SECTION 03310

STRUCTURAL CONCRETE

1.0 G E N E R A L

1.01 SECTION INCLUDES

A. Cast-in-place normal-weight structural concrete and mass concrete.

B. References to Technical Specifications:

1. Section 00300 – Bid Proposal
2. Section 01200 – Measurement
3. Section 01350 – Submittals
4. Section 01450 – Testing Laboratory Services
5. Section 03300 – Cast-in-Place Concrete

1.02 MEASUREMENT AND PAYMENT

A. Measurement for structural concrete is on an each basis for each structure as bid. Payment includes related work performed on these structures in accordance with related sections of these Specifications.

B. If Extra Structural Concrete is allowed, based on the Engineer's direction, and indicated in Section 00300 – Bid Proposal as an Extra Item, measurement will be on a cubic-yard basis, measured in place. Payment includes related work performed in accordance with related sections of these Specifications.

C. Refer to Section 01200 – Measurement and Payment for unit price procedures.

D. No provisions shall be provided for temperature controlled curing of test cylinder. Test cylinder(s) shall be cured in identical environment until picked up by lab.

1.03 DEFINITIONS

A. Mass Concrete: Concrete sections 4 feet or more in least dimension.

B. Hot Weather: Any combination of high air temperature, low relative humidity and wind velocity tending to impair quality of fresh or hardened concrete or otherwise resulting in abnormal properties. Hot weather concreting shall be done in accordance with ACI - 305R.

C. Cold Weather: Period when, for more than 2 successive days, mean daily temperature is below 40 degrees F. Cold weather concreting shall be done in accordance with ACI - 306R.

1.04 SUBMITTALS

A. Conform to Section 01350 – Submittals.

B. Mill Certificates: Required for bulk cement.

C. Design Mixes:

1. Submit test data on proposed design mixes for each type of concrete in the Work, including each class, and variations in type, source or quantity of material. Include type, brand and amount of cementitious materials; type, brand and amount of each admixture; slump; air content; aggregate sources, gradations, specific gravity and absorption; total water (including moisture in aggregate); water/cement ratio; compressive strength test results for 7 and 28 days; and shrinkage tests for Class C and D concrete at 21 or 28 days of drying.

2. Submit abrasion loss and soundness test results for limestone aggregate.

3. Testing of aggregates, including sieve analysis, shall be performed by a certified independent testing laboratory. Tests shall have been performed no earlier than 3 months before Notice to Proceed.

4. Provide standard deviation data for plant producing concrete. Data shall include copies of laboratory test results and standard deviation calculated in accordance with ACI 318, Item 5.3.1. Laboratory tests shall have been performed within past 12 months. When standard deviation data is not available, comply with ACI 318, Table 5.3.2.2.

5. Review and acceptance of mix design does not relieve Contractor of responsibility to provide concrete of quality and strength required by these Specifications.

D. Admixtures: Submit manufacturer's technical information, including following:

1. Air-Entraining Admixture: Give requirements to control air content under all conditions, including temperature variations and presence of other admixtures.

2. Chemical Admixtures: Give requirements for quantities and types to be used under various temperatures and job conditions to produce uniform, workable concrete mix. Submit evidence of compatibility with other admixtures and cementitious materials proposed for use in design mix.

E. High-Range Water Reducer (Superplasticizer): When proposed for use, submit manufacturer's technical information and instructions for use of superplasticizer. State whether superplasticizer will be added at ready-mix plant or job site. When superplasticizer will be added at job site, submit proposed plan for measuring and adding superplasticizer to concrete mix at job site, and establish dosing area on site with holding tanks and metering devices. When superplasticizer is to be added at

ready-mix plant, submit contingency plans for adding additional superplasticizer at job site when required due to delay in placing concrete. Identify portions of Work on which superplasticizer is proposed for use.

F. Hot and Cold Weather Concreting: Submit, when applicable, proposed plans for hot and cold weather concreting. Review and acceptance of proposed procedure will not relieve Contractor of responsibility for quality of finished product.

G. Project Record Drawings: Accurately record actual locations of embedded utilities and components that are concealed from view.

1.05 QUALITY ASSURANCE

A. Provide necessary controls during evaluation of materials, mix designs, production and delivery of concrete, placement and compaction to assure that the Work will be accomplished in accordance with Contract Documents. Maintain records of concrete placement. Record dates, locations, quantities, air temperatures, and test samples taken.

B. Code Requirements: Concrete construction for buildings shall conform to ACI 318. Concrete construction for water and wastewater treatment and conveying structures shall conform to ACI 318 with modifications by ACI 350R, Item 2.6. Where this Specification conflicts with ACI 318 or ACI 350R, this Specification governs.

C. Testing and Other Quality Control Services:

1. Concrete testing required in this section, except concrete mix design, limestone aggregate test data, and testing of deficient concrete, will be performed by an independent commercial testing laboratory employed and paid by the Owner in accordance with Section 01450 – Testing Laboratory Services.

2. Provide material for and cooperate fully with Owner's testing laboratory technician in obtaining samples for required tests.

