Standard Specifications

for Road, Bridge, and Municipal Construction

2021

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Washington State
Department of Transportation

AMERICAN PUBLIC WORKS ASSOCIATION
APWA
Washington State Chapter

Americans with Disabilities Act (ADA) Information

Title VI Notice to Public It is the Washington State Department of Transportation's (WSDOT) policy to assure that no person shall, on the grounds of race, color, national origin or sex, as provided by Title VI of the Civil Rights Act of 1964, be excluded from participation in, be denied the benefits of, or be otherwise discriminated against under any of its programs and activities. Any person who believes his/her Title VI protection has been violated, may file a complaint with WSDOT's Office of Equal Opportunity (OEO). For additional information regarding Title VI complaint procedures and/or information regarding our non-discrimination obligations, please contact OEO's Title VI Coordinator at 360-705-7090.

Foreword

These *Standard Specifications for Road, Bridge, and Municipal Construction* have been developed to serve as a baseline for the work delivered to the public by the Washington State Department of Transportation (WSDOT). The *Standard Specifications* are incorporated into the written agreement (Contract) between WSDOT as Contracting Agency and the Contractor, except where the Contract indicates that a particular specification has been amended or replaced with a special provision to resolve project-specific issues. The decision to amend or replace any standard specification with a special provision is made during the design process and is based upon the sound engineering judgment of the project designer.

These *Standard Specifications* reflect years of refinement through the literally hundreds of projects the Department delivers each year. In addition, the standards are the result of countless hours of development and review by both our internal WSDOT staff as well as our industry partners through the joint WSDOT/Associated General Contractors' Standing Committees.

Finally, these standards reflect the contracting philosophy and balance of risk-allocation that the Department has adopted through the years. We believe that this balance of risks provides us the lowest final cost solution to our transportation needs. For example, shifting risk to the Contractor can provide more certainty on final cost, but may result in higher initial cost. On the other hand, accepting more risk by the owner can result in lower initial costs, but less certainty on the final cost. We at the Department of Transportation believe that we have reached the optimum point of balance for risk, and we will continue to consider this balance on all future specification revisions.

The language above indicates that these specifications are to be used only as a guideline during the design process, and that is true. Once they have been incorporated into a Contract, however, they become the legal and enforceable language of that Contract. The *Standard Specifications*, and the Project Special Provisions, along with any attachments in the Contract documents, define a Contract and are no longer seen as guidelines. Rather, they are the written agreement, subject to revision only through the change order process.

This preface is for informational purposes only and is not to be used to interpret or affect the terms.

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State Construction Engineer

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Division 1 General Requirements

1-01 Definitions and Terms

1-01.1 General

The following abbreviations and terms are defined here as they are used in any Contract documents and Specifications. When used in the Proposal Form to denote items of Work and units of measurements, abbreviations are defined to mean the full expression.

1-01.2 Abbreviations

1-01.2(1) Associations and Miscellaneous

These abbreviations are used in Plans and Specifications as defined here:

AAA	American Arbitration Association
AAR	Association of American Railroads
AASHTO	American Association of State Highway and Transportation Officials
ACI	American Concrete Institute
AGA	American Gas Association
AGC	Associated General Contractors of America
AI	Asphalt Institute
AIA	American Institute of Architects
AISC	American Institute of Steel Construction
AISI	American Iron and Steel Institute
AITC	American Institute of Timber Construction
AMS	Aerospace Material Specification
ANLA	American Nursery and Landscape Association
ANSI	American National Standards Institute
APA	American Plywood Association
API	American Petroleum Institute
APWA	American Public Works Association
ARA	American Railway Association
AREMA	American Railway Engineering and Maintenance Association
ARTBA	American Road & Transportation Builders Association
ASA	American Standards Association
ASCE	American Society of Civil Engineers
ASLA	American Society of Landscape Architects
ASME	American Society of Mechanical Engineers
ASNT	American Society for Nondestructive Testing
ASTM	American Society for Testing and Materials International
AWPA	American Wood Protection Association

AWS	American Welding Society
AWWA	American Water Works Association
CFR	Code of Federal Regulations
CLI	Chain Link Institute
CRAB	County Road Administration Board
CRSI	Concrete Reinforcing Steel Institute
DIPRA	Ductile Iron Pipe Research Association
ECY	Washington State Department of Ecology
EEI	Edison Electric Institute
EPA	Environmental Protection Agency
ESAL	Equivalent Single Axle Loads
FHWA	Federal Highway Administration
FOP	Field Operating Procedure
FSS	Federal Specifications and Standards, General Services Administration
HUD	United States Department of Housing and Urban Development
ICEA	Insulated Cable Engineers Association
IEEE	Institute of Electrical and Electronics Engineers
ITE	Institute of Transportation Engineers
IES	Illumination Engineering Society
IMSA	International Municipal Signal Association
LID	Local Improvement District
LPI	Lighting Protection Institute
MSHA	Mine Safety and Health Act
MUTCD	Manual on Uniform Traffic Control Devices
NEC	National Electrical Code
NEMA	National Electrical Manufacturers' Association
NEPA	National Environmental Policy Act
NFPA	National Fire Protection Association
NIST	National Institute of Standards and Technology
NRMCA	National Ready Mix Concrete Association
OMWBE	Office of Minority and Women's Business Enterprises
OSHA	Occupational Safety and Health Administration
PCA	Portland Cement Association
PPI	Plastic Pipe Institute
P/PCI	Precast/Prestressed Concrete Institute
QPL	Qualified Products List
RAM	Request for Approval of Material
RCW	Revised Code of Washington (Laws of the State)
RID	Road Improvement District
SAE	Society of Automotive Engineers
SEPA	State Environmental Policy Act

SOP	Standard Operating Procedure
SSPC	Society of Protective Coatings
TIB	Transportation Improvement Board
UL	Underwriters Laboratories
ULID	Utility Local Improvement District
UMTA	Urban Mass Transit Administration
WAC	Washington Administrative Code
WAQTC	Western Alliance for Quality Transportation Construction
WCLIB	West Coast Lumber Inspection Bureau
WISHA	Washington Industrial Safety and Health Administration
WRI	Wire Reinforcement Institute
WSDOT	Washington State Department of Transportation
WWPA	Western Wood Products Association

1-01.2(2) Items of Work and Units of Measurement

Plans and Specifications may include common engineering and construction abbreviations. Many such abbreviations need no definition. But when the following abbreviations are used, they will only mean:

Agg.	Aggregate
Al.	Aluminum
BST	Bituminous Surface Treatment
Cl.	Class
Cfm	Cubic Feet per Minute
Cfs	Cubic Feet per Second
Comb.	Combination
Conc.	Concrete
CPF	Composite Pay Factor
Crib.	Cribbing
Culv.	Culvert
cy or cu yd.	Cubic Yard
Diam.	Diameter
ESAL	Equivalent Single Axle Loads
Est.	Estimate or Estimated
Excl.	Excluding
F	Fahrenheit
gph	Gallon per Hour
gpm	Gallon per Minute
Hund.	Hundred
HMA	Hot Mix Asphalt
In.	Inch
Incl.	Including

JMCIF	Job Mix Compliance Incentive Factor
JMF	Job Mix Formula
lb	Pound(s)
LF or Lin. Ft.	Linear Foot (Feet)
LS	Lump Sum
M	Thousand
MBM	Thousand Feet Board Measure
MUTS	Minimum Ultimate Tensile Strength
PCPS	Precast Prestressed
Pres.	Pressure
psf	Pounds per Square Foot
psi	Pounds per Square inch
PVC	Polyvinyl Chloride
RAP	Recycled Asphalt Pavement
Reg.	Regulator
Reinf.	Reinforced, Reinforcing
Sec.	Section
St.	Steel
Str.	Structural
sy or sq. yd.	Square Yard(s)
Th.	Thick or Thickness
Tr.	Treatment
Va	Air Voids
VC	Vitrified Clay
VFA	Voids Filled with Asphalt
VMA	Voids in Mineral Aggregate

1-01.3 Definitions

Addendum – A written or graphic document, issued to all Bidders and identified as an Addendum prior to Bid opening, which modifies or supplements the Bid Documents and becomes a part of the Contract.

Auxiliary Lane – The part of the Roadway next to Traveled Ways for parking, speed changes, turning, weaving, truck climbing, or for anything that adds to through traffic movement.

Award – The formal decision of the Contracting Agency to accept the lowest responsible and responsive Bidder for the Work.

Bid, Proposal – The offer of a Bidder on a properly completed Proposal Form to perform the Contract.

Bidder – An individual, partnership, firm, corporation, or joint venture, submitting a Proposal or Bid. When required by law or otherwise the individual, partnership, firm, corporation, or joint venture shall be prequalified.

Bid Documents – The component parts of the proposed Contract which may include, but are not limited to, the Proposal Form, the proposed Contract Provisions, the proposed Contract Plans, Addenda, and for projects with Contracting Agency subsurface investigations; the Summary of Geotechnical Conditions and subsurface boring logs (if any).

Bridge Approach Embankments – An embankment beneath a Structure and extending 100 feet beyond a Structure's end (at Subgrade elevation for the full embankment width) plus an access ramp on a 10:1 slope to the original ground elevation. Also, any embankment that replaces unsuitable foundation soil beneath the Bridge Approach Embankment.

Call for Bids (Advertisement for Bids) – The published public notice soliciting Proposals or Bids for Work stating, among other things, the time, place, and date for receiving and opening the Bids.

Cold Weather Protection Period – A period of time 7 days from the day of concrete placement or the duration of the cure period, whichever is longer.

Commission, Washington State Transportation Commission – The appointive body having authority over state transportation matters as provided by law.

Completion Dates – Substantial Completion Date is the day the Engineer determines the Contracting Agency has full and unrestricted use and benefit of the facilities, both from the operational and safety standpoint, all the initial plantings are completed and only minor incidental work, replacement of temporary substitute facilities, plant establishment periods, or correction or repair remains for the Physical Completion of the total Contract.

Physical Completion Date is the day all of the Work is physically completed on the project. All documentation required by the Contract and required by law does not necessarily need to be furnished by the Contractor by this date.

Completion Date is the day all the Work specified in the Contract is completed and all the obligations of the Contractor under the Contract are fulfilled by the Contractor. All documentation required by the Contract and required by law must be furnished by the Contractor before establishment of this date.

Contract – The written agreement between the Contracting Agency and the Contractor. It describes, among other things:

1. What work will be done, and by when;
2. Who provides labor and materials; and
3. How Contractors will be paid.

The Contract includes the Contract (agreement) Form, Bidder's completed Proposal Form, Contract Provisions, Contract Plans, *Standard Specifications*, *Standard Plans*, Addenda, various certifications and affidavits, supplemental agreements, change orders, and subsurface boring logs (if any).

Contract Bond – The approved form of security furnished by the Contractor and the Contractor's Surety as required by the Contract, that guarantees performance of all the Work required by the Contract and payment to anyone who provides supplies or labor for the performance of the Work.

Contract Form (Agreement Form) – The form provided by the Contracting Agency that requires the authorized signatures of the Contractor and the Contracting Agency to result in formal execution of the Contract.

Contracting Agency – Agency of Government that is responsible for the execution and administration of the Contract.

Contractor – The individual, partnership, firm, corporation, or joint venture, Contracting with the Contracting Agency to do prescribed Work.

Contract Plans – A publication addressing the Work required for an individual project. At the time of the call for Bids, the Contract Plans may include, but are not limited to, the following: a vicinity map, a summary of quantities, structure notes, signing information, traffic control plans, and detailed drawings; all for a specific individual project. At the time of the Contract execution date, the Contract Plans include any Addenda.

Contract Provisions – A publication addressing the Work required for an individual project. At the time of the call for Bids, the Contract Provisions may include, for a specific individual project, the Special Provisions, a listing of the applicable *Standard Plans*, the prevailing minimum hourly wage rates, and an informational Proposal Form with the listing of Bid items. The proposed Contract Provisions may also include, for a specific individual project, the Required Contract Provisions Federal-aid Construction Contracts, and various required certifications or declarations. At the time of the Contract execution date, the Contract Provisions include the proposed Contract Provisions and include any Addenda, a copy of the Contract Form, and a copy of the Proposal Form with the Contract prices and extensions.

Department, Department of Transportation – The State Agency authorized by law to administer transportation-related work.

Engineer – The Contracting Agency's representative who directly supervises the engineering and administration of a construction Contract.

Federal Highway Administration – The Federal Agency authorized to approve plans and contracts for Federal-Aid Highway projects. They also inspect such projects to ensure Contract compliance.

Frontage Road – A local street or road usually next to an arterial Highway that serves abutting property and adjacent areas and controls access.

Highway – A public way for vehicles, including the entire Right of Way.

Inspector – The Engineer's representative who inspects Contract performance in detail.

Laboratory – The laboratories of the Contracting Agency, or other laboratories the Contracting Agency authorizes to test Work, soils, and materials.

Plans – The Contract Plans or *Standard Plans* which show location, character, and dimensions of prescribed Work including layouts, profiles, cross-sections, and other details.

Project Engineer – Same as Engineer.

Proposal Form – The form provided to Bidders by the Contracting Agency for submittal of a Proposal or Bid to the Contracting Agency for a specific project. The form includes the item number, estimated plan quantity, and item description of the Bid items along with blank spaces to be completed by the Bidder for the unit prices, extensions, the total Bid amount, signatures, date, acknowledgment of Addenda, and the Bidder's address. The required certifications and declarations are part of the form.

Reference Information – Information provided to the Contractor by the Contracting Agency that is not part of the Contract.

Right of Way – Land, property, or property interest, usually in a strip, acquired for or devoted to transportation purposes.

Roadbed – The graded part of the Roadway within top and side slopes, prepared as a foundation for the pavement structure and Shoulders.

Roadside – The area outside the traveled way.

Roadway – The portion of the Right of Way within the outside limits of the side slopes.

Secretary, Secretary of Transportation – The chief executive officer of the Department and other authorized representatives.

Shoulder – The part of the Roadway next to the Traveled Way or Auxiliary Lanes. It provides lateral support of base and surface courses and is an emergency stopping area for vehicles.

Sensitive Area – Natural features, which may be previously altered by human activity, that are present on or adjacent to the project location and protected, managed, or regulated by local, tribal, state, or federal agencies.

Special Provisions – Supplemental Specifications and modifications to the Standard Specifications that apply to an individual project.

Specifications – Provisions and requirements for the prescribed Work.

Standard Plans – A manual of specific plans or drawings adopted by the Contracting Agency which show frequently recurring components of Work that have been standardized for use.

State – The state of Washington acting through its representatives.

Structures – Bridges, culverts, catch basins, drop inlets, retaining walls, cribbing, manholes, endwalls, buildings, service pipes, sewers, underdrains, foundation drains, and other features found during Work that the Contract may or may not classify as a Structure.

Subcontractor – An individual, partnership, firm, corporation, or joint venture who is sublet part of the Contract by the Contractor.

Subgrade – The top surface of the Roadbed on which subbase, base, surfacing, pavement, or layers of similar materials are placed.

Substructure – The part of the Structure *below*:

1. The bottom of the grout pad for the simple and continuous span bearing, or
2. The bottom of the girder or bottom slab soffit, or
3. Arch skewbacks and construction joints at the top of vertical abutment members or rigid frame piers.

Substructures include endwalls, wingwalls, barrier and railing attached to the wingwalls, and cantilever barriers and railings.

Superstructure – The part of the Structure *above*:

1. The bottom of the grout pad for the simple and continuous span bearing, or
2. The bottom of the block supporting the girder, or
3. Arch skewbacks and construction joints at the top of vertical abutment members or rigid frame piers.

Longitudinal limits of the Superstructure extend from end to end of the Structure in accordance with the following criteria:

1. From the face of end diaphragm abutting the bridge approach embankment for end piers without expansion joints, or
2. From the end pier expansion joint for bridges with end pier expansion joints

Superstructures include, but are not limited to, the bottom slab and webs of box girders, the bridge deck and diaphragms of all bridges, and the sidewalks when shown on the bridge deck. The Superstructure also includes the girders, expansion joints, bearings, barrier, and railing attached to the Superstructure when such Superstructure components are not otherwise covered by separate unit measured or lump sum bid items.

Superstructures do not include endwalls, wingwalls, barrier and railing attached to the wingwalls, and cantilever barriers and railings unless supported by the Superstructure.

Surety – A company that is bound with the Contractor to ensure performance of the Contract, payment of all obligations pertaining to the Work, and fulfillment of such other conditions as are specified in the Contract, Contract Bond, or otherwise required by law.

Titles (or Headings) – The titles or headings of the Sections and Subsections herein are intended for convenience of reference and shall not be considered as having any bearing on their interpretation.

Traveled Way – That part of the Roadway made for vehicle travel excluding Shoulders and Auxiliary Lanes.

Work – The provision of all labor, materials, tools, equipment, and everything needed to successfully complete a project according to the Contract.

Working Drawings – Drawings, plans, diagrams, or any other supplementary data or calculations, including a schedule of submittal dates for Working Drawings where specified, which the Contractor must submit to the Engineer.

