly and keep continuously wet throughout the curing period.

3.7.1.4 Impervious Sheeting

Wet the entire exposed surface of the concrete thoroughly with a fine spray of water and cover with impervious sheeting throughout the curing period. Lay sheeting directly on the concrete surface and overlap edges 300 mm 12 inches minimum. Provide sheeting not less than 450 mm 18 inches wider than the concrete surface to be cured. Secure edges and transverse laps to form closed joints. Repair torn or damaged sheeting or provide new sheeting. Cover or wrap columns, walls, and other vertical structural elements from the top down with impervious sheeting; overlap and continuously tape sheeting joints; and introduce sufficient water to soak the entire surface prior to completely enclosing.

3.7.2 Liquid Membrane-Forming Curing Compound

NOTE: Stay in place forms and moist curing are the preferred method for curing concrete. Use of a liquid membrane-forming curing compound is only permitted when approved by the Contracting Officer.

Seal or cover joint openings prior to application of curing compound. Prevent curing compound from entering the joint. Apply in accordance with the recommendations of the manufacturer immediately after any water sheen which may develop after finishing has disappeared from the concrete

surface. Provide and maintain compound on the concrete surface throughout the curing period. Do not use this method of curing where the use of Figure 2 .1.5, "effect of Concrete Temperatures, Relative Humidity, and Wind Velocity on the Rate of Evaporation of Surface Moisture From Concrete" in ACI 305R indicates that hot weather conditions will cause an evaporation rate exceeding one kg pf water per square meter per hour 0.2 pound of water per square foot per hour.

3.7.2.1 Application

Mechanically agitate curing compound thoroughly during use. Use approved power-spraying equipment to uniformly apply two coats of compound in a continuous operation. The total coverage for the two coats shall be 5 square meters maximum per L 200 square feet maximum per gallon of undiluted compound unless otherwise recommended by the manufacturer's written instructions. The compound shall form a uniform, continuous, coherent film that will not check, crack, or peel. Immediately apply an additional coat of compound to areas where the film is defective. Respray concrete surfaces subjected to rainfall within 3 hours after the curing compound application.

3.7.2.2 Protection of Treated Surfaces

Prohibit pedestrian and vehicular traffic and other sources of abrasion at least 72 hours after compound application. Maintain continuity of the coating for the entire curing period and immediately repair any damage.

3.7.3 Liquid Chemical Sealer-Hardener

Apply the sealer-hardener in accordance with manufacturer's recommendations. Seal or cover joints and openings in which joint sealant is to be applied as required by the joint sealant manufacturer. The sealer-hardener shall not be applied until the concrete has been moist cured and has aged for a minimum of 30 days. Apply a minimum of two coats of sealer-hardener.

3.7.4 Curing Periods

NOTE: Add the following if concrete will be
underwater: [Cure land-cast elements for a minimum
of 7 days prior to submerging].

Moist cure concrete using ASTM C1602/C1602M compliant water for a minimum of 7 days. Continue additional curing for a total period of 21 days. Begin curing immediately after placement. Protect concrete from premature drying, excessively hot temperatures, and mechanical injury; and maintain minimal moisture loss at a relatively constant temperature for the period necessary for hydration of the cement and hardening of the concrete. The materials and methods of curing shall be subject to approval by the Contracting Officer.

3.8 FIELD QUALITY CONTROL

NOTE: Consider the size and complexity of job to
determine if all tests are required.

3.8.1 Fresh Concrete Properties

For each concrete mixture, the Contractor shall take samples in accordance with ASTM C172/C172M, test and record the slump, and temperature. If the slump deviates from the previous batch by more than 25.4 mm 1 inch, air content shall also be determined. Adjustment of air content and/or slump with chemical admixture is permitted provided the water to cementitious material ratio is not exceeded.

3.8.1.1 Slump Tests

ASTM C143/C143M. Take concrete samples during concrete placement. The maximum slump may be increased as specified with the addition of an approved high range water reducing (HRWR) admixture provided that the water-cementitious ratio is not exceeded. Perform tests at commencement of concrete placement, when test cylinders are made, and for each batch (minimum) or every 40 cubic meters 50 cubic yards (maximum) of concrete. If concrete does not pass slump test, adjust using a HRWR and test every concrete batch until two (2) consecutive batches meet slump without adjustment.

3.8.1.2 Temperature Tests

- a. Test the concrete delivered and the concrete in the forms. Perform tests in hot or cold weather conditions below 10 degrees C and above 27 degrees C below 50 degrees F and above 80 degrees F for each batch (minimum) or every 40 cubic meters 50 cubic yards (maximum) of concrete, until the specified temperature is obtained, and whenever test cylinders and slump tests are made.
- b. Determine temperature of each concrete sample in accordance with ASTM C1064/C1064M. Temperatures must comply with the Concrete Temperature Control Plans.