3. Standard Services: The following testing and quality control services will be provided by Owner in accordance with Section 01450 – Testing Laboratory Services:

a. Verification that plant equipment and facilities conform to NRMCA "Certification of Ready-Mix Concrete Production Facilities".

b. Testing of proposed materials for compliance with this Specification.

c. Review of proposed mix design submitted by Contractor.

d. Obtaining production samples of materials at plants or stockpiles during work progress and testing for compliance with this Specification.

e. Strength testing of concrete according to following procedures:

1) Obtaining samples for field test cylinders from every 100 cubic yards and any portion less than 100 cubic yards for each mix design placed each day, according to ASTM C172, with each sample obtained from a different batch of concrete on a representative, random basis. Selecting test batches by any means other than random numbers chosen before concrete placement begins is not allowed.

2) Molding four specimens from each sample according to ASTM C31, and curing under standard moisture and temperature conditions as specified in Sections 7(a) and (b) of ASTM C31.

3) Testing two specimens at 7 days and two specimens at 28 days according to ASTM C39, reporting test results averaging strengths of two specimens. However, when one specimen evidences improper sampling, molding or testing, it will be discarded and remaining cylinder considered test result. When high-early-strength concrete is used, specimens will be tested at 3 and 7 days.

f. Air content: For each strength test, determination of air content of normal weight concrete according to ASTM C231.

g. Slump: For each strength test, and whenever consistency of concrete appears to vary, conducting slump test in accordance with ASTM C143.

h. Temperature: For each strength test, checking concrete temperature in accordance with ASTM C1064.

i. Lightweight concrete: For each strength test, or more frequently when requested by the Engineer, determination of air content by ASTM C567 and unit weight by ASTM C567.

j. Monitoring of current and forecasted climatic conditions to determine when rate of evaporation, as determined by Figure 2.1.5 of ACI 305R, will produce loss of 0.2 pounds of water, or more, per square foot per hour. Testing lab representative will advise Contractor to use hot weather precautions when such conditions will exist during concrete placement, and note on concrete test reports when Contractor has been advised that hot weather conditions will exist.

k. Class A and D Concrete Shrinkage Tests: Performance of drying shrinkage tests for trial batches as follows:

1) Preparation and Testing of Specimens: Compression and drying shrinkage test specimens will be taken in each case from the same concrete sample; shrinkage tests will be considered a part of the normal compression tests for the project. 4-inch by 4-inch by 11-inch prisms with an effective gage length of 10 inches, fabricated, cured, dried and measured in accordance with ASTM C157, modified as follows:

(a). Wet curing: Remove specimens from molds at an age of 23 hours ±1 hour after trial batching and immediately immerse in water at 70 degrees F ±3 degrees F for at least 30 minutes;

(b). Measure within 30 minutes after first 30 minutes of immersion to determine original length (not to be confused with "base length");

(c). Then submerge in saturated limewater, at 73 degrees F ±3 degrees F, for 7 days;

(d). Then measure at age 7 days to establish "base length" for drying shrinkage calculations ("zero" days drying age);

(e). Calculate expansion (base length expressed as a percentage of original length);

(f). Immediately store specimens in a temperature and humidity controlled room maintained at 73 degrees F, ±3 degrees, and 50 percent relative humidity, ±4 percent, for the remainder of the test.

(g). Measure to determine shrinkage, expressed as percentage of base length. Compute the drying shrinkage deformation of each specimen as the difference between the base length (at ?zero@ days drying age) and the length after drying at each test age. Compute the average drying shrinkage deformation of the specimens to the nearest 0.0001 inch at each test age. If the drying shrinkage of any specimen departs from the average of that test age by more than 0.0004 inch, disregard the results obtained from that specimen.

Report results of shrinkage tests to the nearest 0.001 percent of shrinkage.

(h). Report shrinkage separately for 7, 14, 21, and 28 days of drying after 7 days of moist curing.

4. Additional Testing and Quality Control Services: The following will be performed by an independent commercial testing laboratory employed and paid by the Owner in accordance with Section 01450, Testing Laboratory Services, when requested by the Engineer.

   a. Checking of batching and mixing operations.

   b. Review of manufacturer's report of each cement shipment and conducting laboratory tests of cement.

   c. Molding and testing reserve 7-day cylinders or field cylinders.

   d. Conducting additional field tests for slump, concrete temperature, and ambient temperature.

   e. Alkalinity Tests: For concrete used in sanitary structures, one test for each structure. Perform alkalinity tests on concrete covering reinforcing steel on the inside of the pipe or structure in accordance with "Encyclopedia of Industrial Chemical Analysis," Vol. 15, page 230.

5. Contractor shall provide the following testing and quality control services:

   a. Employ an independent commercial testing laboratory, acceptable to Owner, to prepare and test design mix for each class of concrete for which material source has been changed.

   b. Notify commercial testing laboratory employed by Owner 24 hours prior to placing concrete.