WSDOT Form – Forms developed and maintained by WSDOT that are required or available for use on a project. These forms can be downloaded from the forms catalogue at: www.wsdot.wa.gov/forms/pdfforms.html

1-02 Bid Procedures and Conditions

1-02.1 Prequalification of Bidders

The Contracting Agency will provide a Bid Proposal Form only after a prospective Bidder submits a "Standard Questionnaire and Financial Statement". This questionnaire enables the Contracting Agency to decide whether or not the Bidder is qualified to perform Highway, road, or other public work. The questionnaire shall be sworn to before a person authorized to take oaths.

On the basis of this questionnaire, the Contracting Agency will either specify the type and amount of Work it considers the prospective Bidder prequalified to perform or advise the prospective Bidder of the reasons they failed to be prequalified. To remain prequalified, the Bidder must submit an updated questionnaire once a year and supplements whenever required by the Contracting Agency.

A submittal deadline applies to any prospective Bidder not prequalified or from whom a supplemental questionnaire is due. To receive consideration for issuance of a Bid Proposal Form on a specific project, the questionnaire (or supplement) must be received by the Prequalification Engineer no less than 15 days prior to the scheduled Bid opening.

The Contracting Agency may withdraw a Bidder's prequalification or reduce its amount if:

1. The extent of other work the Bidder has under Contract (Contracting Agency or otherwise) justifies such action, or
2. Past or present work on a Contracting Agency Contract has been less than satisfactory.

If a Bidder's questionnaire does not contain sufficient information, the Contracting Agency may refuse to provide a Bid Proposal Form and disregard any Bid submitted. After opening Bids, the Contracting Agency may decide that a prequalified Bidder is not responsible and may refuse to accept the Bid on that basis. Such a refusal will be conclusive unless the Bidder appeals within five days to the Superior Court of Thurston County. Any appeal shall be heard within ten days after it is filed and shall provide at least five days' notice to the Contracting Agency.

The Bidder shall ensure that the combination of the Bid amount and other Contract work with the Contracting Agency does not exceed the prequalification amount. If this combination does exceed the prequalification amount, the Contracting Agency may determine the Bidder to be not responsible and refuse to Award a Contract.

Two or more prospective Bidders may, in a joint venture, prequalify and Bid jointly on a single Contract. Each shall have filed a "Standard Questionnaire and Financial Statement". Together they shall also file a standard form of "Individual Project Statement of Joint Venture" and a joint venture agreement in a form acceptable to the Contracting Agency.

To Bid jointly on a continuous joint venture on more than one Contract, two or more prospective Bidders shall submit:

1. A "Standard Questionnaire and Financial Statement" compiled for the joint venture;
2. A "Standard Questionnaire and Financial Statement" for each member (if the Contracting Agency has no copy on file); and
3. A copy of the "Joint Venture Agreement" signed by each member of the joint venture and naming each person authorized to sign documents on its behalf. (If any member is a corporation, a corporate resolution shall accompany the agreement. This resolution shall authorize the joint venture agreement and name the officer(s) authorized to sign the joint venture agreement or Contract on behalf of the corporation.)

The Contracting Agency will treat the continuing joint venture as a new firm and decide its prequalification on that basis.

Any joint venture and each of its members is subject to Section 1-02.14.

1-02.2 Plans and Specifications

The Contracting Agency will place review copies of the Plans and Specifications on file in the offices of:

1. All Regional Administrators of the Department;
2. The County Engineer of the county in which the Work is located; and
3. These plans service offices of the Associated General Contractors of America: Seattle, Spokane, and Tacoma, Washington.

Prospective Bidders may purchase Plans and Specifications from the Department of Transportation in Olympia, Washington, for the fee given in the call for Bids. The fee shall accompany each request for Plans. Checks shall be payable to the State of Washington, Department of Transportation.

After Award of the Contract, the Plans and Specifications will be issued without charge on the following basis:

To Contractor	No. of Sets	Basis of Distribution
Reduced Plans (11″ by 17″) and Special Provision	10	Furnished automatically upon Award.
Additional reduced Plans (11″ by 17″) and Special Provision	10	Furnished only upon request for projects with more than 100 plan sheets.
Large Plans (22″ by 34″) and Special Provisions	1	Furnished automatically upon award.
Additional large Plans (22″ by 34″) and Special Provisions	1	Furnished only upon request for projects with more than 100 plan sheets.

To Subcontractors and Suppliers	No. of Sets	Basis of Distribution
Reduced Plans (11″ by 17″) and accompanying Special Provisions	1	Furnished only upon request by the Contractor for an approved Subcontractor or material supplier.

Additional Plans may be purchased by payment of the current rates.

1-02.3 Estimated Quantities

The quantities shown in the Proposal Form and the Contract Forms are estimates and are stated only for Bid comparison purposes. The Contracting Agency does not warrant expressly or by implication, that the actual quantities of Work will correspond with those estimates. Payment will be made on the basis of the actual quantities of each item of Work completed in accordance with the Contract requirements.

1-02.4 Examination of Plans, Specifications, and Site of Work

1-02.4(1) General

The Bidder shall carefully examine the Bid Documents as defined in Section 1-01.3. Submittal of a Bid shall be conclusive evidence that the Bidder has made these examinations and understands all requirements for the performance of the completed Work. The Bidder further warrants, agrees, and acknowledges by submitting a Bid that it:

1. Has taken steps reasonably necessary to ascertain the nature and location of the Work;
2. Has investigated and satisfied itself as to the general and local conditions which can affect the Work or its cost, including but not limited to:
    a. Conditions bearing upon acquisition, transportation, disposal, handling, and storage of materials;
    b. The availability of labor, materials, water, electric power, and roads;
    c. Uncertainties of weather, river stages, tides, or similar physical conditions at the site;
    d. The conformation and condition of the ground;
    e. The character of equipment and facilities needed preliminary to and during Work performance; and
    f. The site biological hazards and associated physical hazards.
3. Has satisfied itself as to the character, quality, and quantity of surface and subsurface materials or obstacles to be encountered insofar as this information is reasonably ascertainable from an inspection of the Work site (including material sites) as well as from the Bid Documents and other information made a part of this Contract; and
4. Has satisfied itself as to the adequacy of time allowed for the completion of the physical Work on the Contract.

Any failure of the Bidder to take the actions described and acknowledged in this clause shall not relieve the Bidder from responsibility for estimating properly the difficulty and cost of successfully performing the Work, or from proceeding to successfully perform the Work without additional expense to the Contracting Agency.

The Bidder agrees that the Contracting Agency shall not be liable to it on any claim for additional payment or additional time or any claim whatsoever if the claim directly or indirectly results from the Bidder's failure to investigate and familiarize itself sufficiently with the conditions under which the Contract is to be performed.

The Bidder shall be familiar and comply with all Federal, State, tribal, and local laws, ordinances, and regulations which might affect those engaged in the Work. The Contracting Agency will not consider any plea of misunderstanding or ignorance of such requirements.

Bid prices shall reflect what the Bidder anticipates to be the cost of completing the Work, including methods, materials, labor, and equipment. Except as the Contract may provide, the Bidder shall receive no payment for any costs that exceed those in the Bid prices.

Prospective Bidders are advised that projects with Work on or adjacent to water may require insurance coverage in compliance with:

1. The Longshoremen's and Harbor Worker's Compensation Act (administered by U.S. Department of Labor), or
2. The State Industrial Insurance (administrated by the Washington State Department of Labor and Industries), or
3. Both.

The Contractor shall bear all cost for such insurance as provided in Section 1-07.10.

No Claim shall be allowed because of any ambiguity in the Contract if:

1. The Bidder discovers an ambiguity but fails to notify the Contracting Agency, or
2. The Bidder failed to discover a patent ambiguity that would be discovered by a reasonably prudent contractor in preparing its Bid.

Any prospective Bidder desiring an explanation or interpretation of the Bid Documents, shall request the explanation or interpretation in writing by close of business on the Thursday preceding the bid opening to allow a written reply to reach all prospective Bidders before the submission of their Bids. Oral explanations, interpretations, or instructions given by anyone before the Award of a Contract will not be binding on the Contracting Agency. Any information given a prospective Bidder concerning any of the Bid Documents will be furnished to all prospective Bidders as an Addendum if that information is deemed by the Contracting Agency to be necessary in submitting Bids or if the Contracting Agency concludes that the lack of the information would be prejudicial to other prospective Bidders.

Any information provided by the Contracting Agency for inspection by the Bidders as Reference Information will be made available for inspection at the location specified in the Special Provisions. The availability of Reference Information from the Contracting Agency shall not relieve the Bidder or the Contractor from any risks or of any duty to make examinations and investigations as required by this section or any other responsibility under the Contract or as may be required by law.

Prospective Bidders are advised that the Contracting Agency may include a partially completed Washington State Department of Ecology (Ecology) Transfer of Coverage (Ecology form ECY 020-87a) for the Construction Stormwater General Permit (CSWGP) as part of the Bid Documents. When the Contracting Agency requires the transfer of coverage of the CSWGP to the Contractor, an informational copy of the Transfer of Coverage and the associated CSWGP will be included in the appendices. As a condition of Section 1-03.3, the Contractor is required to complete sections I, III, and VIII of the Transfer of Coverage and return the form to the Contracting Agency.

The Contracting Agency is responsible for compliance with the CSWGP until the end of day that the Contract is executed. Beginning on the day after the Contract is executed, the Contractor shall assume complete legal responsibility for compliance with the CSWGP and full implementation of all conditions of the CSWGP as they apply to the Contract Work.

1-02.4(2) Subsurface Information

If the Contracting Agency has made subsurface investigation of the site of the proposed Work, the boring log data, soil sample test data, and geotechnical recommendations reports obtained by the Contracting Agency will be made available for inspection by the Bidders as Reference Information. The Summary of Geotechnical Conditions, as an appendix to the Special Provisions, and the boring logs shall be considered as part of the Contract. However, the Contracting Agency makes no representation or warranty expressed or implied that:

1. The Bidders' interpretations from the boring logs are correct,
2. Moisture conditions and indicated water tables will not vary from those found at the time the borings were made, and
3. The ground at the location of the borings has not been physically disturbed or altered after the boring was made.

The Contracting Agency specifically makes no representations, guarantees, or warranties as to the condition, materials, or proportions of the materials between the specific borings regardless of any subsurface information the Contracting Agency may make available to the prospective Bidders.

The availability of subsurface information from the Contracting Agency shall not relieve the Bidder or the Contractor from any risks or of any duty to make examinations and investigations as required by Section 1-02.4(1) or any other responsibility under the Contract or as may be required by law.

1-02.5 Proposal Forms

At the request of a Bidder, the Contracting Agency will provide a physical Proposal Form for any project on which the Bidder is eligible to Bid. For certain projects selected at the sole discretion of the Contracting Agency, the Bidder may also be authorized to access an electronic Proposal Form for submittal via Trns·Port Expedite® software and BidExpress®.

The Proposal Form will identify the project and its location and describe the Work. It will also list estimated quantities, units of measurement, the items of Work, and the materials to be furnished at the unit Bid prices. The Bidder shall complete spaces on the Proposal Form that call for unit prices, extensions, the total Bid amount, signatures, date, acknowledgment of Addenda, and the Bidder's address. The required certifications are included as part of the Proposal Form.

1-02.6 Preparation of Proposal

The Contracting Agency will accept only those Proposals properly executed on the physical forms it provides, or electronic forms that the Bidder has been authorized to access. Unless it approves in writing, the Contracting Agency will not accept Proposals on forms attached to the Plans and stamped "Informational".

All prices shall be in legible figures (not words) written in ink or typed, and expressed in U.S. dollars and cents. The Proposal shall include:

1. A unit price for each item (omitting digits more than two places to the right of the decimal point),
2. An extension for each unit price (omitting digits more than two places to the right of the decimal point), and
3. The total Contract price (the sum of all extensions).

In the space provided on the signature sheet, the Bidder shall confirm that all Addenda have been received.

The Bidder shall submit with the Bid a completed Disadvantaged Business Enterprise (DBE) Utilization Certification, when required by the Special Provisions. For each and every DBE firm listed on the Bidder's completed Disadvantaged Business Enterprise Utilization Certification, the Bidder shall submit written confirmation from that DBE firm that the DBE is in agreement with the DBE participation commitment that the Bidder has made in the Bidder's completed Disadvantaged Business Enterprise Utilization Certification. WSDOT Form 422-031 (Disadvantaged Business Enterprise Written Confirmation Document) is available for this purpose. Bidder must submit good faith effort documentation with the Disadvantaged Business Enterprise Utilization Certification **ONLY In The Event** the bidder's efforts to solicit sufficient DBE participation have been unsuccessful. Directions for delivery of the Disadvantaged Business Enterprise Written Confirmation Documents and Disadvantaged Business Enterprise Good Faith Effort documentation are included in Sections 1-02.9 and 1-02.10.

The Bidder shall submit with the Bid a list of:

1. Subcontractors who will perform the work of structural steel installation, rebar installation, heating, ventilation, air conditioning, and plumbing as described in RCW 18.106 and electrical as described in RCW 19.28, and
2. The work those Subcontractors will perform on the Contract.
3. Shall not list more than one Subcontractor for each category of work identified, except, when Subcontractors vary with Bid alternates, in which case the Bidder shall identify which Subcontractor will be used for which alternate.

If no Subcontractor is listed, the Bidder acknowledges that it does not intend to use any Subcontractor to perform those items of work.

The Bidder shall submit with their Bid a completed Contractor Certification Wage Law Compliance form (WSDOT Form 272-009). Failure to return this certification as part of the Bid Proposal package will make this Bid Nonresponsive and ineligible for Award. A Contractor Certification of Wage Law Compliance form is included in the Proposal Forms.

Proposals of corporations shall be signed by the officer or officers having authority to sign them. If a Bidder is a copartnership, the Proposal shall be signed by an authorized member of the copartnership. When the Bidder is a joint venture, the Proposal shall be signed by one or more individuals as authorized by the Joint Venture.

1-02.7 Bid Deposit

A deposit of at least 5 percent of the total Bid shall accompany each Bid. This deposit may be cash, certified check, cashier's check, or a proposal bond (Surety bond). For projects that are selected by the Contracting Agency to be Bid electronically, the proposal bond may be in either a physical format, or an electronic format via Surety2000.com or Insurevision.com and BidExpress®. When a physical Bid deposit or proposal bond is furnished to accompany an electronic Proposal Form, the Bid deposit shall be received by the Contracting Agency at the location specified for receipt of Bids prior to the time set for receipt of Bids. Any proposal bond shall be on a form acceptable to the Contracting Agency and shall be signed by the Bidder and the Surety. A proposal bond shall not be conditioned in any way to modify the minimum 5 percent required. The Surety shall: (1) be registered with the Washington State Insurance Commissioner, and (2) appear on the current Authorized Insurance List in the State of Washington published by the Office of the Insurance Commissioner.

The failure to furnish a Bid deposit of a minimum of 5 percent with the Bid or as a physical supplement to the electronic Proposal Form shall make the Bid nonresponsive and shall cause the Bid to be rejected by the Contracting Agency.

1-02.8 Noncollusion Declaration and Lobbying Certification

1-02.8(1) Noncollusion Declaration

When required by Section 112(c) Title 23, United States Code, a declaration shall be provided certifying that the Bidder has not taken part in collusion or other action that would restrain competitive Bidding.

The Code of Federal Regulations 23 CFR 635.112(f)(1) requires that: "Each Bidder shall file a sworn or unsworn statement executed by, or on behalf of the person, firm, association, or corporation submitting the Bid, certifying that such persons, firm, association, or corporation has not either directly or indirectly, entered into any agreement, participated in any collusion, or otherwise taken any action in restraint of free competitive Bidding in connection with the submitted Bid. Failure to submit the sworn or unsworn statement as part of the Bid Proposal package will make the Bid nonresponsive and not eligible for Award consideration". In addition, 23 CFR 635.112(f)(1) requires that the Contracting Agency provide the form for the declaration to prospective Bidders and that the declaration shall be executed by such persons, firm, association, or corporation under penalty of perjury under the laws of the United States.

Therefore, by including the Non-collusion Declaration as part of the signed bid Proposal, the Bidder is deemed to have certified and agreed to the requirements of the Declaration.

1-02.8(2) Lobbying Certification

Section 319 of Public Law 101-121 prohibits payment of Federal Funds for contract lobbying by the Contractor and any Subcontractor or lower tier subcontractor whose contract exceeds $100,000. A Certification for Federal-Aid Contracts (WSDOT Form 272-040) is provided in the Proposal Form for Contracts exceeding $100,000 to address this requirement.

By signing the proposal, the Bidder will be deemed to have signed and agreed to the conditions and requirements of the Certification for Federal-Aid Contracts.

The Contractor shall ensure that a Certification for Federal-Aid Contracts (WSDOT Form 272-040) is included in every contract with any Subcontractor or lower tier subcontractor whose contract exceeds $100,000. By signing the contract any Subcontractor or lower tier subcontractor will be deemed to have signed and agreed to the conditions and requirements of the Certification for Federal-Aid Contracts. The Contractor shall keep evidence in their files that such Subcontractor or lower tier subcontractor has committed to this requirement.