3.8.1.3 Air Content Tests

ASTM C231/C231M or ASTM C173/C173M. Perform tests at commencement of concrete placement each day, when test cylinders are made, and if slump test varies by more than 25.4 mm 1 inch from previous results or concrete does not pass slump test.

3.8.1.4 Unit Weight Test

ASTM C138/C138M. Take concrete samples during concrete placement. Perform tests at commencement of concrete placement, when test cylinders are made, and for each batch (minimum) or every 38.2 cubic meters 50 cubic yards (maximum) of concrete.

3.8.2 Hardened Concrete Properties

NOTE: The Engineer of Record must specify the frequency of testing during the construction phase. Sufficient testing must be done to maintain confidence that the concrete, as delivered and placed, remains consistent. For example: sample and test every 75 cubic meters 100 cubic yards for the first 382 cubic meters 500 cubic yards, then every

382 cubic meters 500 cubic yards once confidence is established in uniformity. However, this is only a guideline, and the owner and Engineer of Record should agree on the frequency of sampling as best suits the particulars of each project and budget.

For example, a sampling interval for a new pier may be as follows:

- o During the first week of casting piles
- o During the second week of casing piles
- o Midway through the casting of all piles
- o During the final week of casting piles
- o At the first pile cap and every tenth bent thereafter
- o During the two first concrete deck pours
- o During the final concrete deck pour

Sample and test each lot at [75] cubic meters [100] cubic yards for the first [382] cubic meters [500] cubic yards, then every [382] cubic meters [500] cubic yards thereafter.

Cast and cure specimens in accordance with ASTM C172/C172M, ASTM C31/C31M, and applicable requirements of ACI 305R and ACI 306R.

For each lot, record the date and time sampled, the batch ticket code, cylinder ID code the location of placement, total volume of concrete represented by the sample, and fresh concrete properties; ASTM C143/C143M for slump or ASTM C1611/C1611M for slump flow and visual stability index (VSI), ASTM C231/C231M for air content, ASTM C1064/C1064M for temperature, and ASTM C138/C138M unit weight.

For each lot sample, cast twelve 150 by 300 mm 6 by 12 inch cylinder specimens for strength and seven 100 by 200 mm 4 by 8 inch cylinder specimens for transport property testing. Special handling will be necessary for shipments of transport property specimens. These cylinders shall be wrapped completely with slightly damp paper towels with spring water only. The wrapped cylinders shall be placed in either a vacuum package or double layers of sealed plastic bags. Package cylinders to prevent damage and ship priority mail to the approved testing laboratory.

In the event the results of cylinder tests fail to satisfy transport properties, then an additional pair of specimens shall be tested. In the event quality acceptance test results and retest results fail to meet the quality acceptance criteria, the entire lot shall be considered non-conforming material, refer to the subpart entitled "REPAIR, REHABILITATION and REMOVAL".

For every [382.3 cubic meters] [500 cubic yards] perform a petrographic examination in accordance with ASTM C856.

3.8.2.1 Compressive Strength Tests

NOTE: When the same mix design is used for multiple elements such as slabs, beams, and walls, the design element type may be specified in addition to the mix design to better identify deficient concrete.

ACI 214R tests for strength - conduct strength tests of concrete during construction in accordance with the following procedures:

- a. Test cylinders in accordance with ASTM C39/C39M. Test three cylinders at 3 days, three cylinders at 7 days, and three cylinders at the age when the compressive strength requirement was specified. Hold the remaining three cylinders in storage. If one specimen in a test shows evidence of improper sampling, molding or testing, discard the specimen and consider the strength of the remaining cylinder to be the test result. If more than one specimen shows excess defects, the Contracting Officer may allow the entire test to be discarded. Test results shall not exceed the specified compressive strength by more than 20 percent for the age specified.
- b. If the average strength test results are less than the specified strength ($f'c$) extract three core samples from the structure in accordance with ASTM C42/C42M, from the area that correlates to the low test results. These extracted cores shall not contain steel reinforcing. Repair core holes with non-shrink grout. Match color and finish of adjacent concrete. For concrete not meeting strength criteria the Contractor shall prepare a remediation strategy for the review by the Contracting Officer.
- c. Strength test reports shall be provided within 7 days of test completion.

3.8.2.2 Transport Property Tests

Test cylinder concrete for porosity and ion diffusion coefficient at 28 days. Calculate the D_{eff} with the determined ionic diffusion coefficient (D_{oh}) and volume of permeable voids (porosity). Concrete representative of the tested concrete with D_{eff} values greater than the quality acceptance values determined in the Concrete Qualification Testing Requirements program, will require retesting using spare samples. If the retest exceeds the quality acceptance limit, this shall be grounds to stop concrete placement and to review quality control issues.