6. Testing of deficient concrete in place:

   a. When averages of three consecutive strength test results fail to equal or exceed specified strength, or when any individual strength test result falls below specified strength by more than 500 psi, strength of concrete shall be considered potentially deficient and core testing, structural analysis or load testing may be required by the Engineer.

   b. When concrete in place proves to be deficient, Contractor shall pay costs, including costs due to delays, incurred in providing additional

testing and analysis services provided by the Engineer, or the independent commercial testing laboratory selected by the Owner.

c. Replace concrete work judged inadequate by core tests, structural analysis or load tests at no additional cost to the Owner.

d. Core Tests:

1) Obtain and test cores in accordance with ASTM C42. Where concrete in structure will be dry under service conditions, air dry cores (temperature 60 to 80 degrees F, relative humidity less than 60 percent) for 7 days before test; test dry. Where concrete in structure will be more than superficially wet under service conditions, test cores after moisture conditioning in accordance with ASTM C42.

2) Take at least three representative cores from each member or area of concrete in place that is considered potentially deficient. Location of cores shall be determined by the Engineer so as to least impair strength of structure. When, before testing, one or more cores shows evidence of having been damaged during or after removal from structure, replace the damaged cores.

3) Concrete in area represented by core test will be considered adequate when average strength of cores is equal to at least 85 percent of specified strength, and when no single core is less than 75 percent of specified strength.

4) Patch core holes in accordance with Section 03300 – Cast-in-Place Concrete, Paragraph 3.13.

e. Structural Analysis: When core tests are inconclusive or impractical to obtain, the Engineer may perform additional structural analysis at Contractor's expense to confirm safety of structure.

f. Load Tests: When core tests and structural analysis do not confirm safety of structure, load tests may be required, and their results evaluated, in accordance with ACI 318.

g. Testing by impact hammer, sonoscope, probe penetration tests (Windsor probe), or other nondestructive device may be permitted by the Engineer to determine relative strengths at various locations in structure, to evaluate concrete strength in place, or for selecting areas to be cored. However, such tests, unless properly calibrated and correlated with other test data, shall not be used as basis for acceptance or rejection of structure's safety.

1.06 STORAGE AND HANDLING OF MATERIALS

A. Cement: Store cement in weather tight buildings, bins or silos to provide protection from dampness and contamination and to minimize warehouse set. When there is any doubt as to the expansive potential of shrinkage-compensating cements because of method or length of storage and exposure, laboratory test cement before use.

B. Aggregate: Arrange and use aggregate stockpiles to avoid excessive segregation or contamination with other materials or with other sizes of like aggregates. Build stockpiles in successive horizontal layers not exceeding 3 feet in thickness. Complete each layer before next is started.

C. Fine Aggregate: Before using, allow fine aggregate to drain until uniform moisture content is reached.

D. Admixtures: Store admixtures to avoid contamination, evaporation or damage. For those used in form of suspensions or non-stable solutions, provide suitable agitating equipment to assure uniform distribution of ingredients. Protect liquid admixtures from freezing and other temperature changes which would adversely affect their characteristics.

E. Lightweight Aggregates: Uniformly pre-dampen lightweight aggregates as necessary to prevent excessive variations in moisture content. Allow pre-dampened aggregates to remain in stockpiles, under continuous fog spray, for minimum of 24 hours before use. Provide adequate drainage in stockpile areas to eliminate excess water and accumulation of contaminated fines.

2.0 P R O D U C T S

2.01 MATERIALS

A. Cement:

1. Use same brand of cement used in concrete mix design. Use only one brand of each type in each structure, unless otherwise indicated on Drawings.

2. Portland Cement: ASTM C150, Type I or Type II, gray in color. Use Type III only when specifically authorized by the Engineer in writing. Use Type II, including the requirements of Table 2, in construction of liquid-containing structures and cooling towers, unless shown otherwise on Drawings.

B. Admixtures:

1. Do not use calcium chloride, thiocyanate or admixtures containing more than 0.05 percent chloride ions.

2. Air-Entraining Admixtures: ASTM C260, compatible with other admixtures used.

3. Chemical Admixtures: Polymer type, non-staining, chloride-free admixtures conforming to ASTM C494, Type A, C, D or E.

4. High-Range Water Reducer (Superplasticizer): ASTM C494, Type F or G, compatible with and by the same manufacturer as other admixtures.

C. Mixing Water: Use clean, potable water, free from harmful amounts of oils, acids, alkalis or other deleterious substances, meeting requirements of ASTM C94.

D. Aggregates: Use coarse aggregate from only one source and fine aggregate from only one source, for exposed concrete in any single structure.

1. Coarse Aggregate: Gravel, crushed gravel or crushed limestone conforming to ASTM C33.

2. Fine Aggregate: Natural sand complying with ASTM C33.

3. Limestone aggregate shall conform to ASTM C33 and the following additional requirements:

a. Clean, hard, strong and durable particles free of chemicals and coatings of silt, clay, or other fine materials that may affect hydration and bond of cement paste.

b. Select crushed limestone: High-calcium limestone (minimum 95 percent $CaCO_3$ and maximum 3.5 percent $MgCO_3$) with maximum Los Angeles Abrasion loss of 38 percent, when tested in accordance with ASTM C131 or ASTM C535.

c. Test aggregate for soundness in accordance with ASTM C88; maximum loss shall not exceed 18 percent after 5 cycles of magnesium sulfate test.

4. Maximum size of coarse aggregate:

a. Normal weight concrete, except as noted below: 1-1/2 inches.

b. Formed members 6 inches or less in least dimension: 1/5 least dimension.

c. Slabs: 1/3 depth of slab.

d. Drilled shafts: 1/3 clearance between reinforcing steel, but not greater than 3/4 inch.

e. Concrete fill, seal slabs and bonded concrete topping in clarifiers: 3/8 inch.