Section 319 of Public Law 101-121 also provides that, if any funds other than Federal appropriated funds have been paid or will be paid to any person for influencing or attempting to influence an officer or employee of any Federal agency, a Member of Congress, an officer or employee of Congress, or an employee of a Member of Congress in connection with this Federal Contract, grant, loan, or cooperative agreement, the Contractor shall complete and submit to the Contracting Agency the Standard Form LLL, DISCLOSURE OF LOBBYING ACTIVITIES, in accordance with the instructions

on the form. Any Subcontractor or lower tier subcontractor whose contract exceeds $100,000 shall disclose in the same manner as the Contractor, except that, Standard Form LLL shall be submitted to the Contractor for processing to the Contracting Agency.

Audits will be conducted to ensure compliance with this section.

The Certification for Federal-Aid Contracts (WSDOT Form 272-040) may be reproduced from the Proposal form. The disclosure form is available from the Washington State Department of Transportation's Contract Ad and Award Office, Transportation Building, Olympia, WA 98504.

1-02.9 Delivery of Proposal

For projects scheduled for Bid opening in Olympia, the Proposal shall be sealed and submitted in the envelope provided with it to the address provided below or shall be submitted electronically via Trns·Port Expedite® software and BidExpress®. The Bidder shall fill in all blanks on this envelope to ensure proper handling and delivery. Bids are to be received no later than until 11:00:59 A.M. Pacific time on the date of Bid opening:

Washington State Department of Transportation
Room 2D20
310 Maple Park Avenue SE
Olympia WA 98501-2361

For projects scheduled for Bid opening in other locations, the Proposal shall be sealed and submitted in the envelope provided with it at the location and time identified in the Special Provisions. The Bidder shall fill in all blanks on this envelope to ensure proper handling and delivery.

Proposals that are received as required will be publicly opened and read as specified in Section 1-02.12. The Contracting Agency will not open or consider any Proposal when the Proposal or Bid deposit is received after the time specified for receipt of Proposals or received in a location other than that specified for receipt of Proposals unless an emergency or unanticipated event interrupts normal work processes of the Contracting Agency so that Proposals cannot be received.

If an emergency or unanticipated event interrupts normal work processes of the Contracting Agency so that Proposals cannot be received at the office designated for receipt of bids as specified in Section 1-02.12 the time specified for receipt of the Proposal will be deemed to be extended to the same time of day specified in the solicitation on the first work day on which the normal work processes of the Contracting Agency resume.

When a Bid deposit is furnished in a physical format as specified in Section 1-02.7 the Bid deposit shall be submitted in a sealed envelope marked as "BID SUPPLEMENT" and with the Bidder's company name, project title, and Bid date.

1-02.10 Withdrawing, Revising, or Supplementing Proposal

After submitting a physical Bid Proposal to the Contracting Agency, the Bidder may withdraw, revise, or supplement it if:

1. The Bidder submits a written request signed by an authorized person, and
2. The Contracting Agency receives the request before the time set for receipt of Proposals.

The original physical Bid Proposal may be supplemented, or revised and resubmitted as the official Bid Proposal if the Contracting Agency receives it before the time set for receipt of Proposals. Faxed Bid revisions and supplements will be accepted only if they are submitted in accordance with the "Example Format for Facsimile Bid Changes" instructions posted on the WSDOT website at www.wsdot.wa.gov/biz/contaa/bulletin.

Unless specifically allowed in the Contract, emailed requests to withdraw, revise, or supplement a Proposal are not acceptable. The Contracting Agency is not responsible fordelayed, partial, failed, illegible, or partially legible FAX document transmissions, and such documents may be rejected as incomplete at the Bidder's risk.

The Contracting Agency will not accept requests to revise or withdraw electronic Bid Proposals. Such requests shall be furnished directly to BidExpress® and in accordance with their terms and conditions.

1-02.11 Combination and Multiple Proposals

A project may be organized for Bidding and construction by various methods to enable proposals to be submitted for combined projects or for the construction method specified. The Contracting Agency reserves the right to Award combined or separate Bids or by such other method deemed most advantageous to the Contracting Agency. Only those combined Bids specifically prescribed in the project Special Provisions will be accepted. If contracts are Awarded for combinations of projects, separate contracts will be written for each project included in the combination.

A Bidder submitting more than one Proposal at a letting may attach one of the following statements to each Proposal:

"We prefer to be Awarded not more than (Number) Contracts for projects for which we have submitted Bids at this letting;" or

"We prefer to be Awarded Contracts of a total value of not more than $____ for projects for which we have submitted Bids at this letting".

Such attachments will not make the Proposals irregular. The Contracting Agency will Award each Contract to the lowest responsible Bidder but will consider such attachment in determining the responsibility of the Bidder to perform each Contract for which a statement has been attached.

1-02.12 Public Opening of Proposals

Proposals will be opened and publicly read at the time indicated in the call for Bids unless the Bid opening has been delayed or canceled. Bidders, their authorized agents, and other interested parties are invited to be present.

If an emergency or unanticipated event interrupts normal work processes of the Contracting Agency so that Proposals cannot be opened at the time indicated in the call for Bids the time specified for opening of Proposals will be deemed to be extended to the same time of day on the first work day on which the normal work processes of the Contracting Agency resume.

1-02.13 Irregular Proposals

1. A Proposal will be considered irregular and may be rejected if:
    a. The Bidder is not prequalified;
    b. The Bidder adds provisions reserving the right to reject or accept the Award, or enter into the Contract;
    c. A price per unit cannot be determined from the Bid Proposal;
    d. The Proposal form is not properly executed;
    e. The Bidder fails to submit or properly complete a Subcontractor list, if applicable, as required in Section 1-02.6;
    f. The Bidder fails to submit or properly complete an Disadvantaged Business Enterprise Utilization Certification, if applicable, as required in Section 1-02.6;
    g. The Bidder fails to submit written confirmation from each DBE firm listed on the Bidder's completed Disadvantaged Business Enterprise Utilization Certification that they are in agreement with the Bidder's DBE participation commitment, if applicable, as required in Section 1-02.6, or if the written confirmation that is submitted fails to meet the requirements of the Special Provisions;
    h. The Bidder fails to submit Disadvantaged Business Enterprise Good Faith Effort documentation, if applicable, as required in Section 1-02.6, or if the documentation that is submitted fails to demonstrate that a Good Faith Effort to meet the Condition of Award was made;
    i. The Bidder fails to submit a DBE Bid Item Breakdown form, if applicable, as required in Section 1-02.6, or if the documentation that is submitted fails to meet the requirements of the Special Provisions;
    j. The Bidder fails to submit DBE Trucking Credit Forms, if applicable, as required in Section 1-02.6, or if the documentation that is submitted fails to meet the requirements of the Special Provisions; or
    k. The Bid Proposal does not constitute a definite and unqualified offer to meet the material terms of the Bid invitation.

2. A Proposal may be considered irregular and may be rejected if:
   a. The Proposal does not include a unit price for every Bid item;
   b. Any of the unit prices are excessively unbalanced (either above or below the amount of a reasonable Bid) to the potential detriment of the Contracting Agency;
   c. The authorized Proposal Form furnished by the Contracting Agency is not used or is altered;
   d. The completed Proposal form contains any unauthorized additions, deletions, alternate Bids, or conditions;
   e. Receipt of Addenda is not acknowledged;
   f. A member of a joint venture or partnership and the joint venture or partnership submit Proposals for the same project (in such an instance, both Bids may be rejected); or
   g. If Proposal form entries are not made in ink.

1-02.14 Disqualification of Bidders

A Bidder may be deemed not responsible and the Proposal rejected if:

1. More than one Proposal is submitted for the same project from a Bidder under the same or different names;
2. Evidence of collusion exists with any other Bidder. Participants in collusion will be restricted from submitting further Bids;
3. A Bidder is not prequalified for the Work or to the full extent of the Bid;
4. An unsatisfactory performance record exists based on past or current Contracting Agency Work;
5. There is uncompleted work (Contracting Agency or otherwise) which might hinder or prevent the prompt completion of the Work Bid upon;
6. The Bidder failed to settle bills for labor or materials on past or current Contracts;
7. The Bidder has failed to complete a written public contract or has been convicted of a crime arising from a previous public contract;
8. The Bidder is unable, financially or otherwise, to perform the Work;
9. A Bidder is not authorized to do business in the state of Washington; or
10. There are any other reasons deemed proper by the Contracting Agency.

1-02.15 Pre-Award Information

Before Awarding any Contract, the Contracting Agency may require one or more of these items or actions of the apparent lowest responsible Bidder:

1. A complete statement of the origin, composition, and manufacture of any or all materials to be used;
2. Samples of these materials for quality and fitness tests;
3. A progress schedule (in a form the Contracting Agency requires) showing the order of and time required for the various phases of the Work;
4. A breakdown of costs assigned to any Bid item;
5. Attendance at a conference with the Engineer or representatives of the Engineer; or
6. Any other information or action taken that is deemed necessary to ensure that the Bidder is the lowest responsible Bidder.

1-03 Award and Execution of Contract

1-03.1 Consideration of Bids

After opening and reading Proposals, the Contracting Agency will check them for correctness of extensions of the prices per unit and the total price. If a discrepancy exists between the price per unit and the extended amount of any Bid item, the price per unit will control. The total of extensions, corrected where necessary, will be used by the Contracting Agency for Award purposes and to fix the amount of the Contract Bond.

The right is reserved by the Contracting Agency to waive informalities in the bidding, accept a Proposal of the lowest responsible Bidder, reject any or all Bids, republish the call for Bids, revise or cancel the Work, or require the Work to be done in another way if the best interest of the Contracting Agency is served.

A Bidder who wishes to claim error after the Bids have been publicly opened and read as required by RCW 47.28.090 shall promptly notify the Contracting Agency that an error occurred. The Bidder shall submit a notarized affidavit or declaration under penalty of perjury signed by the Bidder and accompanied by the work sheets used in the preparation of the Bid, requesting relief from the responsibilities of Award. The affidavit or declaration shall describe the specific error(s) and certify that the work sheets are the ones used in preparing the Bid.

The affidavit or declaration shall be submitted no later than 5:00 p.m. on the first business day after Bid opening or the claim will not be considered. The Contracting Agency will review the affidavit or declaration and the certified work sheets to determine the validity of the claimed error and if the error is of the kind for which the law allows relief from forfeiture of the Bid deposit. If the Contracting Agency concurs in the claim of error and determines that the error is of the kind which allows relief from forfeiture, the Bidder will be relieved of responsibility and the Bid deposit of the Bidder will be returned. If the Contracting Agency does not concur in the error or determines that the error is not the kind for which the law allows relief, the Contracting Agency may Award the Contract and if the Bidder refuses to execute the Contract, the Bidder's Bid deposit shall be forfeited as required by RCW 47.28.100.

1-03.1(1) Identical Bid Totals

After opening Bids, if two or more lowest responsive Bid totals are exactly equal, then the tie-breaker will be determined by drawing as described in this section. Two or more slips of paper will be marked as follows: one marked "Winner" and the other(s) marked "unsuccessful". The slips will be folded to make the marking unseen. The slips will be placed inside a box. One authorized representative of each Bidder shall draw a slip from the box. Bidders shall draw in alphabetic order by the name of the firm as registered with the Washington State Department of Licensing. The slips shall be unfolded and the firm with the slip marked "Winner" will be determined to be the successful Bidder and eligible for Award of the Contract. Only those Bidders who submitted a Bid total that is exactly equal to the lowest responsive Bid are eligible to draw.

1-03.2 Award of Contract

Normally, Contract Award or Bid rejection will occur within 45 calendar days after Bid opening. If the lowest responsible Bidder and the Contracting Agency agree, this deadline may be extended. If they cannot agree on an extension by the 45 calendar day deadline, the Contracting Agency reserves the right to Award the Contract to the next lowest responsible Bidder or reject all Bids. The Contracting Agency will notify the successful Bidder of the Contract Award in writing.

1-03.3 Execution of Contract

Within 20 calendar days after the Award date, the successful Bidder shall return the signed Contracting Agency-prepared Contract, an insurance certification as required by Section 1-07.18, a satisfactory bond as required by law and Section 1-03.4, the Transfer of Coverage form for the Construction Stormwater General Permit with sections I, III, and VIII completed when provided, and shall be registered as a contractor in the state of Washington.

Until the Contracting Agency executes a Contract, no Proposal shall bind the Contracting Agency nor shall any Work begin within the project limits or within Contracting Agency-furnished sites. The Contractor shall bear all risks for any Work begun outside such areas and for any materials ordered before the Contract is executed by the Contracting Agency.

If the Bidder experiences circumstances beyond their control that prevents return of the Contract documents within 20 calendar days after the Award date, the Contracting Agency may grant up to a maximum of 20 additional calendar days for return of the documents, provided the Contracting Agency deems the circumstances warrant it.

1-03.4 Contract Bond

The successful Bidder shall provide an executed Contract Bond for the full Contract amount. This Contract Bond shall:

1. Be on a Contracting Agency-furnished form;
2. Be signed by an approved Surety (or Sureties) that:
    a. Is registered with the Washington State Insurance Commissioner; and
    b. Appears on the current Authorized Insurance List in the State of Washington published by the Office of the Insurance Commissioner,
3. Be conditioned upon the faithful performance of the Contract by the Contractor within the prescribed time;
4. Be conditioned upon the payment of taxes, increases, and penalties incurred on the project under titles 50, 51, and 82 RCW; and
5. Guarantee that the Surety shall indemnify, defend, and protect the Contracting Agency against any claim of direct or indirect loss resulting from the failure:
    a. Of the Contractor (or any of the employees, Subcontractors, or lower tier subcontractors of the Contractor) to faithfully perform the Contract; or

b. Of the Contractor (or the Subcontractors or lower tier subcontractors of the Contractor) to pay all laborers, mechanics, Subcontractors, lower tier subcontractors, material person, or any other person who provides supplies or provisions for carrying out the Work.

The Contracting Agency may require Sureties or Surety companies on the Contract Bond to appear and qualify themselves. Whenever the Contracting Agency deems the Surety or Sureties to be inadequate, it may, upon written demand, require the Contractor to furnish additional Surety to cover any remaining Work. Until the added Surety is furnished, payments on the Contract will stop.

1-03.5 Failure to Execute Contract

Failure to return the insurance certification and bond with the signed Contract as required in Section 1-03.3, or failure to provide Disadvantaged, Minority or Women's Business Enterprise information if required in the Contract, or failure or refusal to sign the Contract, or failure to register as a contractor in the state of Washington, or failure to return the completed Transfer of Coverage for the Construction Stormwater General Permit to the Contracting Agency when provided shall result in forfeiture of the proposal bond or deposit of this Bidder. If this should occur, the Contracting Agency may then Award the Contract to the second lowest responsible Bidder or reject all remaining Bids. If the second lowest responsible Bidder fails to return the required documents as stated above within the time provided after Award, the Contract may then be Awarded successively in a like manner to the remaining lowest responsible Bidders until the above requirements are met or the remaining Proposals are rejected.

1-03.6 Return of Bid Deposit

When Proposals have been examined and corrected as necessary, proposal bonds and deposits accompanying Proposals ineligible for further consideration will be returned. All other proposal bonds and deposits will be held until the Contract has been properly executed. When the Contract has been properly executed, all remaining deposits or bonds, except those subject to forfeiture, will be returned.

1-03.7 Judicial Review

Any decision made by the Contracting Agency regarding the Award and execution of the Contract or Bid rejection shall be conclusive subject to the scope of judicial review permitted under Washington Law. Such review, if any, shall be timely filed in the Superior Court of Thurston County, Washington.

1-04 Scope of the Work

1-04.1 Intent of the Contract

The intent of the Contract is to prescribe a complete Work. Omissions from the Contract of details of Work that are necessary to carry out the intent of the Contract shall not relieve the Contractor from performing the omitted Work.

1-04.1(1) Bid Items Included in the Proposal

The Contractor shall provide all labor, materials, tools, equipment, transportation, supplies, and incidentals required to complete all Work for the items included in the Proposal.

1-04.1(2) Bid Items Not Included in the Proposal

When the Contract specifies Work that has no Bid item, and the Work is not specified as being included with or incidental to other Bid items, an equitable adjustment will be made in accordance with Section 1-04.4 unless that Work is customarily considered as incidental to other items.

1-04.2 Coordination of Contract Documents, Plans, Special Provisions, Specifications, and Addenda

The complete Contract includes these parts: the Contract Form, Bidder's completed Proposal Form, Contract Plans, Contract Provisions, Standard Specifications, *Standard Plans*, Addenda, various certifications and affidavits, supplemental agreements, change orders, and subsurface boring logs (if any). These parts complement each other in describing a complete Work. Any requirement in one part binds as if stated in all parts. The Contractor shall provide any Work or materials clearly implied in the Contract even if the Contract does not mention it specifically.

Any inconsistency in the parts of the Contract shall be resolved by following this order of precedence (e.g., 1 presiding over 2, 3, 4, 5, and 6; 2 presiding over 3, 4, 5, and 6; and so forth):

1. Addenda,
2. Proposal Form,
3. Special Provisions,
4. Contract Plans,
5. Standard Specifications, and
6. *Standard Plans*.

On the Contract Plans, Working Drawings, and *Standard Plans*, figured dimensions shall take precedence over scaled dimensions.

This order of precedence shall not apply when Work is required by one part of the Contract but omitted from another part or parts of the Contract. The Work required in one part must be furnished even if not mentioned in other parts of the Contract.