The Contractor shall monitor the transport properties throughout the duration of the project and prepare an as-built report documenting the transport property test results. The report shall include a chart or table of the effective diffusion coefficient (D_{eff}) versus the specified effective diffusion coefficient (D_{spec}) over the duration of the placement for each concrete, indicate the concrete placed outside of the tolerance limits, describe any mitigation measures taken to ensure the service life specified, and estimate the service life of the various concretes, as placed.

[3.8.2.3 Chloride Ion Concentration

Comply with ACI 318M ACI 318. Determine water soluble chloride ion concentration. Perform test once for each mix design. The limits for average chloride ion content are provided in Table 3.

]3.8.2.4 Anti-Washout Admixture

Comply with COE CRD-C 61. Determine cumulative mass loss. Perform test once for each 267.6 cubic meters 350 cubic yards of underwater concrete.

3.8.2.5 Non-Destructive Tests

Use of a rebound hammer to obtain data on the strength of the concrete surface shall be in accordance with [ASTM C805/C805M](#). Test results from the rebound hammer and other non-destructive testing may be helpful in selecting areas to extract concrete cores for destructive testing.

3.8.3 Core Samples and Compressive Strength Testing

Obtain and test cores in accordance with [ASTM C42/C42M](#).

If concrete in the structure is dry under service conditions, air dry cores (temperature [16 to 27 degrees C](#) [60 to 80 degrees F](#), relative humidity less than 60 percent) for 7 days before testing and test dry. Otherwise, test the cores, after moisture conditioning, in accordance with [ASTM C42/C42M](#).

Acceptance criteria for cylinder compressive strength are provided in subpart entitled "Acceptance of Concrete Strength".

Take at least three representative cores from each member or area of concrete in place that is considered potentially strength deficient. Impair the strength of the structure as little as possible. If, before testing, extracted cores show evidence of having been damaged subsequent to or during removal from the structure, take replacement cores.

Fill core holes with low slump concrete or mortar of a strength equal to or greater than the original concrete.

The Contracting Officer will evaluate and validate core tests in accordance with the specified procedures.

3.8.4 Acceptance of Concrete Strength

3.8.4.1 Standard Molded and Cured Strength Specimens

The acceptance of concrete strengths shall be based on averages of results from three consecutive compressive strength tests. When the averages of all sets of three consecutive compressive strength test results are between 1.0 and 1.2 times the field test strength (fcr), and no individual strength test falls below fcr by more than [3.45 MPa](#) [500 psi](#), the strength of the concrete is satisfactory. These criteria also apply when accelerated strength testing is specified unless another basis for acceptance is specified.

3.8.4.2 Non-Destructive Tests

Non-destructive tests may be used when permitted to evaluate concrete where standard molded and cured cylinders have yielded results not meeting the criteria.

3.8.4.3 Extracted Core Tests

When the average compressive strengths of the representative cores are between 0.85 fcr and 1.2 fcr and if no single core is less than 0.75 fcr, the strength of concrete is satisfactory.

3.8.5 Inspection

[ACI 311.4R](#). Inspect concrete placed under water with qualified divers.

3.9 REPAIR, REHABILITATION AND REMOVAL

Before the Owner accepts the structure and final payment is made the Contractor shall inspect the structure for cracks, damage and substandard concrete placements that may adversely affect the service life of the structure. A report documenting these defects shall be prepared which includes recommendations for repair, removal and/or remediation which, will be reviewed by the agency's Subject Matter Expert in Concrete Materials and submitted to the Contracting Officer for approval before any corrective work is accomplished.

3.9.1 Crack Repair

Prior to final acceptance, all cracks in excess of 0.50 mm 0.02 inches wide shall be documented and repaired. The proposed method and materials to repair the cracks shall be submitted to the Contracting Officer for approval. The proposal shall address the amount of movement expected in the crack due to temperature changes and loading.

3.9.2 Repair of Weak Surfaces

Weak surfaces are defined as mortar-rich, rain-damaged, uncured, or containing exposed voids or deleterious materials. Concrete surfaces with weak surfaces less than 6 mm 1/4 inch thick shall be diamond ground to remove the weak surface. Surfaces containing weak surfaces greater than 6 mm 1/4 inch thick shall be removed and replaced or mitigated in a manner acceptable to the Contracting Officer.

3.9.3 Failure of Quality Assurance Test Results

NOTE: Test results accomplished on concrete samples during concrete production that fall short of the acceptance criteria alert the Contractor to something in the production and placement process that has drifted out of calibration or that an error has been made. The goal is to track down the problem and correct it as quickly as possible. Unless the concrete producer makes a large error in batching or in placing, the chance that hardened concrete needs to be removed is remote. Removal and replacement is a last resort.

For those areas adversely affected by substandard concrete new STADIUM® simulations can be helpful to evaluate the effectiveness of the proposed remediation strategies.

Proposed mitigation efforts by the Contractor to restore the service life shall be reviewed by the agency's Subject Matter Expert in Concrete Materials and approved by the Contracting Officer prior to proceeding.

-- End of Section --