5. Coarse aggregate for lightweight concrete: ASTM C330. Grading limits: 3/4 inch to No. 4.

6. Abrasive Aggregate: Conform to requirements of Section 03300 – Cast-in-Place Concrete, Paragraph 3.13.

E. Calcium Chloride: Not permitted.

F. Evaporation Retardant: Masterbuilders "Confilm", Euclid "Eucobar", or equal.

G. Miscellaneous Materials:

1. Bonding Agent: Two-component modified epoxy resin.

2. Vapor barrier: 6-mil clear polyethylene film of type recommended for below-grade application.

3. Non-shrink grout: premixed compound consisting of non-metallic aggregate, cement and water-reducing and plasticizing agents; capable of developing minimum compressive strength of 2,400 psi in 48 hours and 7,000 psi in 28 days.

2.02 CONCRETE MIX

A. Objective: Select proportions of ingredients to produce concrete having proper placability, durability, strength, appearance and other specified properties.

B. Mix Design: Employ and pay an independent commercial testing laboratory, acceptable to Owner, to prepare and test mix designs for each type of concrete specified. Proportion mix design ingredients by weight. Submit mix designs and test results for approval.

1. During the trial batches, aggregate proportions may be adjusted by the testing laboratory using two coarse aggregate size ranges to obtain the required properties. If one size range produces an acceptable mix, a second size range need not be used. Such adjustments shall be considered refinements to the mix design and shall not be the basis for extra compensation to the Contractor. Concrete shall conform to the requirements of this Section, whether the aggregate proportions are from the Contractor's preliminary mix design, or whether the proportions have been adjusted during the trial batch process. Prepare trial batches using the aggregates, cement and admixtures proposed for the project. Make trial batches large enough to obtain 3 drying shrinkage test specimens and 6 compression test specimens from each batch. Shrinkage testing is required only for Class A and D concrete.

2. Determine compressive strength by testing 6-inch diameter by 12-inch high cylinders, made, cured and tested in accordance with ASTM C192 and ASTM C39. Test 3 compression test cylinders at 7 days and 3 at 28 days. Average compressive strength for the 3 cylinders tested at 28 days for any given trial batch shall be not less than 125 percent of the specified compressive strength.

3. Perform sieve analysis of the combined aggregate for each trial batch according to of ASTM C136. Report percentage passing each sieve.

4. In mix designs for Class A and D concrete, fine aggregate shall not exceed 41 percent of total aggregate by weight.

C. Shrinkage Limitations, Class A and D Concrete

1. Maximum concrete shrinkage for specimens cast in the laboratory from the trial batch: 0.036 percent as measured at 21-day drying age or 0.042 percent at 28-day drying age. Use for construction only mix designs that meet trial batch shrinkage requirements. Shrinkage limitations apply only to Class A and D concrete.

2. Maximum concrete shrinkage for specimens cast in the field shall not exceed the trial batch maximum shrinkage requirement by more than 25 percent.

3. If the required shrinkage limitation is not met during construction, take any or all of the following actions, at no additional cost to the Owner, for securing the specified shrinkage requirements: Changing the source or aggregates, cement or admixtures; reducing water content; washing of aggregate to reduce fines; increasing the number of construction joints; modifying the curing requirements; or other actions designed to minimize shrinkage or its effects.

D. Selecting Ingredient Proportions for Concrete:

1. Proportion concrete mix according to ACI 301, Chapter 3.

2. Establish concrete mix design by laboratory trial batches prepared by independent testing laboratory, or on basis of previous field experience in accordance with provisions of ACI 318, Item 5.3; however, minimum cement content for each class of concrete shall not be less than specified.

3. Concrete mix design data submitted for review shall have average 28-day compressive strength calculated in accordance with ACI 318, Item 5.3.2.1. When data is not available to determine standard deviation in accordance with ACI 318, Item 5.3.1, average 28-day strength of mix design shall conform to ACI 318, Table 5.3.2.2.

E. Water-Cement Ratios:

1. Maximum allowable water-cement ratios shall be as follows:

a. Concrete for liquid-containing structures: 0.45.
b. Concrete subjected to brackish water, salt spray or deicers: 0.40.
c. All other concrete: 0.55.

2. Superplasticizer may be added to maintain specified maximum water-cement ratios. Include free water in aggregate in water-cement ratio computations.

F. Adjustment of Mix Proportions: After sufficient data becomes available during construction, mix may be adjusted upon approval of the Engineer, in accordance with ACI 318, Item 5.5; however, minimum cement content for each class of concrete shall not be less than specified.

G. Entrained Air: Air-entrain all concrete except drilled shafts. Total air content in accordance with ASTM C173: 4 to 6 percent.