Whenever reference is made in these Specifications or the Special Provisions to codes, rules, specifications, and standards, the reference shall be construed to mean the code, rule, specification, or standard that is in effect on the Bid advertisement date, unless otherwise stated or as required by law.

If any part of the Contract requires Work that does not include a description for how the Work is to be performed, the Work shall be performed in accordance with standard trade practice(s). For purposes of the Contract, a standard trade practice is one having such regularity of observance in the trade as to justify an expectation that it will be observed by the Contractor in doing the Work.

In case of any ambiguity or dispute over interpreting the Contract, the Engineer's decision will be final as provided in Section 1-05.1.

1-04.3 Reference Information

Reference Information provided to the Contractor is not part of the Contract. The Contracting Agency does not guarantee the accuracy of the Reference Information and is not responsible for the content of the Reference Information in any manner. Any use of Reference Information by the Contractor is done solely at the Contractor's risk. If a document that is provided as reference information contains material also included as a part of the Contract, that portion of the document shall be considered a part of the Contract and not as Reference Information.

1-04.4 Changes

The Engineer reserves the right to make, at any time during the Work, such changes in quantities and such alterations in the Work as are necessary to satisfactorily complete the project. Such changes in quantities and alterations shall not invalidate the Contract nor release the Surety, and the Contractor agrees to perform the Work as altered. Among others, these changes and alterations may include:

1. Deleting any part of the Work.
2. Increasing or decreasing quantities.
3. Altering Specifications, designs, or both.
4. Altering the way the Work is to be done.
5. Adding new Work.
6. Altering facilities, equipment, materials, services, or sites, provided by the Contracting Agency.
7. Ordering the Contractor to speed up or delay the Work.

The Engineer will issue a written change order for any change unless the remainder of this section provides otherwise.

If the alterations or changes in quantities significantly change the character of the Work under the Contract, whether or not changed by any such different quantities or alterations, an adjustment, excluding loss of anticipated profits, will be made to the Contract. The basis for the adjustment shall be agreed upon prior to the performance of the Work. If a basis cannot be agreed upon, then an adjustment will be made either for or against the Contractor in such amount as the Engineer may determine to be fair and equitable. If the alterations or changes in quantities do not significantly change the character of the Work to be performed under the Contract, the altered Work will be paid for as provided elsewhere in the Contract. The term *significant change* shall be construed to apply only to the following circumstances:

A. When the character of the Work as altered differs materially in kind or nature from that involved or included in the original proposed construction; or

B. When an item of Work, as defined elsewhere in the Contract, is increased in excess of 125 percent or decreased below 75 percent of the original Contract quantity. For the purpose of this section, an item of Work will be defined as any item that qualifies for adjustment under the provisions of Section 1-04.6.

For item 1, an equitable adjustment for deleted Work will be made as provided in Section 1-09.4.

For item 2, if the actual quantity of any item, exclusive of added or deleted amounts included in agreed change orders, increases or decreases by more than 25 percent from the original Plan quantity, the unit Contract prices for that item may be adjusted in accordance with Section 1-04.6.

For any changes except item 1 (deleted Work) or item 2 (increasing or decreasing quantities), the Engineer will determine if the change should be paid for at unit Contract price(s). If the Engineer determines that the change increased or decreased the Contractor's costs or time to do any of the Work including unchanged Work, the Engineer will make an equitable adjustment to the Contract. The equitable adjustment will be by agreement with the Contractor. However, if the parties are unable to agree, the Engineer will determine the amount of the equitable adjustment in accordance with Section 1-09.4 and adjust the time as the Engineer deems appropriate. Extensions of time will be evaluated in accordance with Section 1-08.8. The Engineer's decision concerning equitable adjustment and extension of time shall be final as provided in Section 1-05.1.

The Contractor shall proceed with the Work upon receiving:

1. A written change order approved by the Engineer, or

2. An oral order from the Engineer before actually receiving the written change order.

Within 14 calendar days of delivery of the change order the contractor shall endorse and return the change order, request an extension of time for endorsement or respond in accordance with Section 1-04.5. The Contracting Agency may unilaterally process the change order if the Contractor fails to comply with these requirements. Changes

normally noted on field stakes or variations from estimated quantities, except as provided in subparagraph A or B above, will not require a written change order. These changes shall be made at the unit prices that apply. The Contractor shall respond immediately to changes shown on field stakes without waiting for further notice.

The Contractor shall obtain written consent of the Surety or Sureties if the Engineer requests such consent.

1-04.4(1) Minor Changes

Payments or credits for changes amounting to $25,000 or less may be made under the Bid item "Minor Change". At the discretion of the Contracting Agency, this procedure for Minor Changes may be used in lieu of the more formal procedure as outlined in Section 1-04.4, Changes.

The Contractor will be provided a copy of the completed order for Minor Change. The agreement for the Minor Change will be documented by signature of the Contractor, or notation of verbal agreement. If the Contractor is in disagreement with anything required by the order for Minor Change, the Contractor may protest the order as provided in Section 1-04.5.

Payments or credits will be determined in accordance with Section 1-09.4. For the purpose of providing a common Proposal for all Bidders, the Contracting Agency has entered an amount for "Minor Change" in the Proposal to become a part of the total Bid by the Contractor.

1-04.4(2) Value Engineering Change Proposal (VECP)

1-04.4(2)A General

A VECP is a Contractor proposed change to the Contract Provisions which will accomplish the projects functional requirements in a manner that is equal to or better than the requirements in the Contract. The VECP may be: (1) at a less cost or time, or (2) either no cost savings or a minor increase in cost with a reduction in Contract time. The net savings or added costs to the Contract Work are shared by the Contractor and Contracting Agency.

The Contractor may submit a VECP for changing the Plans, Specifications, or other requirements of the Contract. The Engineer's decision to accept or reject all or part of the proposal is final and not subject to arbitration under the arbitration clause or otherwise subject to litigation.

The VECP shall meet all of the following:

1. Not adversely affect the long term life cycle costs.
2. Not adversely impact the ability to perform maintenance.
3. Provide the required safety and appearance.
4. Provide substitution for deleted or reduced Condition of Award Work, Apprentice Utilization and Training.

VECPs that provide a time reduction shall meet the following requirements:

1. Time saving is a direct result of the VECP.
2. Liquidated damages penalties are not used to calculate savings.
3. Administrative/overhead cost savings experienced by either the Contractor or Contracting Agency as a result of time reduction accrue to each party and are not used to calculate savings.

1-04.4(2)B VECP Savings

1-04.4(2)B1 Proposal Savings

The incentive payment to the Contractor shall be one-half of the net savings of the proposal calculated as follows:

1. (gross cost of deleted work) – (gross cost of added work) = (gross savings)
2. (gross savings) – (Contractor's engineering costs) – (Contracting Agency's costs) = (net savings)
3. (net savings) / 2 = (incentive pay)

The Contracting Agency's costs shall be the actual consultant costs billed to the Contracting Agency and in-house costs. Costs for personnel assigned to the Engineer's office shall not be included.

1-04.4(2)B2 Added Costs to Achieve Time Savings

The cost to achieve the time savings shall be calculated as follows:

1. (cost of added work) + (Contractor's engineering costs - Contracting Agency's engineering costs) = (cost to achieve time savings)
2. (cost to achieve time savings) / 2 = (Contracting Agency's share of added cost)

If the timesaving proposal also involves deleting work and, as a result, creates a savings for the Contracting Agency, then the Contractor shall also receive one-half of the savings realized through the deletion.

1-04.4(2)C VECP Approval

1-04.4(2)C1 Concept Approval

The Contractor shall submit a written proposal to the Engineer for consideration. The proposal shall contain the following information:

1. An explanation outlining the benefit provided by the change(s).
2. A narrative description of the proposed change(s). If applicable, the discussion shall include a demonstration of functional equivalency or a description of how the proposal meets the original contract scope of work.

3. A cost discussion estimating any net savings. Savings estimates will generally follow the outline below under the section, “Proposal Savings”.
4. A statement providing the Contracting Agency with the right to use all or any part of the proposal on future projects without future obligation or compensation.
5. A statement acknowledging and agreeing that the Engineer’s decision to accept or reject all or part of the proposal is final and not subject to arbitration under the arbitration clause or otherwise be subject to claims or disputes.
6. A statement giving the dates the Engineer must make a decision to accept or reject the conceptual proposal, the date that approval to proceed must be received, and the date the work must begin in order to not delay the contract. If the Contracting Agency does not approve the VECP by the date specified by the Contractor in their proposal the VECP will be deemed rejected.
7. The submittal will include an analysis on other Work that may have costs that changed as a result of the VECP. Traffic control and erosion control shall both be included in addition to any other impacted Work.

After review of the proposal, the Engineer will respond in writing with acceptance or rejection of the concept. This acceptance shall not be construed as authority to proceed with any change contract work. Concept approval allows the Contractor to proceed with the Work needed to develop final plans and other information to receive formal approval and to support preparation of a change order.

1-04.4(2)C2 Formal Approval

The Contractor’s submittal to the Engineer for formal approval shall include the following:

1. Deleted Work – Include the calculated quantities of unit price Work to be deleted. Include the proposed partial prices for portions of lump sum Work deleted. For deletion of force account items include the time and material estimates.
2. Added Work – Include the calculated quantities of unit price Work to be added, either by original unit Contract prices or by new, negotiated unit prices. For new items of Work include the quantities and proposed prices.
3. Contractor’s Engineering Costs – Submit the labor costs for the engineering to develop the proposal; costs for Contractor employees utilized in contract operations on a regular basis shall not be included.
4. Schedule Analysis – If the VECP is related to time savings, the Contractor shall submit a partial progress schedule showing the changed Work. The submittal shall also include a discussion comparing the partial progress schedule with the approved progress schedule for the project.
5. Working Drawings – Type 3 Working Drawings shall be submitted; those drawings which require engineering shall be a Type 3E.

Formal approval of the proposal will be documented by issuance of a change order. The VECP change order will contain the following statements which the Contractor agrees to by signing the change order:

1. The Contractor accepts design risk of all features, both temporary and permanent, of the changed Work.
2. The Contractor accepts risk of constructability of the changed Work.
3. The Contractor provides the Contracting Agency with the right to use all or any part of the proposal on future projects without further obligation or compensation.

VECP change orders will contain separate pay items for the items that are applicable to the Proposal. These are as follows:

1. Deleted Work.
2. Added Work.
3. The Contractor's engineering costs, reimbursed at 100 percent of the Contractor's cost.
4. Incentive payment to the Contractor.

When added Work costs exceed Deleted Work costs, but time savings make a viable proposal, then items 3 and 4 above are replaced with the following:

3. The Contracting Agency's share of added cost to achieve time savings.
4. The Contractor's share of savings from deleted Work.

1-04.4(2)C3 Authority to Proceed with Changed Work

The authority for the Contractor to proceed with the VECP Work will be provided by one of the following options:

1. Execution of the VECP change order, or
2. At the Contractor's request the Contracting Agency may provide approval by letter from the Engineer for the Work to proceed prior to execution of a change order. All of the risk for proceeding with the VECP shall be the responsibility of the Contractor. Additionally, the following criteria are required to have been met:
    a. Concept approval has been granted by the Contracting Agency.
    b. All design reviews and approvals have been completed, including plans and specifications.
    c. The Contractor has guaranteed, in writing, the minimum savings to the Contracting Agency.

1-04.5 Procedure and Protest by the Contractor

The Contractor accepts all requirements of a change order by: (1) endorsing it, (2) writing a separate acceptance, (3) not responding within the allotted time as outlined in Section 1-04.4, or (4) not protesting in the way this section provides. A change order that is not protested as provided in this section shall be full payment and final settlement of all claims for Contract time and for all costs of any kind, including costs of delays, related to any Work either covered or affected by the change. By not protesting as this section provides, the Contractor also waives any additional entitlement and accepts from the Engineer any written or oral order (including directions, instructions, interpretations, and determinations).

If in disagreement with anything required in a change order, another written order, or an oral order from the Engineer, including any direction, instruction, interpretation, or determination by the Engineer, the Contractor shall:

1. Immediately give a signed written notice of protest to the Engineer or the Engineer's field Inspectors before doing the Work;
2. Supplement the written protest within 14 calendar days with a written statement and supporting documents providing the following:
    a. The date and nature of the protested order, direction, instruction, interpretation or determination;
    b. A full discussion of the circumstances which caused the protest, including names of persons involved, time, duration and nature of the Work involved, and a review of the Plans and Contract Provisions referenced to support the protest;
    c. The estimated dollar cost, if any, of the protested Work and a detailed breakdown showing how that estimate was determined;
    d. An analysis of the progress schedule showing the schedule change or disruption if the Contractor is asserting a schedule change or disruption; and
    e. If the protest is continuing, the information required above shall be supplemented upon request by the Engineer until the protest is resolved.

Throughout any protested Work, the Contractor shall keep complete records of extra costs and time incurred. The Contractor shall permit the Engineer access to these and any other records related to the protested Work as determined by the Engineer.

The Engineer will evaluate all protests provided the procedures in this section are followed. If the Engineer determines that a protest is valid, the Engineer will adjust payment for Work or time by an equitable adjustment in accordance with Section 1-09.4. Extensions of time will be evaluated in accordance with Section 1-08.8. No adjustment will be made for an invalid protest.

If the Engineer determines that the protest is invalid, that determination and the reasons for it will be provided in writing to the Contractor. The determination will be provided within 14 calendar days after receipt of the Contractor's supplemental written statement

(including any additional information requested by the Engineer to support a continuing protest) described in item 2 above.

If the Contractor does not accept the Engineer's determination then the Contractor shall pursue the dispute and claims procedures set forth in Section 1-09.11. In spite of any protest or dispute, the Contractor shall proceed promptly with the Work as the Engineer orders.

By failing to follow the procedures of Sections 1-04.5 and 1-09.11, the Contractor completely waives any claims for protested Work.

1-04.6 Variation in Estimated Quantities

Payment to the Contractor will be made only for the actual quantities of Work performed and accepted in conformance with the Contract. When the accepted quantity of Work performed under a unit item varies from the original Proposal quantity, payment will be at the unit Contract price for all Work unless the total accepted quantity of any Contract item, adjusted to exclude added or deleted amounts included in change orders accepted by both parties, increases or decreases by more than 25 percent from the original Proposal quantity. In that case, payment for Contract Work may be adjusted as described herein.

The adjusted final quantity shall be determined by starting with the final accepted quantity measured after all Work under an item has been completed. From this amount, subtract any quantities included in additive change orders accepted by both parties. Then, to the resulting amount, add any quantities included in deductive change orders accepted by both parties. The final result of this calculation shall become the adjusted final quantity and the basis for comparison to the original Proposal quantity.

1. **Increased Quantities** – Either party to the Contract will be entitled to renegotiate the price for that portion of the adjusted final quantity in excess of 1.25 times the original Proposal quantity. The price for excessive increased quantities will be determined by agreement of the parties, or, where the parties cannot agree, the price will be determined by the Engineer based upon the actual costs to perform the Work, including reasonable markup for overhead and profit.

2. **Decreased Quantities** – Either party to the Contract will be entitled to an equitable adjustment if the adjusted final quantity of Work performed is less than 75 percent of the original Bid quantity. The equitable adjustment shall be based upon and limited to three factors:

    a. Any increase or decrease in unit costs of labor, materials or equipment, utilized for Work actually performed, resulting solely from the reduction in quantity;

    b. Changes in production rates or methods of performing Work actually done to the extent that the nature of the Work actually performed differs from the nature of the Work included in the original plan; and

    c. An adjustment for the anticipated contribution to unavoidable fixed cost and overhead from the units representing the difference between the adjusted final quantity and 75 percent of the original Plan quantity.

The following limitations shall apply to renegotiated prices for increases and/or equitable adjustments for decreases:

1. The equipment rates shall be actual cost but shall not exceed the rates set forth in the AGC/WSDOT Equipment Rental Agreement (referred to in Section 1-09.6) that is in effect at the time the Work is performed.
2. No payment will be made for extended or unabsorbed home office overhead and field overhead expenses to the extent that there is an unbalanced allocation of such expenses among the Contract Bid items.
3. No payment for consequential damages or loss of anticipated profits will be allowed because of any variance in quantities from those originally shown in the Proposal form, Contract Provisions, and Contract Plans.
4. The total payment (including the adjustment amount and unit prices for Work performed) for any item that experiences an equitable adjustment for decreased quantity shall not exceed 75 percent of the amount originally Bid for the item.

If the adjusted final quantity of any item does not vary from the quantity shown in the Proposal by more than 25 percent, then the Contractor and the Contracting Agency agree that all Work under that item will be performed at the original Contract unit price.

When ordered by the Engineer, the Contractor shall proceed with the Work pending determination of the cost or time adjustment for the variation in quantities.

The Contractor and the Contracting Agency agree that there will be no cost adjustment for decreases if the Contracting Agency has entered the amount for the item in the Proposal form only to provide a common Proposal for Bidders.

1-04.7 Differing Site Conditions (Changed Conditions)

During the progress of the Work, if preexisting subsurface or latent physical conditions are encountered at the site, differing materially from those indicated in the Contract, or if preexisting unknown physical conditions of an unusual nature, differing materially from those ordinarily encountered and generally recognized as inherent in the Work provided for in the Contract, are encountered at the site, the party discovering such conditions shall promptly notify the other party in writing of the specific differing site conditions before they are disturbed and before the affected Work is performed.