H. Consistency, Workability, and Slump:

1. The quantity of water in a batch of concrete shall be just sufficient, with a normal mixing period, to produce concrete which can be worked properly into place without segregation, and which can be compacted by vibratory methods as specified, to give the desired strength, density, impermeability and smoothness of surface. Change the quantity of water as necessary, with variations in the nature or moisture content of the aggregates, to maintain uniform production of a desired consistency. Determine the consistency of the concrete in successive batches by slump tests in accordance with ASTM C 143. Slumps shall be as follows:

Concrete Type	Minimum Slump	Maximum Slump
Portland Cement Concrete	2”	4”
Concrete to be dosed with superplasticizer:	1”	3”
Normal Weight Concrete after dosing with superplasticizer	4”	9”
Lightweight Concrete after dosing with superplasticizer	4”	7”
Drilled Shaft Concrete:	4”*	8”

* Minimum slump where drilled shafts are cast in temporary casings: 5 inches

2. Specified slump shall apply at time when concrete is discharged at job site. Perform slump tests to monitor uniformity and consistency of concrete delivered to job site; however, do not use as basis for mix design. Do not exceed water-cement ratios specified.

I. Admixtures: Proportion admixtures according to manufacturer's recommendations. Use of accelerator is permitted when air temperature is less than 40 degrees F. Use of retarder is permitted when temperature of placed concrete exceeds 65 degrees F.

J. High-Range Water Reducers (Superplasticizers): Use superplasticizer to improve workability of concrete or delay hydration of cement, in accordance with requirements and recommendations of product manufacturer and approved submittals.

K. Concrete Classification and Strength:

1. Strength: Conform to values for class of concrete indicated on Drawings for each portion of Work. Requirements are based on 28-day compressive strength. If high early-strength concrete is allowed, requirements are based on 7-day compressive strength.

2. Classification:

Class (Normal-weight)	Minimum 28-day Compressive Strength (psi)	Minimum Cement Content Pounds per Cubic Yard
Concrete for Structures Containing Water or Wastewater		
A	4,000	564 (6 sacks)
B	1,500	329 (3 ½ sacks)
C	3,000	470 (5 sacks)
D	5,000	658 (7 sacks)
H	3,000	611 (6 ½ sacks)
Concrete for Buildings, Slabs on Grade and Miscellaneous Structures		
AB	4,000	Not Applicable
BB	1,500	Not Applicable
CB	3,000	Not Applicable
DB	5,000	Not Applicable

Class (Light-weight)	Minimum 28-day Compressive Strength (psi)	Minimum Cement Content Pounds per Cubic Yard
E	3,000	Not Applicable
F	4,000	Not Applicable
G	5,000	Not Applicable

3. Maximum size aggregate for Class H concrete: 3/8 inch. Maximum size aggregate for all other normal-weight concrete: 1-1/2 inches, except as specified in Paragraph 2.01D.4.

4. When required strength is not obtained with minimum cement content as specified, add cement, lower water-cement ratio or provide other aggregates as necessary.

5. In addition to conforming to specified strength, lightweight concrete must be within specified unit weight limits. Maximum air-dry unit weight is 118 pounds per cubic foot; minimum is 110 pounds per cubic foot unless shown otherwise on Drawings. Determine air-dry unit weight in accordance with ASTM C567. Correlate air-dry unit weight with fresh unit weight of the same concrete as a basis for acceptance during construction.

L. Use of Classes of Concrete:

1. Use classes of concrete as indicated on the Drawings and in other specifications.

2. Liquid-containing structures: If not otherwise indicated, use the following classes for structures containing water or wastewater and for utility applications in the locations described:

a. Class A: All reinforced concrete and where not otherwise defined.

b. Class B: Unreinforced concrete used for plugging pipes, seal slabs, thrust blocks, and trench dams, unless indicated otherwise.

c. Class H: Fill and topping. Where concrete fill thickness exceeds 3 inches in the majority of a placement and is not less than 1.5 inches thick, Class A concrete may be used.

3. All other structures: If not otherwise indicated, use the following classes in the locations described:

a. Class AB: All reinforced concrete and where not otherwise defined.

b. Class CB: Duct banks; see Section 16402 – Underground Duct Banks for additional requirements.

c. Class BB: Unreinforced concrete fill under structures.

2.03 MIXING NORMAL WEIGHT CONCRETE

A. Conform to ACI 301, Chapter 7.

B. Ready-Mixed Concrete:

1. Measure, batch, mix and transport ready-mixed concrete according to ASTM C94. Plant equipment and facilities shall conform to NRMCA "Certification of Ready Mixed Concrete Production Facilities".

2. Provide batch tickets with information specified in ASTM C94. Deliver batch ticket with concrete and give to Owner's on-site testing laboratory representative.

C. Batch Mixing at Site:

1. Mix concrete in batch mixer conforming to requirements of CPMB "Concrete Plant Mixer Standards". Use mixer equipped with suitable charging hopper, water storage tank and water measuring device. Batch mixer shall be capable of mixing aggregates, cement and water into uniform mass within specified mixing time, and of discharging mix without segregation. Operate mixer according to rated capacity and recommended revolutions per minute printed on manufacturer's rating plate.

2. Charge batch into mixer so some water will enter before cement and aggregates. Keep water running until one-fourth of specified mixing time has elapsed. Provide controls to prevent discharging until required mixing time has elapsed. When concrete of normal weight is specified, provide controls to prevent addition of water during mixing. Discharge entire batch before mixer is recharged.

3. Mix each batch of 2 cubic yards or less for not less than 1 minute and 30 seconds. Increase minimum mixing time 15 seconds for each additional cubic yard or fraction of cubic yard.

4. Keep mixer clean. Replace pick-up and throw-over blades in drum when they have lost 10 percent of original depth.

D. Admixtures:

1. Charge air-entraining and chemical admixtures into mixer as solution using automatic dispenser or similar metering device. Measure admixture to accuracy within $\pm$ 3 percent. Do not use admixtures in powdered form.

2. Two or more admixtures may be used in same concrete, provided that admixtures in combination retain full efficiency and have no deleterious effect on concrete or on properties of each other. Inject admixtures separately during batching sequence.

3. Add retarding admixtures as soon as practicable after addition of cement.

E. Temperature Control:

1. When ambient temperature falls below 40 degrees F, keep as-mixed temperature above 55 degrees F to maintain concrete above minimum placing temperature.

2. When water or aggregate has been heated, combine water with aggregate in mixer before cement is added. Do not add cement to mixtures of water and aggregate when temperature of mixture is greater than 100 degrees F.

3. In hot weather, maintain temperature of concrete below maximum placing temperature. When necessary, temperature may be lowered by cooling ingredients, cooling mixer drum by fog spray, using chilled water or well-crushed ice in whole or part for added water, or arranging delivery sequence so that time of transport and placement does not generate unacceptable temperatures.

4. Submit hot weather and cold weather concreting plans for approval.

2.04 MIXING LIGHTWEIGHT CONCRETE

A. Determining Absorption of Aggregates: Mixing procedures vary according to total absorption by weight of lightweight aggregates. Determine total absorption by weight before pre-damping in accordance with ASTM C127.

B. Ten Percent or Less Absorption: Follow same requirements as for mixing normal-weight concrete when preparing concrete made with low-absorptive lightweight aggregates having 10 percent or less total absorption by weight. To be low-absorptive, aggregates must absorb less than 2 percent additional water in first hour after mixing.

C. More Than 10 Percent Absorption: Batch and mix concrete made with lightweight aggregates having more than 10 percent total absorption by weight, as follows:

1. Place approximately 80 percent of mixing water in mixer.

2. If aggregates are pre-dampened, add air-entraining admixture and all aggregates. Mix for minimum of 30 seconds, or 5 to 10 revolutions of truck mixer.

3. When aggregates have not been pre-dampened, mix aggregates and water for minimum of 1 minute and 30 seconds, or 15 to 30 revolutions of truck mixer. Then add air-entraining admixture and mix for additional 30 seconds.

4. Then, in the following sequence, add specified or permitted admixtures (other than air-entraining agent), all cement, and mixing water previously withheld.

5. Complete mixing using procedures for normal-weight concrete.

2.05 MASS CONCRETE

A. Do not use high early-strength cement (Type III) or accelerating admixtures.

B. Use high-range water-reducing admixture (superplasticizer) to minimize water content and cement content.

C. Specified water-reducing retarding admixture may be required to prevent cold joints when placing large quantities of concrete, to permit revibration of concrete, to offset effects of high temperature in concrete or weather, and to reduce maximum temperature or rapid temperature rise.

2.06 EQUIPMENT

A. Select equipment of size and design to ensure continuous flow of concrete at delivery end. Conform to following equipment and operations requirements.

B. Truck mixers, agitators and manner of operation: Conform to ASTM C94. Use of non-agitating equipment for transporting concrete is not permitted.

C. Belt conveyors: Configure horizontally, or at a slope causing no segregation or loss. Use approved arrangement at discharge end to prevent separation. Discharge long runs without separation into hopper.

D. Chutes: Metal or metal-lined (other than aluminum). Arrange for vertical-to-horizontal slopes not more than 1 to 2 or less than 1 to 3. Chutes longer than 20 feet or not meeting slope requirements may be used if concrete is discharged into hopper before distribution.

E. Do not use aluminum or aluminum-alloy pipe or chutes for conveying concrete.

3.0 E X E C U T I O N

3.01 SPECIAL CONSIDERATIONS

A. Concreting Under Water: Not permitted except where shown otherwise on Drawings or approved by the Engineer. When shown or permitted, deposit concrete under water by methods acceptable to the Engineer so fresh concrete enters mass of previously-placed concrete from within, causing water to be displaced with minimum disturbance at surface of concrete.

B. Protection from Adverse Weather: Unless adequate protection is provided or the Engineer's approval is obtained, do not place concrete during rain, sleet, snow or freezing weather. Do not permit rainwater to increase mixing water or to damage surface finish. If rainfall occurs after placing operations begin, provide adequate covering to protect Work.

3.02 PREPARATION OF SURFACES FOR CONCRETING

A. Earth Surfaces:

1. Under interior slabs on grade, install vapor barrier. Lap joints at least 6 inches and seal watertight with tape, or sealant applied between overlapping edges and ends. Repair vapor barrier damaged during placement of reinforcing and inserts with vapor barrier material; lap over damaged areas at least 6 inches and seal watertight.

2. Other Earth Surfaces: Thoroughly wet by sprinkling prior to placing concrete, and keep moist by frequent sprinkling up to time of placing concrete thereon. Remove standing water. Surfaces shall be free from standing water, mud and debris at the time of placing concrete.