Upon written notification, the Engineer will investigate the conditions and if he/she determines that the conditions materially differ and cause an increase or decrease in the cost or time required for the performance of any Work under the Contract, an adjustment, excluding loss of anticipated profits, will be made and the Contract modified in writing accordingly. The Engineer will notify the Contractor of his/her determination whether or not an adjustment of the Contract is warranted.

No Contract adjustment which results in a benefit to the Contractor will be allowed unless the Contractor has provided the required written notice.

The equitable adjustment will be by agreement with the Contractor. However, if the parties are unable to agree, the Engineer will determine the amount of the equitable adjustment in accordance with Section 1-09.4. Extensions of time will be evaluated in accordance with Section 1-08.8.

If the Engineer determines that different site conditions do not exist and no adjustment in costs or time is warranted, such determination shall be final as provided in Section 1-05.1.

If there is a decrease in the costs or time required to perform the Work, failure of the Contractor to notify the Engineer of the differing site conditions shall not affect the Contracting Agency's right to make an adjustment in the costs or time.

No claim by the Contractor shall be allowed unless the Contractor has followed the procedures provided in Sections 1-04.5 and 1-09.11.

1-04.8 Progress Estimates and Payments

Engineer-issued progress estimates or payments for any part of the Work shall not be used as evidence of performance or quantities. Progress estimates serve only as basis for partial payments. The Engineer may revise progress estimates any time before final acceptance. If the Engineer deems it proper to do so, changes may be made in progress estimates and in the final estimate.

1-04.9 Use of Buildings or Structures

The Engineer will decide whether any building or Structure on the Right of Way may remain during the Work and whether the Contractor may use such a building or Structure.

1-04.10 Use of Materials Found on the Project

With the Engineer's written approval, the Contractor may use on the project: stone, gravel, sand, other materials from on-site excavation, or timbers removed in the course of the Work. Approval will not be granted if:

1. The excavated materials or timber fail to meet Contract requirements;
2. The excavated materials or timber are required for other use under the Contract;
3. The excavated materials are required for use as Selected Materials under Section 2-03.3(10); or
4. Such use is not in the best interests of the Contracting Agency as determined by the Engineer, whose decision shall be final as provided in Section 1-05.1.

Any material disturbed by, but not used in, the Work shall be disposed of as provided elsewhere in the Contract or as ordered by the Engineer in accordance with Section 1-04.4.

1-04.11 Final Cleanup

The Contractor shall perform final cleanup as provided in this section to the Engineer's satisfaction. The Engineer will not establish the Physical Completion Date until this is done. The Highway Right of Way, material sites, and all ground the Contractor occupied to do the Work shall be left neat and presentable. The Contractor shall:

1. Remove all rubbish, surplus materials, discarded materials, falsework, camp buildings, temporary structures, equipment, and debris; and
2. Deposit in embankments, or remove from the project, all unneeded, oversized rock left from grading, surfacing, or paving.

The Contractor shall not remove warning, regulatory, or guide signs unless the Engineer approves.

1-05 Control of Work

1-05.1 Authority of the Engineer

The Engineer shall be satisfied that all the Work is being done in accordance with the requirements of the Contract. The Contract and Specifications give the Engineer authority over the Work. Whenever it is so provided in this Contract, the decision of the Engineer shall be final: provided, however, that if an action is brought within the time allowed in this Contract challenging the Engineer's decision, that decision shall be subject to the scope of judicial review provided in such cases under Washington case law.

The Engineer's decisions will be final on all questions including the following:

1. Quality and acceptability of materials and Work,
2. Measurement of unit price Work,
3. Acceptability of rates of progress on the Work,
4. Interpretation of Plans and Specifications,
5. Determination as to the existence of changed or differing site conditions,
6. Fulfillment of the Contract by the Contractor,
7. Payments under the Contract including equitable adjustment,
8. Suspension(s) of Work,
9. Termination of the Contract for default or public convenience,
10. Determination as to unworkable days, and
11. Approval of Working Drawings.

The Engineer represents the Contracting Agency with full authority to enforce Contract requirements. If the Contractor fails to respond promptly to the requirements of the Contract or orders from the Engineer:

1. The Engineer may use Contracting Agency resources, other contractors, or other means to accomplish the Work; and
2. The Contracting Agency will not be obligated to pay the Contractor, and will deduct from the Contractor's payments any costs that result when any other means are used to carry out the Contract requirements or Engineer's orders.

At the Contractor's risk, the Engineer may suspend all or part of the Work according to Section 1-08.6.

Nothing in these Specifications or in the Contract requires the Engineer to provide the Contractor with direction or advice on how to do the Work. If the Engineer approves or recommends any method or manner for doing the Work or producing materials, the approval or recommendation shall not:

1. Guarantee that following the method or manner will result in compliance with the Contract,
2. Relieve the Contractor of any risks or obligations under the Contract, or
3. Create any Contracting Agency liability.

1-05.2 Authority of Assistants and Inspectors

The Engineer may appoint assistants and Inspectors to assist in determining that the Work and materials meet the Contract requirements. Assistants and Inspectors have the authority to reject defective material and suspend Work that is being done improperly, subject to the final decisions of the Engineer.

Assistants and Inspectors are not authorized to accept Work, to accept materials, to issue instructions, or to give advice that is contrary to the Contract. Work done or material furnished which does not meet the Contract requirements shall be at the Contractor's risk and shall not be a basis for a claim even if the Inspectors or assistants purport to change the Contract.

Assistants and Inspectors may advise the Contractor of any faulty Work or materials or infringements of the terms of the Contract; however, failure of the Engineer or the assistants or Inspectors to advise the Contractor does not constitute acceptance or approval.

1-05.3 Working Drawings

The Contract may require the Contractor to submit Working Drawings for the performance of the work. Working Drawings shall be submitted by the Contractor electronically to the Engineer in PDF format; drawing details shall be prepared in accordance with conventional detailing practices. If the PDF format is found to be unacceptable, at the request of the Engineer, the Contractor shall provide paper copies of the Working Drawings with drawings on 11 by 17 inch sheets and calculations/text on 8½ by 11 inch sheets.

Working Drawings will be classified under the following categories:

1. **Type 1** – Submitted for Contracting Agency information. Submittal must be received by the Contracting Agency a minimum of 7 calendar days before Work represented by the submittal begins.
2. **Type 2** – Submitted for Contracting Agency review and comment. Unless otherwise stated in the Contract, the Engineer will require up to 20 calendar days from the date the Working Drawing is received until it is returned to the Contractor. The Contractor shall not proceed with the Work represented by the Working Drawing until comments from the Engineer have been addressed.
3. **Type 2E** – Same as a Type 2 Working Drawing with Engineering as described below.
4. **Type 3** – Submitted for Contracting Agency review and approval. Unless otherwise stated in the Contract, the Engineer will require up to 30 calendar days from the date the Working Drawing is received until it is returned to the Contractor. The Contractor shall obtain the Engineer's written approval before proceeding with the Work represented by the Working Drawing.
5. **Type 3E** – Same as a Type 3 Working Drawing with Engineering as described below.

All Working Drawings shall be considered Type 3 Working Drawings except as specifically noted otherwise in the Contract. Unless designated otherwise by the Contractor, submittals of Working Drawings will be reviewed in the order they are received by the Engineer. In the event that several Working Drawings are received simultaneously, the Contractor shall specify the sequence in which they are to be reviewed. If the Contractor does not submit a review sequence for simultaneous Working Drawing submittals, the review sequence will be at the Engineer's discretion.

Working Drawings requiring Engineering, Type 2E and 3E, shall be prepared by (or under the direction of) a Professional Engineer, licensed under Title 18 RCW, State of Washington, and in accordance with WAC 196-23-020. Design calculations shall carry the Professional Engineer's signature and seal, date of signature, and registration number on the cover page. The cover page shall also include the Contract number, Contract title and sequential index to calculation page numbers.

If more than the specified number of calendar days is required for the Engineer's review of any individual Working Drawing or resubmittal, an extension of time will be considered in accordance with Section 1-08.8.

Review or approval of Working Drawings shall neither confer upon the Contracting Agency nor relieve the Contractor of any responsibility for the accuracy of the drawings or their conformity with the Contract. The Contractor shall bear all risk and all costs of any Work delays caused by rejection or nonapproval of Working Drawings.

Unit Bid prices shall cover all costs of Working Drawings.

1-05.4 Conformity With and Deviations From Plans and Stakes

The Special Provisions may require that the Contractor be contractually responsible for part or all of the project surveying. For survey requirements not the responsibility of the Contractor, the Engineer will lay out and set construction stakes and marks needed to establish the lines, grades, slopes, cross-sections, and curve superelevations. These stakes and marks will govern the Contractor's Work. The Contractor shall take full responsibility for detailed dimensions, elevations, and slopes measured from them.

All Work performed shall be in conformity with the lines, grades, slopes, cross-sections, superelevation data, and dimensions as shown in the Plans, or as staked. If the Plans, Special Provisions, or these Specifications, state specific tolerances, then the Work shall be performed within those limits. The Engineer's decision on whether the Work is in conformity shall be final, as provided in Section 1-05.1.

The Contractor shall not deviate from the approved Plans and Working Drawings unless the Engineer approves in writing.

When the Contracting Agency is responsible for roadway surveying, and the Contractor trims the Subgrade with an automatic machine guided by reference lines, the Engineer will set control stakes for line and grade only once after grading is complete. To gain better control with unusual pavement widths or for other reasons, the Engineer may set more control stakes without added cost to the Contractor. The Contractor shall set reference

lines from these control stakes for trimming Subgrade, for surfacing, and for controlling the paving machines.

The Contractor shall work to preserve stakes, marks, and monuments set by the Engineer. The Contracting Agency will deduct from payments due the Contractor all costs to replace such stakes, marks, and monuments carelessly or willfully damaged or destroyed by the Contractor's operation.

The Contractor shall provide enough safe areas to permit the Engineer to set those points and elevations that are the responsibility of the Contracting Agency and to perform random checks of the surveying performed by the Contractor.

The Contractor shall keep the Engineer informed of staking requirements to provide the Engineer with adequate time to set the stakes for which the Contracting Agency is responsible. Contractor requests for stakes shall be made at least 3 working days before the Engineer needs to begin the staking operation.

1-05.5 Tolerances

Geometrical tolerances shall be measured from the points, lines, and surfaces defined in Contract documents.

A plus (+) tolerance increases the amount or dimension to which it applies, or raises a deviation from level. A minus (-) tolerance decreases the amount or dimension to which it applies, or lowers a deviation from level. Where only one signed tolerance is specified (+ or -), there is no specified tolerance in the opposing direction.

Tolerances shall not be cumulative. The most restrictive tolerance shall control.

Tolerances shall not extend the Work beyond the Right of Way or other legal boundaries identified in the Contract documents. If application of tolerances causes the extension of the Work beyond the Right of Way or legal boundaries, the tolerance shall be reduced for that specific instance.

Tolerances shall not violate other Contract requirements. If application of tolerances causes the Work to violate other Contract requirements, the tolerance shall be reduced for that specific instance. If application of tolerances causes conflicts with other components or aspects of the Work, the tolerance shall be reduced for that specific instance.

1-05.6 Inspection of Work and Materials

The Engineer may inspect all Work and materials for conformity with Contract terms. To ensure the Engineer's safety and access during these inspections, the Contractor shall provide any equipment needed, such as walkways, railings, ladders, and platforms.

When the Engineer requests, the Contractor shall (without charge) provide samples of materials used or to be used in the Work. If the Contractor uses materials tested and approved for one project in an unrelated project, the Contracting Agency may deduct its testing and inspection costs from payments due the Contractor. The Engineer may order

the Contractor to remove and replace, and bear the cost of doing so, any materials used without inspection.

Any inspections, tests, measurements, or other actions by Contracting Agency employees serve only one purpose: to assure the Engineer that Work, materials, progress rate, and quantities comply with Contract terms. Such work by Contracting Agency employees shall not relieve the Contractor from doing any Contract-assigned Work or from determining whether Contract requirements are being met. The Contractor shall correct any substandard Work or materials. The Engineer will reject unsuitable Work or materials even though inspected or paid for in a progress estimate.

If the Engineer requests, then the Contractor shall remove or uncover any area of the completed Work. After the Engineer inspects it, the Contractor shall restore the area to the standard the Contract requires. The Contractor shall bear the cost of uncovering, removing, and restoring the exposed Work: (a) if it proves unacceptable, or (b) if it was placed without authority or without due notice to the Engineer. The Contracting Agency will pay these costs by agreed price or by force account if the Work proves to be acceptable and the Contractor had performed the original Work with the authority of and due notice to the Engineer.

The Contractor, if advised to do so by the Engineer, shall permit representatives from other agencies to inspect the Work when it is to be done:

1. On any railroad, utility, or facility of a public agency; or
2. To the satisfaction of any federal, state, or municipal agency.

In any crushing or screening operation, the Contractor shall provide and install a mechanical sampler that:

1. Is automatic or semi-automatic;
2. Can safely and easily obtain representative samples of the materials being produced;
3. Can convey the samples to ground level in Contracting Agency-provided sacks;
4. Moves at an even rate through the full width of the materials stream falling from the discharge end of the belt, gate, or chute;
5. Is power driven during the material intercept cycle; and
6. Can be adjusted to take samples of about 100 pounds as often as the Engineer requires.

No material from the crushing or screen operation will be accepted until after the Engineer has approved the design and operation of the sampling equipment. The Contractor shall bear all costs of providing the sampling equipment, the power to operate it, and the space for its use.

1-05.7 Removal of Defective and Unauthorized Work

The Contracting Agency will not pay for unauthorized or defective Work. Unauthorized or defective Work includes: Work and materials that do not conform to Contract requirements; Work done beyond the lines and grades set by the Plans or the Engineer; and extra Work and materials furnished without the Engineer's written approval. At the Engineer's order, the Contractor shall immediately remedy, remove, replace, or dispose of unauthorized or defective Work or materials and bear all costs of doing so.

1-05.8 Vacant

1-05.9 Equipment

Prior to mobilizing equipment on site, the Contractor shall thoroughly remove all loose dirt and vegetative debris from drive mechanisms, wheels, tires, tracks, buckets and undercarriage. The Engineer will reject equipment from the site until it returns clean.

At the Engineer's request, the Contractor shall provide an operating and maintenance manual for each model or type of mixing, placing, or processing equipment before using it in the Work. The Contractor shall also provide test instruments to confirm whether the equipment meets operating requirements, such as vibration rate, revolutions-per-minute, or any other requirements.

The Contract may require automatically controlled equipment for some operations. If the automatic controls on such equipment fail, then the Contractor may operate the equipment manually for the remainder of that normal working day, provided the method of operation produces results otherwise meeting the Specifications. Continued operation of the equipment manually beyond this working day will be permitted only by specific authorization of the Engineer.

The Engineer will reject equipment that repeatedly breaks down or fails to produce results within the required tolerances. The Contractor shall have no claim for additional payment or for extension of time due to rejection and replacement of any equipment.

Upon completion of the Work, the Contractor shall completely remove all loose dirt and vegetative debris from equipment before removing it from the job site.

1-05.10 Guarantees

The Contractor shall furnish to the Contracting Agency any guarantee or warranty furnished as a customary trade practice in connection with the purchase of any equipment, materials, or items incorporated into the project.

1-05.11 Final Inspection

The Engineer will not make the final inspection until the physical Work required by the Contract, including final cleanup and all extra Work ordered by the Engineer, has been completed. The Physical Completion Date for the Contract will be determined as provided in Section 1-08.5.

1-05.12 Final Acceptance

The Contractor must perform all the obligations under the Contract before a Completion Date and final acceptance can occur. Failure of the Contractor to perform all the obligations under the Contract shall not bar the Contracting Agency from unilaterally accepting the Contract as provided in Section 1-09.9. The Secretary accepts the completed Contract and the items of Work shown in the final estimate by signature of the Final Contract Voucher Certification. The date of that signature constitutes the acceptance date. Progress estimates or payments shall not be construed as acceptance of any Work under the Contract.

The Contractor agrees that neither completion nor final acceptance shall relieve the Contractor of the responsibility to indemnify, defend, and protect the Contracting Agency against any claim or loss resulting from the failure of the Contractor (or the Subcontractors or lower tier subcontractors) to pay all laborers, mechanics, Subcontractors, materialpersons, or any other person who provides labor, supplies, or provisions for carrying out the Work or for any payments required for unemployment compensation under Title 50 RCW or for industrial insurance and medical aid required under Title 51 RCW.

Final acceptance shall not constitute acceptance of any unauthorized or defective work or material. The Contracting Agency shall not be barred from requiring the Contractor to remove, replace, repair, or dispose of any unauthorized or defective work or material or from recovering damages for any such work or material.

1-05.13 Superintendents, Labor, and Equipment of Contractor

At all times, the Contractor shall keep at the Work site a set of the Plans, Specifications, Special Provisions, and Addenda. The Contractor shall devote the attention required to make reasonable progress on the Work and shall cooperate fully with the Engineer and Inspectors.