B. Construction Joints:

1. Definition: Concrete surfaces upon or against which concrete is to be placed, where the placement of the concrete has been interrupted so that, in the judgment of the Engineer, new concrete cannot be incorporated integrally with that previously placed.

2. Interruptions: When placing of concrete is to be interrupted long enough for the concrete to take a set, use forms or other means to shape the working face to secure proper union with subsequent work. Make construction joints only where acceptable to the Engineer.

3. Preparation: Give horizontal joint surfaces a compacted, roughened surface for good bond. Except where the Drawings call for joint surfaces to be coated, clean joint surfaces of laitance, loose or defective concrete and foreign material by hydroblasting or sandblasting (exposing aggregate), roughen surface to expose aggregate to a depth of at least 1/4 inch and wash thoroughly. Remove standing water from the construction joint surface before new concrete is placed.

4. After surfaces have been prepared cover approximately horizontal construction joints with a 3-inch lift of a grout mix consisting of Class A concrete batched without coarse aggregate; place and spread grout uniformly. Place wall concrete on the grout mix immediately thereafter.

C. Set and secure reinforcement, anchor bolts, sleeves, inserts and similar embedded items in the forms where indicated on Contract Drawings, shop drawings and as otherwise required. Obtain the Engineer's acceptance before concrete is placed. Accuracy of placement is the sole responsibility of the Contractor.

D. Place no concrete until at least 4 hours after formwork, inserts, embedded items, reinforcement and surface preparation have been completed and accepted by the Engineer. Clean surfaces of forms and embedded items that have become encrusted with grout or previously-placed concrete before placing adjacent concrete.

E. Casting New Concrete Against Old: Where concrete is to be cast against old concrete (any concrete which is greater than 60 days of age), thoroughly clean and roughen the surface of the old concrete by hydroblasting or sandblasting (exposing aggregate). Coat joint surface with epoxy bonding agent following manufacturer's written instructions, unless indicated otherwise. Unless noted otherwise, this provision does not apply to vertical wall joints where waterstop is installed.

F. Protection from Water: Place no concrete in any structure until water entering the space to be filled with concrete has been properly cut off or diverted and carried out of the forms, clear of the work. Deposit no concrete underwater without special methods. Do not allow still water to rise on any concrete until concrete has attained its initial set. Do not allow water to flow over the surface of any concrete in a manner and at a velocity that will damage the surface finish of the concrete. Pumping, dewatering and other necessary operations for removing ground water, if required, are subject to the Engineer's review.

G. Corrosion Protection: Position and support pipe, conduit, dowels and other ferrous items to be embedded in concrete construction prior to placement of concrete so there is at least a 2 inch clearance between them and any part of the concrete reinforcement. Do not secure such items in position by wiring or welding them to the reinforcement.

H. Where practicable, provide for openings for pipes, inserts for pipe hangers and brackets, and setting of anchors during placing of concrete.

I. Accurately set anchor bolts and maintain in position with templates while they are being embedded in concrete.

J. Cleaning: Immediately before concrete is placed, thoroughly clean dirt, grease, grout, mortar, loose scale, rust and other foreign substances from surfaces of metalwork to be in contact with concrete.

3.03 HANDLING, TRANSPORTING AND PLACING CONCRETE

A. Conform to applicable requirements of Chapter 8 of ACI 301 and this Section. Use no aluminum materials in conveying concrete.

B. Rejected Work: Remove concrete found to be defective or non-conforming in materials or workmanship. Replace rejected concrete with concrete meeting requirements of Contract Documents, at no additional cost to the Owner.

C. Unauthorized Placement: Place no concrete except in the presence of the Engineer. Notify the Engineer in writing at least 24 hours before placement of concrete.

D. Placement in Wall Forms:

1. Do not drop concrete through reinforcing steel that will not be covered by current pour.

2. Do not place concrete in any form so as to leave an accumulation of mortar on form surfaces above the concrete.

3. Pump concrete or use hoppers and, if necessary, vertical ducts of canvas, rubber or metal (other than aluminum) for placing concrete in forms so it reaches the place of final deposit without separation. Free fall of concrete shall not exceed 4 feet below the ends of pump hoses, ducts, chutes or buggies. Uniformly distribute concrete during depositing.

4. Do not displace concrete in forms more than 6 feet in horizontal direction from place where it was originally deposited. Do not transport concrete with vibrators.

5. Deposit in uniform horizontal layers not deeper than 2 feet; take care to avoid inclined layers or inclined construction joints except where required for sloping members.

6. Place each layer while the previous layer is still soft. Rate of placement shall not exceed 5 feet of vertical rise per hour.

7. Provide sufficient illumination in form interior so concrete at places of deposit is visible from the deck or runway.

E. Conveyors and Chutes: Design and arrange ends of chutes, hopper gates and other points of concrete discharge in the conveying, hoisting and placing system so concrete passing from them will not fall separated into whatever receptacle immediately receives it. Conveyors, if used, shall be of a type acceptable to the Engineer. Do not use chutes longer than 50 feet. Slope chutes so concrete of specified consistency will readily flow. If a conveyor is used, it shall be wiped clean by a device operated in such a manner that none of the mortar adhering to the belt will be wasted. All conveyors and chutes shall be covered.

F. Placement of Slabs: In hot or windy weather, conducive to plastic shrinkage cracks, apply evaporation retardant to slab after screeding in accordance with manufacturer's instructions and recommendations. Do not use evaporation retardant to increase water content of the surface cement paste. Place concrete for sloping slabs uniformly from the bottom of the slab to the top, for the full width of the placement. As work progresses, vibrate and carefully work concrete around slab reinforcement. Screed the slab surface in an up-slope direction.

G. When adverse weather conditions affect quality of concrete, postpone concrete placement. Do not mix concrete when the air temperature is at or below 40 degrees F and falling. Concrete may be mixed when temperature is 35 degrees F and rising. Take temperature readings in the shade, away from artificial heat. Protect concrete from temperatures below 32 degrees F until the concrete has cured for a minimum of 3 days at 70 degrees F or 5 days at 50 degrees F.

H. When concrete temperature is 85 degrees F or above, do not exceed 60 minutes between introduction of cement to the aggregates and discharge. When the weather is such that the concrete temperature would exceed 90 degrees F, employ effective means, such as pre-cooling of aggregates and mixing water, using ice or placing at night, as necessary to maintain concrete temperature, as placed, below 90 degrees F.

3.04 PUMPING OF CONCRETE

A. If pumped concrete does not produce satisfactory results, in the judgment of the Engineer, discontinue pumping operations and proceed with the placing of concrete using conventional methods.

B. Pumping Equipment: Use a 2-cylinder pump designed to operate with only one cylinder if one is not functioning, or have a standby pump on site during pumping.

C. The minimum hose (conduit) diameter: Comply with ACI 304.2R.

D. Replace pumping equipment and hoses (conduits) that do not function properly.

E. Do not use aluminum conduits for conveying concrete.

F. Field Control: Take samples for slump, air content and test cylinders at the placement (discharge) end of the line.

3.05 CONCRETE PLACEMENT SEQUENCE

A. Place concrete in a sequence acceptable to the Engineer. To minimize effects of shrinkage, place concrete in units bounded by construction joints shown. Place alternate units so each unit placed has cured at least 7 days for hydraulic structures, or 3 days for other structures, before contiguous unit or units are placed, except do not place corner sections of vertical walls until the 2 adjacent wall panels have cured at least 14 days for hydraulic structures and 7 days for other structures.

B. Level the concrete surface whenever a run of concrete is stopped. To ensure straight and level joints on the exposed surface of walls, tack a wood strip at least 3/4-inch thick to the forms on these surfaces. Carry concrete about 1/2-inch above the underside of the strip. About one hour after concrete is placed, remove the strip, level irregularities in the edge formed by the strip with a trowel and remove laitance.

3.06 TAMPING AND VIBRATING

A. Thoroughly settle and compact concrete throughout the entire depth of the layer being consolidated, into a dense, homogeneous mass; fill corners and angles, thoroughly embed reinforcement, eliminate rock pockets and bring only a slight excess of water to the exposed surface of concrete during placement. Use ACI 309R Group 3 immersion-type high-speed power vibrators (8,000 to 12,000 rpm) in sufficient number and with

sufficient (at least one) standby units. Use Group 2 vibrators only when accepted by the Engineer for specific locations.

B. Use care in placing concrete around waterstops. Carefully work concrete by rodding and vibrating to make sure air and rock pockets have been eliminated. Where flat-strip type waterstops are placed horizontally, work concrete under waterstops by hand, making sure air and rock pockets have been eliminated. Give concrete surrounding the waterstops additional vibration beyond that used for adjacent concrete placement to assure complete embedment of waterstops in concrete.

C. Concrete in Walls: Internally vibrate, ram, stir, or work with suitable appliances, tamping bars, shovels or forked tools until concrete completely fills forms or excavations and closes snugly against all surfaces. Do not place subsequent layers of concrete until previously-placed layers have been so worked. Provide vibrators in sufficient numbers, with standby units as required, to accomplish the results specified within 15 minutes after concrete of specified consistency is placed in the forms. Keep vibrating heads from contact with form surfaces. Take care not to vibrate concrete excessively or to work it in any manner that causes segregation of its constituents.

3.07 PLACING MASS CONCRETE

A. Observe the following additional restrictions when placing mass concrete.

1. Use specified superplasticizer.
2. Maximum temperature of concrete when deposited: 70 degrees F.
3. Place in lifts approximately 18 inches thick. Extend vibrator heads into previously-placed layer.

3.08 REPAIRING SURFACE DEFECTS AND FINISHING

A. Conform to Section 03300 - Cast-in-Place Concrete.

3.09 CURING

A. Conform to Section 03300 - Cast-in- Place Concrete.

3.10 PROTECTION

A. Protect concrete against damage until final acceptance by the Owner.

B. Protect fresh concrete from damage due to rain, hail, sleet or snow. Provide such protection while the concrete is still plastic and whenever such precipitation is imminent or occurring.

C. Do not backfill around concrete structures or subject them to design loadings until all components of the structure needed to resist the loading are complete and have reached the specified 28-day compressive strength, except as authorized otherwise by the Engineer.

END OF SECTION