Either the Contractor in person or an authorized representative shall remain on site whenever the Work is underway. Before the Work begins, the Contractor shall name in writing an experienced superintendent who understands the Contract and is able to supervise the Work. This superintendent shall have full authority to represent and act for the Contractor. Any superintendent who repeatedly fails to follow the Engineer's written or oral orders, directions, instructions, or determinations, shall be subject to removal from the project. Upon the written request of the Engineer, the Contractor shall immediately remove such superintendent and name a replacement in writing.

Competent supervisors experienced in the task being performed shall continuously oversee the Contract Work. At the Engineer's written request, the Contractor shall immediately remove and replace any incompetent, careless, or negligent employee.

Noncompliance with the Engineer's request to remove and replace personnel at any level shall be grounds for terminating the Contract under the terms of Section 1-08.10.

The Contractor shall keep all machinery and equipment in good, workable condition. It shall be adequate for its purpose and used by competent operators.

The Engineer will rate the Contractor's performance and Contract compliance in these categories:

1. Progress of Work,
2. Quality of Work,
3. Equipment,
4. Administration/Management/Supervision, and
5. Coordination and Control of Subcontractors.

Whenever the Contracting Agency evaluates the Contractor's prequalification under RCW 47.28.070, it will take these reports into account.

1-05.13(1) Emergency Contact List

The Contractor shall submit an Emergency Contact List to the Engineer no later than 5 calendar days after the date the Contract is executed. The list shall include, at a minimum, the Contractor's Project Manager, or equivalent, the Contractor's Project Superintendent, the Erosion and Sediment Control (ESC) Lead, and the Traffic Control Supervisor. The list shall identify a representative with delegated authority to act as the emergency contact on behalf of the Contractor and include one or more alternates. The emergency contact shall be available upon the Engineer's request at other than normal working hours. The Emergency Contact List shall include 24-hour telephone numbers for all individuals identified as emergency contacts or alternates.

1-05.14 Cooperation With Other Contractors

The Contracting Agency may perform other work at or near the site, including any material site, with other forces than those of the Contractor. This work may be done with or without a contract. If such work takes place within or next to this project, the Contractor shall cooperate with all other contractors or forces. The Contractor shall carry out Work under this project in a way that will minimize interference and delay for all forces involved. The Engineer will resolve any disagreements that may arise among the contractors or the Contractor and the Contracting Agency over the method or order of doing the Work. The Engineer's decision in these matters shall be final, as provided in Section 1-05.1.

The coordination of the Work shall be taken into account by the Contractor as part of the site investigation in accordance with Section 1-02.4 and any resulting costs shall be incidental and included within the unit Bid prices in the Contract.

1-05.15 Method of Serving Notices

Any written notice to the Contractor required under these Specifications may be served on the Contractor either personally or by mailing or by delivery to the last post office address known to the Engineer.

All correspondence from the Contractor shall be directed to the Engineer.

1-06 Control of Material

1-06.1 Approval of Materials Prior to Use

Prior to use, the Contractor shall notify the Engineer of all proposed materials. The Contractor shall use the Qualified Product List (QPL), the Aggregate Source Approval (ASA) Database, or the Request for Approval of Material (RAM) form.

All equipment, materials, and articles incorporated into the permanent Work:

1. Shall be new, unless the Special Provisions or *Standard Specifications* permit otherwise;
2. Shall meet the requirements of the Contract and be approved by the Engineer;
3. May be inspected or tested at any time during their preparation and use; and
4. Shall not be used in the Work if they become unfit after being previously approved.

1-06.1(1) Qualified Products List (QPL)

The QPL is a listing of manufactured products that have been evaluated and determined suitable for use in Highway construction.

If the Contractor elects to use the QPL, the most current list available at the time the product is proposed for use, shall be used. The QPL submittal shall be prepared by the Contractor in accordance with the instructions in the QPL and submitted to the Engineer prior to use.

The QPL identifies the approved products, the applicable Specification Section, and the basis for acceptance at the project level. The listing is divided into two categories, “Approved” and “Conditionally Approved”. “Approved” products are denoted with an “A”. Those products may be accepted without additional sampling. “Conditionally Approved” products are denoted with a “CA”. The acceptance and use of these products is based upon additional job sampling and/or documentation. All additional acceptance actions need to be completed prior to the material being incorporated into the Work.

The Contractor shall advise the Engineer of the intended items for use from the QPL by reference to the Contract Bid item.

The use of listed products shall be restricted to the Standard Specification for which they are listed and fulfillment of the acceptance requirement defined in the QPL. Qualified products not conforming to the Specifications, not fulfilling the acceptance requirements, or improperly handled or installed, shall be replaced at the Contractor’s expense.

To qualify for continued listing on the QPL, products may be sampled and tested for conformance to the *Standard Specifications*. The Contracting Agency reserves the right to make revisions to the QPL at any time.

If there is a conflict between the QPL and the Contract, the provisions of the Contract shall take precedence over the QPL.

The current QPL can be accessed online at www.wsdot.wa.gov/business/materialslab/QPL.htm.

1-06.1(2) Request for Approval of Material (RAM)

The RAM shall be used when the Contractor elects not to use the QPL or the material is not listed in the QPL. The RAM shall be prepared by the Contractor in accordance with the instructions on Form 350-071 and submitted to the Engineer for approval before the material is incorporated into the Work.

Approval of the material does not constitute acceptance of the material for incorporation into the Work.

Additional acceptance actions as noted on the RAM need to be completed prior to the materials being incorporated into the Work.

When requesting approval of an item that requires fabrication, both the fabricator and the manufacturer of the base material shall be identified on the RAM.

1-06.1(3) Aggregate Source Approval (ASA) Database

The ASA database contains the results of WSDOT preliminary testing of aggregate sources as well as the results pertaining to the review of the aggregate source Quality Control Programs. Aggregate sources evaluated after January 1, 2021 shall have Quality Control Program compliant with QC 11 and QC 12.

This database is used by the Contracting Agency to indicate the approval status of these aggregate sources for applications that require preliminary testing as defined in the Contract. The ASA '*Aggregate Source Approval* Report' identifies the currently approved applications for each aggregate source listed. The acceptance and use of these aggregates is contingent upon additional job sampling and/or documentation. The ASA database can be accessed online at the agency website.

Aggregates approved for applications on the ASA '*Aggregate Source Approval* Report' not conforming to the Specifications, not fulfilling the acceptance requirements, or improperly handled or installed, shall be replaced at the Contractor's expense.

Aggregate materials that are not approved for use in the ASA data base may be sampled and tested by the Agency, for a specified use on a project, from the source or from a processed stockpile of the material and all cost for the sampling and testing will be deducted from the Contract.

The Contractor agrees to authorize the Engineer to deduct the sampling and testing costs from any money due or coming due to the Contractor.

Regardless of the status of the source, whether listed or not listed in the ASA database the source owner may be asked to provide testing results for toxicity in accordance with Section 9-03.21(1).

1-06.1(4) Fabrication Inspection Expense

In the event the Contractor elects to have items fabricated beyond 300 miles from Seattle, Washington, the Contracting Agency will deduct from monies due or that may become due to the Contractor all costs to perform plant approval and fabrication acceptance inspection for the items listed in Table 1 and costs for initial plant approval for items listed in Table 2. Plants currently listed on the QPL for the items shown in Table 1 and Table 2 in this section do not require plant approval.

Table 1 Items Requiring Plant Approval and Fabrication Acceptance Inspection

- Anchor Bolts (ASTM A449 & F1554 Grade 105)
- Bridge Bearings (Cylindrical, Disc, Fabric Pad, Low Rise, Pin, Pendulum, and Spherical)
- Cattle Guards
- Coated Piling and Casing
- Epoxy-Coated Reinforcing Steel
- Fabricated/Welded Miscellaneous Metal Drainage Items: Grate Inlets, and Drop Inlets
- Longitudinal Seismic Restrainers
- Metal Bridge Railing and Handrail
- Metal Castings for Concrete Drainage, electrical, and Utility Items
- Modular Expansion Joints
- Paint & Powder Coating Facilities for Table 1 items
- Precast Concrete Bridge Deck Panels
- Precast Concrete Catch Basins, Manholes, Inlets, Drywells, and Risers
- Precast Concrete Drain, Perforated Underdrain, Culvert, Storm Sewer, and Sanitary Sewer Pipe
- Precast Concrete Floor Panels
- Precast Concrete Junction Boxes, Pull Boxes, Cable Vaults
- Precast Concrete Marine Pier Deck Panels
- Precast Concrete Pier Caps
- Precast Concrete Retaining Walls, including Lagging Panels
- Precast Concrete Roof Panels
- Precast Concrete Structural Earth Walls, Noise Barrier Walls, Wall Panels, and Wall Stem Panels
- Precast Concrete Traffic Barrier
- Precast Concrete Vaults (Electrical, Utility, Drainage, etc.)
- Precast Concrete Girders and Precast Bridge Components
- Prestressed Concrete Girders
- Prestressed Concrete Panels
- Precast Reinforced Concrete Box Culverts
- Precast Reinforced Concrete Split Box Culverts
- Precast Reinforced Concrete Three Sided Structures
- Prestressed Concrete Piles
- Retrofit Guardrail Posts with Welded Base Plates
- Signal Standards
- Signing Material
- Sign Structures – Cantilever, Sign Bridge, and Bridge Mounted, Roadside Type PLT/PLU
- Soldier Piles
- Steel Bridges and Steel Bridge Components
- Steel Column Jackets
- Steel Light Standards, and High Mast Light Poles
- Strip Seal Expansion Joints
- Structural Steel for Ferry Terminal Berthing, Pedestrian and Vehicle Loading Structures
- Timber Bridges
- Treated Timber and Lumber 6 inch by 6 inch or larger
- Welded Structural Steel (Miscellaneous)

Table 2 Items Requiring Initial Plant Approval Only

- Epoxy Coating of Dowels and Tiebars for Concrete Pavement
- Guardrail Posts and Blocks
- Precast Concrete Blocks for Structural Earth Walls
- Steel Pipe Piling

The deductions for fabrication inspection costs will be as shown in the Payment Table below.

Zone	Place of Fabrication or Inspection Site	Reduction in Payment
1	Within 300 airline miles from Seattle	None*
2	Between 300 and 3,000 airline miles from Seattle	$700.00 per inspection day**
3	Over 3,000 airline miles from Seattle	$1,000 per inspection day,** but not less than $2,500 per trip

*Fabrication inspection expense does not apply for initial acceptance inspection in Zone 1. Re-inspection of items due to unacceptable workmanship or scheduling errors made by the Contractor, fabricator, or facility applying protective coatings will be assessed at $60.00 per hour but not less than $120.00 per inspection.
**An inspection day includes any calendar day or portion of a calendar day spent by one inspector inspecting, on standby, or traveling to and from, a place of fabrication. An additional cost per inspection day will be assessed for each additional inspector. Reimbursement will be assessed at $280.00 per day for weekends and holidays for each on site inspector in travel status, but not engaged in inspection or travel activities when fabrication activities are not taking place.

Where fabrication of an item takes place in more than one zone, the reduction in payment will be computed on the basis of the entire item being fabricated in the farthest of zones where any fabrication takes place on that item.

The rates for Zones 2 and 3 shall be applied for the full duration of time for all fabrication inspection activities, to include, but not be limited to: plant approvals, prefabrication meetings, fabrication, coatings, and final inspection. When an inspection is for more than one Contract the fabrication inspection costs shall be prorated as determined by the Engineer.

1-06.2 Acceptance of Materials

1-06.2(1) Samples and Tests for Acceptance

The Contractor shall deliver representative samples (from the Contractor, Producer, or Fabricator) to the Engineer without charge before incorporating material into the Work. In providing samples, the Contractor shall provide the Engineer with sufficient time and quantities for testing before use. The Engineer may require samples at any time. Samples not taken by or in the presence of the Engineer will not be accepted for test, unless the Engineer permits otherwise.

The Contractor shall designate specific Contractor employees as points of contact for concrete testing and acceptance. Alternates shall be designated to ensure that direct contact is maintained during concrete placement. If designated by the Contractor to the Engineer, the concrete supplier will receive all 28-day concrete strength test results.

The Engineer will designate specific Contracting Agency employees as points of contact for concrete testing and acceptance.

The Contractor may observe any of the sampling and testing performed by the Engineer. If the Contractor observes a deviation from the specified sampling and testing procedures, the Contractor shall verbally describe the deviations observed to the Engineer or designated representative immediately, and shall confirm these observed deviations in writing to the Engineer within 24 hours, referencing the specific procedures and steps. The Engineer will respond in writing within 3 working days of the receipt of the Contractor's written communications.

All field and Laboratory materials testing by the Engineer will follow methods described in Contract documents, or in the WSDOT *Materials Manual* M 46-01, using qualified testing personnel and calibrated or verified equipment. The standard or tentative standard in effect on the Bid advertising date will apply in each case.

Revisions to the WSDOT *Materials Manual* M 46-01 or revisions to other Specifications or test methods such as AASHTO, ASTM, or Federal Specifications will be considered as in effect 60 calendar days after publication.

1-06.2(2) Statistical Evaluation of Materials for Acceptance

1-06.2(2)A General

Where specified, acceptance sampling and testing will be performed by the Contracting Agency and statistically evaluated for acceptance by the provisions of this Subsection. All test results for a lot will be analyzed collectively and statistically by the quality level analysis procedures shown at the end of this Subsection to determine the total percent of the lot that is within Specification limits and to determine an appropriate pay factor. Lots and sublots are defined in the appropriate Subsection of these Specifications for the material being statistically evaluated.

Quality level analysis is a statistical procedure for determining the percent compliance of the material with these Specifications. Quality level is the computed percent of material meeting these Specifications and is determined from the arithmetic mean, (X_m), and the sample standard deviation (S), for each constituent of the lot.

Any necessary rounding off of test results or calculations will be accomplished according to the individual testing procedure, or, if not defined in the procedure then accomplished according to the following rule:

1. The final significant digit will not be changed when the succeeding digit is less than 5.
2. The final significant digit will be increased by one when the succeeding digit is 5 or greater.

Table 1 Estimated percent of Work Within Specification Limits

Estimated percent Within Specification Limits (P_U or P_L)	Upper Quality Index Q_U or Lower Quality Index Q_L														
	n=3	n=4	n=5	n=6	n=7	n=8	n=9	n=10 to n=11	n=12 to n=14	n=15 to n=17	n=18 to n=22	n=23 to n=29	n=30 to n=42	n=43 to n=66	n=67 to ∞
100	1.16	1.49	1.72	1.88	1.99	2.07	2.13	2.20	2.28	2.34	2.39	2.44	2.48	2.51	2.56
99		1.46	1.64	1.75	1.82	1.88	1.91	1.96	2.01	2.04	2.07	2.09	2.12	2.14	2.16
98		1.43	1.58	1.66	1.72	1.75	1.78	1.81	1.84	1.87	1.89	1.91	1.93	1.94	1.95
97	1.15	1.40	1.52	1.59	1.63	1.66	1.68	1.71	1.73	1.75	1.76	1.78	1.79	1.80	1.81
96		1.37	1.47	1.52	1.56	1.58	1.60	1.62	1.64	1.65	1.66	1.67	1.68	1.69	1.70
95	1.14	1.34	1.42	1.47	1.49	1.51	1.52	1.54	1.55	1.56	1.57	1.58	1.59	1.59	1.60
94		1.31	1.38	1.41	1.43	1.45	1.46	1.47	1.48	1.49	1.50	1.50	1.51	1.51	1.52
93	1.13	1.28	1.33	1.36	1.38	1.39	1.40	1.41	1.41	1.42	1.43	1.43	1.44	1.44	1.44
92	1.12	1.25	1.29	1.31	1.33	1.33	1.34	1.35	1.35	1.36	1.36	1.37	1.37	1.37	1.38
91	1.11	1.22	1.25	1.27	1.28	1.28	1.29	1.29	1.30	1.30	1.30	1.31	1.31	1.31	1.31
90	1.10	1.19	1.21	1.23	1.23	1.24	1.24	1.24	1.25	1.25	1.25	1.25	1.25	1.26	1.26
89	1.09	1.16	1.18	1.18	1.19	1.19	1.19	1.19	1.20	1.20	1.20	1.20	1.20	1.20	1.20
88	1.07	1.13	1.14	1.14	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15	1.15
87	1.06	1.10	1.10	1.10	1.10	1.10	1.10	1.10	1.11	1.11	1.11	1.11	1.11	1.11	1.11
86	1.04	1.07	1.07	1.07	1.07	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06	1.06
85	1.03	1.04	1.03	1.03	1.03	1.03	1.02	1.02	1.02	1.02	1.02	1.02	1.02	1.02	1.02
84	1.01	1.01	1.00	0.99	0.99	0.99	0.99	0.98	0.98	0.98	0.98	0.98	0.98	0.98	0.98
83	0.99	0.98	0.97	0.96	0.95	0.95	0.95	0.95	0.94	0.94	0.94	0.94	0.94	0.94	0.94
82	0.97	0.95	0.93	0.92	0.92	0.92	0.91	0.91	0.91	0.91	0.90	0.90	0.90	0.90	0.90
81	0.95	0.92	0.90	0.89	0.88	0.88	0.88	0.87	0.87	0.87	0.87	0.87	0.87	0.87	0.87
80	0.93	0.89	0.87	0.86	0.85	0.85	0.84	0.84	0.84	0.83	0.83	0.83	0.83	0.83	0.83
79	0.91	0.86	0.84	0.82	0.82	0.81	0.81	0.81	0.80	0.80	0.80	0.80	0.80	0.80	0.79
78	0.88	0.83	0.81	0.79	0.79	0.78	0.78	0.77	0.77	0.77	0.76	0.76	0.76	0.76	0.76
77	0.86	0.80	0.77	0.76	0.75	0.75	0.74	0.74	0.74	0.73	0.73	0.73	0.73	0.73	0.73
76	0.83	0.77	0.74	0.73	0.72	0.72	0.71	0.71	0.70	0.70	0.70	0.70	0.70	0.70	0.70
75	0.81	0.74	0.71	0.70	0.69	0.69	0.68	0.68	0.67	0.67	0.67	0.67	0.67	0.67	0.66
74	0.78	0.71	0.68	0.67	0.67	0.65	0.65	0.65	0.64	0.64	0.64	0.64	0.64	0.64	0.63
73	0.75	0.68	0.65	0.64	0.63	0.62	0.62	0.62	0.61	0.61	0.61	0.61	0.61	0.61	0.60
72	0.73	0.65	0.62	0.61	0.60	0.59	0.59	0.59	0.58	0.58	0.58	0.58	0.58	0.58	0.57
71	0.70	0.62	0.59	0.58	0.57	0.57	0.56	0.56	0.55	0.55	0.55	0.55	0.55	0.55	0.54
70	0.67	0.59	0.56	0.55	0.54	0.54	0.53	0.53	0.52	0.52	0.52	0.52	0.52	0.52	0.52
69	0.64	0.56	0.53	0.52	0.51	0.51	0.50	0.50	0.50	0.49	0.49	0.49	0.49	0.49	0.49
68	0.61	0.53	0.50	0.49	0.48	0.48	0.48	0.47	0.47	0.47	0.46	0.46	0.46	0.46	0.46
67	0.58	0.50	0.47	0.46	0.45	0.45	0.45	0.44	0.44	0.44	0.44	0.43	0.43	0.43	0.43
66	0.55	0.47	0.45	0.43	0.43	0.42	0.42	0.42	0.41	0.41	0.41	0.41	0.41	0.41	0.40
65	0.51	0.44	0.42	0.40	0.40	0.39	0.39	0.39	0.38	0.38	0.38	0.38	0.38	0.38	0.38
64	0.48	0.41	0.39	0.38	0.37	0.37	0.36	0.36	0.36	0.36	0.35	0.35	0.35	0.35	0.35
63	0.45	0.38	0.36	0.35	0.34	0.34	0.34	0.33	0.33	0.33	0.33	0.33	0.33	0.33	0.32
62	0.41	0.35	0.33	0.32	0.32	0.31	0.31	0.31	0.30	0.30	0.30	0.30	0.30	0.30	0.30
61	0.38	0.30	0.30	0.30	0.29	0.28	0.28	0.28	0.28	0.28	0.28	0.28	0.28	0.28	0.28
60	0.34	0.28	0.28	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
59	0.31	0.27	0.25	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23	0.23
58	0.30	0.25	0.23	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20
57	0.25	0.20	0.18	0.18	0.18	0.18	0.18	0.18	0.18	0.18	0.18	0.18	0.18	0.18	0.18
56	0.20	0.18	0.16	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.15
55	0.18	0.15	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.13	0.13
54	0.15	0.13	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10
53	0.10	0.10	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08	0.08
52	0.08	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05
51	0.05	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03
50	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00

Table 2 Pay Factors

Pay Factor	Required Quality Level for a Given Sample Size (n) and a Given Pay Factor														
	n=3	n=4	n=5	n=6	n=7	n=8	n=9	n=10 to n=11	n=12 to n=14	n=15 to n=17	n=18 to n=22	n=23 to n=29	n=30 to n=42	n=43 to n=66	n=67 to ∞
1.05						100	100	100	100	100	100	100	100	100	100
1.04					100	99	97	95	96	96	96	97	97	97	97
1.03				100	98	96	94	92	93	93	94	95	95	96	96
1.02				99	97	94	91	89	90	91	92	93	93	94	94
1.01	100	100	100	98	95	92	89	87	88	89	90	91	92	92	93
1.00	69	75	78	80	82	83	84	85	86	87	88	89	90	91	92
0.99	66	72	76	78	80	81	82	83	84	85	86	87	89	90	91
0.98	64	70	74	76	78	79	80	81	82	84	85	86	87	88	90
0.97	63	68	72	74	76	77	78	79	81	82	83	84	86	87	88
0.96	61	67	70	72	74	75	76	78	79	81	82	83	84	86	87
0.95	59	65	68	71	72	74	75	76	78	79	80	82	83	84	86
0.94	58	63	67	69	71	72	73	75	76	78	79	80	82	83	85
0.93	57	62	65	67	69	71	72	73	75	76	78	79	80	82	84
0.92	55	60	63	66	68	69	70	72	73	75	76	78	79	81	82
0.91	54	59	62	64	66	68	69	70	72	74	75	76	78	79	81
0.90	53	57	61	63	65	66	67	69	71	72	74	75	77	78	80
0.89	51	56	59	62	63	65	66	68	69	71	72	74	75	77	79
0.88	50	55	58	60	62	64	65	66	68	70	71	73	74	76	78
0.87	49	53	57	59	61	62	63	65	67	68	70	71	73	75	77
0.86	48	52	55	58	59	61	62	64	66	67	69	70	72	74	76
0.85	46	51	54	56	58	60	61	62	64	66	67	69	71	72	75
0.84	45	49	53	55	57	58	60	61	63	65	66	68	70	71	73
0.83	44	48	51	54	56	57	58	60	62	64	65	67	69	70	72
0.82	43	47	50	53	54	56	57	59	61	62	64	66	67	69	71
0.81	41	46	49	51	53	55	56	58	59	61	63	64	66	68	70
0.80	40	44	48	50	52	54	55	56	58	60	62	63	65	67	69
0.79	39	43	46	49	51	52	54	55	57	59	61	62	64	66	68
0.78	38	42	45	48	50	51	52	54	56	58	59	61	63	65	67
0.77	36	41	44	46	48	50	51	53	55	57	58	60	62	64	66
0.76	35	39	43	45	47	49	50	52	54	56	57	59	61	63	65
0.75	33	38	42	44	46	48	49	51	53	54	56	58	60	62	64
REJECT	Values Less Than Those Shown Above														

Reject Quality Levels Less Than Those Specified for a 0.75 Pay Factor

Note:

If the value of $(P_U + P_L) - 100$ does not correspond to a $(P_U + P_L) - 100$ value in this table, use the next smaller $(P_U + P_L) - 100$ value.

1-06.2(2)B Financial Incentive

As an incentive to produce superior quality material, a pay factor greater than 1.00 may be obtained with the maximum pay factor being 1.05. A lot containing non-Specification material will be accepted provided the Composite Pay Factor reaches the minimum value specified elsewhere. A lot containing non-Specification material which fails to obtain at least the specified minimum Composite Pay Factor will be rejected by the Engineer. The Engineer will take one or more of the following actions when rejected material has been incorporated into the Work:

1. Require complete removal and replacement with Specification material at no additional cost to the Contracting Agency.
2. At the Contractor's written request, allow corrective work at no additional cost to the Contracting Agency and then an appropriate price reduction that may range from no reduction to no payment.
3. At the Contractor's written request, allow material to remain in place with an appropriate price reduction that may range from a designated percentage reduction to no payment.

Any lot for which at least three samples have been obtained, and all of the test results meet one of the appropriate criteria listed below, will receive at least a 1.00 Composite Pay Factor:

1. All test results are within the allowable limits specified for the item, or
2. All test results that only have a lower Specification limit are greater than or equal to that limit, or
3. All test results that only have an upper Specification limit are less than or equal to that limit.

Computation of the quality level in these instances will be for determining the amount of any bonus that might be warranted.

Lots represented by less than three samples or unsampled lots will be exempt from statistical based acceptance.

1-06.2(2)C Removed and Rejected Materials

The Contractor may, prior to sampling, elect to remove any defective material and replace it with new material at no expense to the Contracting Agency. Any such new material will be sampled, tested, and evaluated for acceptance as a part of the sublot in accordance with this statistical sampling and testing procedure.

The Engineer may reject a sublot that tests show to be defective. Such rejected material shall not be used in the Work, and the results of tests run on the rejected material will not be included in the original lot acceptance tests.

1-06.2(2)D Quality Level Analysis

1-06.2(2)D1 General

The quality level calculations for HMA and other materials are completed using the formulas in Section 1-06.2(2)D4. For HMA, the definition of the "x" value used in the calculations and the definition of the upper and lower specification limit are in Section 1-06.2(2)D2. For other materials, the definition of the "x" value used in the calculations and the definition of the upper and lower specification limit are in Section 1-06.2(2)D3. All other terms and variables are the same for all calculations.

1-06.2(2)D2 Hot Mix Asphalt

For HMA mixture:

x = difference between an individual test value and the job mix formula (JMF)

USL = maximum allowable limit in Section 9-03.8(7)

LSL = minimum allowable limit in Section 9-03.8(7)

For HMA compaction:

x = individual test value

LSL = the value specified in Section 5-04.3(10)C3

1-06.2(2)D3 Other Materials

x = individual test value

USL = upper specification limit

LSL = lower specification limit

1-06.2(2)D4 Quality Level Calculation

The procedures for determining the quality level and pay factors for a material, other than HMA compaction, are as follows:

1. Determine the arithmetic mean, X_m, for each specified material constituent:

$$X_m = \frac{\Sigma x}{n}$$

Where:

$\sum$ = summation of x
n = total number test values

2. Compute the sample standard deviation, "S", for each constituent:

$$S = \left[\frac{n\Sigma x^2 - (\Sigma x)^2}{n(n-1)}\right]^{\frac{1}{2}}$$

Where:

Σx^2 = summation of the squares of individual test values

$(\Sigma x)^2$ = summation of the individual test values squared

3. Compute the upper quality index, (Q_U), for each constituent:

$$Q_U = \frac{USL - X_m}{S}$$

4. Compute the lower quality index, (Q_L), for each constituent:

$$Q_L = \frac{X_m - LSL}{S}$$

5. For each constituent determine P_U (the percent within the upper Specification limit which corresponds to a given Q_U) from Table 1. If USL is 100.00 percent or is not specified, P_U will be 100. For negative values of Q_U, P_U (e.g., N = 15 and Q_U = -0.5 will result in P_U = 30) is equal to 100 minus the table P_U. If the value of Q_U does not correspond exactly to a figure in the table, use the next higher value.

6. For each constituent determine P_L (the percent within the lower Specification limit which corresponds to a given Q_L) from Table 1. If LSL is zero or not specified, P_L will be 100. For negative values of Q_L, P_L is equal to 100 minus the table P_L. If the value of Q_L does not correspond exactly to a figure in the table, use the next higher value.

7. For each constituent determine the quality level (the total percent within Specification limits):

   Quality Level = (P_U + P_L) – 100

8. Using the quality level from step 7, determine the pay factor (PF_i) from Table 2 for each constituent tested.

9. Determine the Composite Pay Factor (CPF) for each lot.

$$CPF = \frac{f_1(PF_1) + f_2(PF_2) + \cdots + f_i(PF_i)}{\Sigma f_i}$$

$$i = 1 \text{ to } j$$

Where:

f_i = price adjustment factor listed in these Specifications for the applicable material

j = number of constituents being evaluated

1-06.3 Manufacturer's Certificate of Compliance

When authorized by these Specifications or the Special Provisions and prior to use, the Engineer may accept certain materials on the basis of a Manufacturer's Certificate of Compliance as an alternative to material inspection and testing.

The Contractor may request, in writing, authority from the Engineer to install such materials prior to submitting the required certification; however, no payment will be made for the Work in the absence of an acceptable Manufacturer's Certificate of Compliance. The Contracting Agency reserves the right to deny the request for good cause. If for

any reason the Contractor has not provided an acceptable Manufacturer's Certificate of Compliance by the Physical Completion Date established by Section 1-08.5, the Contracting Agency will assess the usefulness of the installed material. At the Engineer's discretion, the Contracting Agency will either require replacement of the material by the Contractor at no expense to the Contracting Agency or process the final payment as provided by Section 1-09.9 without paying for the materials or any portion of the Work performed to install the materials provided on such a basis. The unit Contract prices for the Work shall be used to determine the amount to be withheld. Where unit Contract prices do not exist, as in a lump sum item, the amount to be withheld shall be an equitable adjustment, covering labor, equipment and materials, determined in accordance with Section 1-09.4.

The Manufacturer's Certificate of Compliance must identify the manufacturer, the type and quantity of material being certified, the applicable Specifications being affirmed, and the signature of a responsible corporate official of the manufacturer and include supporting mill tests or documents. A Manufacturer's Certificate of Compliance shall be furnished with each lot of material delivered to the Work and the lot so certified shall be clearly identified in the certificate.

All materials used on the basis of a Manufacturer's Certificate of Compliance may be sampled and tested at any time. Any material not conforming to the requirements will be subject to rejection whether in place or not. The Contracting Agency reserves the right to refuse to accept materials on the basis of a Manufacturer's Certificate of Compliance.

1-06.4 Handling and Storing Materials

In storage and handling, the Contractor shall protect materials against damage from careless handling, from exposure to weather, from mixture with foreign matter, and from all other causes. The Engineer will reject and refuse to test materials improperly handled or stored.

The Contractor shall repair, replace, or make good all Contracting Agency-provided materials that are damaged or lost due to the Contractor's operation or while in the Contractor's possession, at no expense to the Contracting Agency.

1-06.5 Owners Manuals and Operating Instructions

For equipment and materials that are permanently incorporated in the Work, the Contractor shall provide to the Engineer all owners manuals and operating instructions furnished by the equipment or material manufacturer.

1-06.6 Recycled Materials

The Contractor shall make their best effort to utilize recycled materials in the construction of the project; the use of recycled concrete aggregate as specified in Section 1-06.6(1)A is a requirement of the Contract.

The Contractor shall submit a Recycled Material Utilization Plan on WSDOT Form 350-075A within 30 calendar days after the Contract is executed. The plan shall provide

the Contractor's anticipated usage of recycled concrete aggregates for meeting the requirements of these Specifications. The quantity of recycled concrete aggregate will be provided in tons and as a percentage of the Plan quantity for eligible material listed in Section 9-03.21(1)E Table on Maximum Allowable percent (By Weight) of Recycled Material. When a Contract does not include Work that requires the use of a material that is included in the requirements for using materials the Contractor may state in their plan that no recycled materials are proposed for use.

Within 30 calendar days after Physical Completion the Contractor shall report the quantity of recycled concrete aggregates that were utilized in the construction of the project for each eligible item listed in Section 9-03.21(1)E. The Contractor's report shall be provided on WSDOT Form 350-075A, Recycled Concrete Aggregate Reporting.

1-06.6(1) Recycling of Aggregate and Concrete Materials

1-06.6(1)A General

The minimum quantity of recycled concrete aggregate shall be 25 percent of the total quantity of aggregate that is incorporated into the Contract for those items listed in Section 9-03.21(1)E Table on Maximum Allowable percent (By Weight) of Recycled Material that allow the use of recycled concrete aggregate. The percentage of recycled material incorporated into the project for meeting the required percentage will be calculated in tons based on the quantity of recycled concrete used on the entire Contract and not as individual items.

If the Contractor's total cost for Work with recycled concrete aggregate is greater than without the Contractor may choose to not use recycled concrete aggregate. If the Recycled Material Utilization Plan does not indicate the minimum usage of recycled concrete aggregate required above, or if completed project quantities do not meet the minimum usage required, the Contractor shall develop the following:

1. A cost estimate for each material listed in Section 9-03.21(1)E that is utilized on the Contract. The cost estimate shall include the following:
    a. The estimated costs for the Work for each material with 25 percent recycled concrete aggregate. The cost estimate shall include for each material a documented price quote from the supplier with the lowest total cost for the Work.
    b. The estimated costs for the Work for each material without recycled concrete aggregate.

The Contractor's cost estimates shall be submitted as an attachment to the Recycled Material Utilization Plan, or with the Reporting form.

1-07 Legal Relations and Responsibilities to the Public

1-07.1 Laws to be Observed

The Contractor shall always comply with all Federal, State, tribal, or local laws, ordinances, and regulations that affect Work under the Contract. The Contractor shall indemnify, defend, and save harmless the State (including the Governor, Commission, Secretary, and any agents, officers, and employees) against any claims that may arise because the Contractor (or any employee of the Contractor or Subcontractor or materialperson) violated a legal requirement.

The Contractor shall be responsible for the safety of all workers and shall comply with all appropriate state safety and health standards, codes, rules, and regulations, including, but not limited to, those promulgated under the Washington Industry Safety and Health Act RCW 49.17 (WISHA) and as set forth in Title 296 WAC (Department of Labor and Industries). In particular the Contractor's attention is drawn to the requirements of WAC 296.800 which requires employers to provide a safe workplace. More specifically WAC 296.800.11025 prohibits alcohol and narcotics from the workplace. The Contractor shall likewise be obligated to comply with all federal safety and health standards, codes, rules, and regulations that may be applicable to the Contract Work. A copy of all safety plans (e.g., fall protection work plan) that are developed by the Contractor shall be submitted to the Engineer as a Type 1 Working Drawing. When requested by the Engineer, the Contractor shall provide training to Contracting Agency employees working on-site for any activity covered by a safety plan. Costs for training that is provided solely to Contracting Agency employees will be paid to the Contractor in accordance with Section 1-09.4.

U.S. Mine Safety and Health Administration rules apply when the project includes pit or quarry operations. Among other actions, these regulations require the Contractor to notify the nearest Mine Safety and Health sub district office (1) of the project before it begins, (2) of the starting date, and (3) of the Physical Completion Date.

Without usurping the authority of other agencies, the Contracting Agency will cooperate with them in their efforts to enforce legal requirements. Upon awareness of a violation of a legal requirement, the Engineer will notify the Contractor in an effort to achieve compliance. The Engineer may also notify the agency responsible for enforcement if the Engineer deems that action is necessary to achieve compliance with legal requirements. The Engineer will also assist the enforcement agency to obtain Contractor compliance to the extent such assistance is consistent with the provisions of the Contract.

The Contracting Agency will not adjust payment to compensate the Contractor for changes in legal requirements unless those changes are specifically within the scope of RCW 39.04.120. For changes under RCW 39.04.120, the Contracting Agency will compensate the Contractor by negotiated change order as provided in Section 1-04.4.

Under certain conditions, the Contracting Agency will adjust payment to compensate for tax changes. First, the changes shall involve federal or state taxes on materials or fuel used in or consumed for the project. Second, the changes shall increase or decrease Contractor-paid taxes by more than $500. For items in the original Contract, the tax change must occur after the Bid opening date. For negotiated Contracts or items in a supplemental agreement, the tax change must take place after the execution date of the Contract or agreement. Within these conditions, the Contracting Agency will adjust compensation by the actual dollar amounts of increase or decrease caused by the tax changes. If the Engineer requests it, the Contractor shall certify in writing that the Contract price does not include any extra amount to cover a possible change in taxes.

The Contracting Agency may audit the records of the Contractor as provided in Section 1-09.12, to verify any claim for compensation because of changes in laws or taxes.

1-07.2 State Taxes

The Washington State Department of Revenue has issued special rules on the state sales tax. Sections 1-07.2(1) through 1-07.2(3) are meant to clarify those rules. The Contracting Agency will not adjust its payment if the Contractor bases a Bid on a misunderstood tax liability.

The Contracting Agency may deduct from its payments to the Contractor, retainage or lien the bond, in the amount the Contractor owes the State Department of Revenue, whether the amount owed relates to the Contract in question or not. Any amount so deducted will be paid into the proper State fund on the contractor's behalf. For additional information on tax rates and application refer to applicable RCWs, WACs or the Department of Revenue website.

1-07.2(1) State Sales Tax: WAC 458-20-171 – Use Tax

For Work designated as Rule 171, **Use Tax**, the Contractor shall include for compensation the amount of any taxes paid in the various unit Bid prices or other Contract amounts. Typically, these taxes are collected on materials incorporated into the project and items such as the purchase or rental of; tools, machinery, equipment, or consumable supplies not integrated into the project.

The Summary of Quantities in the Contract Plans identifies those parts of the project that are subject to **Use Tax** under Section 1-07.2(1).

1-07.2(2) State Sales Tax: WAC 458-20-170 – Retail Sales Tax

For Work designated as Rule 170, **Retail Sales Tax**, the Contractor shall collect from the Contracting Agency, **Retail Sales Tax** on the full Contract price. The Contracting Agency will automatically add this **Retail Sales Tax** to each payment to the Contractor and for this reason; the Contractor shall not include the **Retail Sales Tax** in the unit Bid prices or in any other Contract amount. The Contractor (Prime or Subcontractor) shall include sales or use tax on the purchase or rental of tools, machinery, equipment, or consumable supplies not integrated into the project, in the unit bid prices.

The Summary of Quantities in the Contract Plans identifies those parts of the project that are subject to **Retail Sales Tax** under Section 1-07.2(2).

1-07.2(3) Services

Any contract wholly for professional or other applicable services is generally not subject to **Retail Sales Tax** and therefore, the Contractor shall not collect **Retail Sales Tax** from the Contracting Agency on those Contracts. Any incidental taxes paid as part of providing the services shall be included in the payments under the contract.

1-07.3 Fire Prevention and Merchantable Timber Requirements

1-07.3(1) Fire Prevention Control and Countermeasures Plan

The Contractor shall prepare and implement a project-specific fire prevention, control, and countermeasures plan (FPCC Plan) for the duration of the project. The Contractor shall submit a Type 2 Working Drawing no later than the date of the preconstruction conference.

1-07.3(1)A FPCC Implementation Requirements

The Contractor's FPCC Plan shall be fully implemented at all times. The Contractor shall update the FPCC Plan throughout project construction so that the plan reflects actual site conditions and practices. The Contractor shall update the FPCC Plan at least annually and maintain a copy of the updated FPCC Plan that is available for inspection on the project site. Revisions to the FPCC Plan and the Industrial Fire Precaution Level (IFPL) shall be discussed at the weekly project safety meetings.

1-07.3(1)A1 FPCC Plan Element Requirements

The FPCC Plan shall include the following:

1. The names, titles, and contact information for the personnel responsible for implementing and updating the plan.
2. The names and telephone numbers of the Federal, State, and local agencies the Contractor shall notify in the event of a fire.
3. All potential fire causing activities such as welding, cutting of metal, blasting, fueling operations, etc.

4. The location of fire extinguishers, water, shovels, and other firefighting equipment.
5. The response procedures the Contractor shall follow in the event of a fire.

Most of Washington State is covered under the IFPL system which, by law, is managed by the Department of Natural Resources (DNR). In some cases jurisdiction is transferred to the United States Forest Service (USFS) or to the local fire authority. It is the Contractor's responsibility to be familiar with the IFPL requirements and to verify whether or not IFPL applies to the specific project.

If the Contractor wishes to continue a work activity that is prohibited under an industrial fire precaution level, the Contractor shall obtain a waiver from the fire authority with jurisdiction and provide a copy to the Engineer prior to continuation of work on the project.

If the IFPL requirements prohibit the Contractor from performing Work the Contractor may be eligible for an unworkable day in accordance with Section 1-08.5.

The Contractor shall comply with the requirements of these provisions at no additional cost to the Contracting Agency.

1-07.3(1)A2 Forest Fire Prevention

When the Work is in or next to State or Federal forests, the Contractor shall know and observe all laws and rules (State or Federal) on fire prevention and sanitation. The Contractor shall ask the local forest supervisor or regional manager to outline requirements for permits, sanitation, firefighting equipment, and burning.

The Contractor shall take all reasonable precautions to prevent and suppress forest fires. In case of forest fire, the Contractor shall immediately notify the nearest forest headquarters of its exact site and shall make every effort to suppress it. If needed, the Contractor shall require his/her employees and those of any Subcontractor to work under forest officials in fire-control efforts.

1-07.3(2) Merchantable Timber Requirements

When merchantable timber is to be cut, the Contractor shall obtain a permit from the appropriate regional office of the State Department of Natural Resources and comply fully with the State Forest Practices Act.

No person may export from the United States, or sell, trade, exchange, or otherwise convey to any other person for the purpose of export from the United States, timber originating from the project.

The Contractor shall comply with the Forest Resources Conservation and Shortage Relief Amendments Act of 1993 (Public Law 103-45) and the Washington State Log Export Regulations (WAC 240-15).

1-07.4 Sanitation

1-07.4(1) General

The Contractor shall provide employees with all accommodations required by the State Department of Health and other agencies. These accommodations shall be kept clean, neat, and sanitized, and shall not create any public nuisance. The Contractor shall keep all campsites clean, properly dispose of all refuse, and leave each site in a neat and sanitary condition.

1-07.4(2) Health Hazards

Biological hazards and associated physical hazards may be present in the worksite. The Contractor shall take precautions and perform any necessary Work to provide and maintain a safe and healthful worksite in accordance with applicable laws. Payment for Work necessary to provide and maintain a safe worksite will be incidental to associated items of Contract Work unless the Contract includes provisions to the contrary.

1-07.5 Environmental Regulations

1-07.5(1) General

No Work shall occur within areas under the jurisdiction of resource agencies unless authorized in the Contract. Some, though not all, of these rules are summarized below. Any of these agencies may, without prejudice to the Contracting Agency, add rules as needed to protect game, fish, or the environment.

The Contractor shall be responsible to immediately report to the Engineer any deviation from the contract provisions pertaining to environmental compliance, including but not limited to spills, unauthorized fill in waters of the State including wetlands, water quality standards, noise, air quality, etc.

1-07.5(2) State Department of Fish and Wildlife

In doing the Work, the Contractor shall:

1. Not degrade water in a way that would harm fish, wildlife, or their habitat.
2. Not place materials below or remove them from the ordinary high water line except as may be specified in the Contract.
3. Not allow equipment to enter waters of the State except as specified in the Contract.
4. Revegetate in accordance with the Plans, unless the Special Provisions permit otherwise.
5. Prevent any fish-threatening silt buildup on the bed or bottom of any body of water.
6. Ensure continuous stream flow downstream of the Work area.

7. Dispose of any project debris by removal, burning, or placement above high-water flows.
8. Immediately notify the Engineer and stop all work causing impacts, if at any time, as a result of project activities, fish are observed in distress or a fish kill occurs.

If the Work in (1) through (3) above differs little from what the Contract requires, the Contracting Agency will measure and pay for it at unit Contract prices. But if Contract items do not cover those areas, the Contracting Agency will pay pursuant to Section 1-09.4. Work in (4) through (8) above shall be incidental to Contract pay items.

1-07.5(3) State Department of Ecology

In doing the Work, the Contractor shall:

1. Comply with Washington State Water Quality Standards.
2. Perform Work in such a manner that all materials and substances not specifically identified in the Contract documents to be placed in the water do not enter waters of the State, including wetlands. These include, but are not limited to, petroleum products, hydraulic fluid, fresh concrete, concrete wastewater, process wastewater, slurry materials and waste from shaft drilling, sediments, sediment-laden water, chemicals, paint, solvents, or other toxic or deleterious materials.
3. Use equipment that is free of external petroleum-based products.
4. Remove accumulations of soil and debris from drive mechanisms (wheels, tracks, tires) and undercarriage of equipment prior to using equipment below the ordinary high water line.
5. Clean loose dirt and debris from all materials placed below the ordinary high water line. No materials shall be placed below the ordinary high water line without the Engineer's approval.
6. When a violation of the Construction Stormwater General Permit (CSWGP) occurs, immediately notify the Engineer and fill out WSDOT Form 422-011, Contractor ECAP Report, and submit the form to the Engineer within 48 hours of the violation.
7. Once Physical Completion has been given, prepare a Notice of Termination (Ecology Form ECY 020-87) and submit the Notice of Termination electronically to the Engineer in a PDF format a minimum of 7 calendar days prior to submitting the Notice of Termination to Ecology.
8. Transfer the CSWGP coverage to the Contracting Agency when Physical Completion has been given and the Engineer has determined that the project site is not stabilized from erosion.
9. Submit copies of all correspondence with Ecology electronically to the Engineer in a PDF format within four calendar days.

1-07.5(4) Air Quality

The Contractor shall comply with all regional clean air authority and/or State Department of Ecology rules and regulations.

The air quality permit process may include additional State Environment Policy Act (SEPA) requirements. Contractors shall contact the appropriate regional air pollution control authority well in advance of beginning Work.

When the Work includes demolition or renovation of any existing facility or structure that contains Asbestos Containing Material (ACM) and/or Presumed Asbestos-Containing Material (PACM), the Contractor shall comply with the National Emission Standards for Hazardous Air Pollutants (NESHAP).

Any requirements included in Federal regulations regarding air quality that applies to the "owner or operator" shall be the responsibility of the Contractor.

1-07.5(5) U.S. Army Corps of Engineers

When temporary fills are permitted, the Contractor shall remove fills in their entirety and the affected areas returned to pre-construction elevations.

If a U.S. Army Corps of Engineers permit is noted in Section 1-07.6 of the Special Provisions, the Contractor shall retain a copy of the permit or the verification letter (in the case of a Nationwide Permit) on the worksite for the life of the Contract. The Contractor shall provide copies of the permit or verification letter to all subcontractors involved with the authorized work prior to their commencement of any work in waters of the U.S.

1-07.5(6) U.S. Fish and Wildlife Service and National Marine Fisheries Service

The Contracting Agency will provide fish exclusion and handling services if the Work dictates. However, if the Contractor discovers any fish stranded by the project and a Contracting Agency biologist is not available, they shall immediately release the fish into a flowing stream or open water.

1-07.6 Permits and Licenses

Contractors shall obtain all required permits and licenses and give any notices these call for.

The Contracting Agency will support the Contractor in efforts to obtain a temporary operating permit in its name if:

1. A local rule or an agency policy prevent issuing the permit to a private firm;
2. The Contractor takes all action to obtain the permit;
3. The permit will serve the public interest;
4. The permit applies only to Work under the Contract;

5. The Contractor agrees in writing: (a) to comply with all the issuing agency requires, and (b) to hold the Contracting Agency harmless for any Work-related liability incurred under the permit; and
6. The permit costs the Contracting Agency nothing.

1-07.7 Load Limits

1-07.7(1) General

While moving equipment or materials on any public Highway, the Contractor shall comply with all laws that control traffic or limit loads. The Contract neither exempts the Contractor from such laws nor licenses overloads. At the Engineer's request, the Contractor shall provide any facts needed to compute the equipment's weight on the Roadway.

All Contractor movement or storage of materials or equipment within the project limits (as shown in the Plans):

1. Legal load limits shall apply on any road open to and in use by public traffic.
2. Legal load limits shall apply on any existing road not scheduled for major reconstruction under the current Contract.
3. The Contractor may haul overloads (not more than 25 percent above load limits) on any newly paved roads (with final lift in place) built under this Contract not open to public traffic if this does not damage completed Work.
4. When moving vehicles or operating equipment on or over structures design for direct bearing of live load, buried structures, culverts, pipes, or retaining walls within the project limits, the Contractor shall meet the load-limit restrictions in Section 1-07.7(2).
5. When storing material on a Structure or retaining wall, the Contractor shall meet the load-limit restrictions in Section 1-07.7(2). These requirements are not intended for long term storage of material.
6. The Contractor shall remain responsible for and pay all repair costs due to any load-caused damage on any newly paved roads, new and existing Structures, culverts, pipes and retaining walls.

Unit prices shall cover all costs for operating vehicles or storing materials on or over structures, culverts, pipes, and retaining walls. Nothing in this section affects the Contractor's other responsibilities under these Specifications or under public Highway laws.

Bridges that are under construction shall meet the load restrictions in Section 6-01.6.

1-07.7(2) Load-Limit Restrictions

At the request of the Engineer, the Contractor shall provide supporting documentation of vehicle, equipment or material loads, axle or support dimensions and any additional information used to determine the loads.

1. **Structures Designed for Direct Bearing of Live Loads**
   The gross vehicle weight or maximum load on each axle shall not exceed the legal load limit nor any posted weight limit on a Structure.

   Construction equipment that is not considered a legal vehicle licensed for legal travel on the public Highway, including but not limited to track or steel wheeled vehicles, may operate on a Structure. Gross equipment weight, axle spacing, equipment spacing, and other attributes identified in the Plans shall not be exceeded. When loads are not identified in the Plans, the construction equipment shall not exceed the following load restrictions:

   a. The gross vehicle weight or maximum load on each axle shall not exceed the legal load limit, axle spacing nor any posted weight limit on a Structure.

   b. A tracked vehicle with a maximum gross vehicle weight of 40,000 pounds and track contact length no less than 8 feet. The maximum gross vehicle weight may increase by 2,000 pounds for each one foot of track contact length over 8 feet, but shall not exceed 80,000 pounds.

   c. A tracked vehicle with a maximum gross vehicle weight of 20,000 pounds and track contact length less than 8 feet.

   d. No single axle shall exceed 20,000 pounds.

   e. No more than one vehicle shall operate over any Structure at one time.

   Track contact length shall be measured once for two or more parallel tracks.

   The Contractor shall not store construction materials on timber Structures or Structures posted for weight limits. When a structure within the project limits is not posted for weight limits and there is no other reasonable storage space within the project limits, the Contractor may store construction material on the Structure and shall not exceed the maximum uniformly distributed load and distribution length along the structure per the following table:

Maximum Uniform Load (psf)		
Maximum Distributed Length Along Structure	Structure Width (curb-to-curb)	
	24 feet or less	greater than 24 feet
15 ft	250	160
40 ft	125	80
80 ft	75	50
Full Structure Length	50	35

The load restrictions for storing material or operating equipment shall not be combined and shall apply to the full structure length. Materials that are stored in two or more locations on the same structure shall use the total combined length to determine the maximum load restriction. Vehicle traffic and the Contractor's equipment may operate in the adjacent lanes to the stored materials and shall not be allowed on the structure width that is occupied by the stored materials. Contractor's equipment that is used to deliver or remove any stored material with the same structure width shall be considered in combination with all stored materials. This equipment shall be assumed to be uniformly distributed over the largest axle spacing and average axle width.

The Contractor shall immediately remove any dirt, rock, or debris that may gather on the Structure's roadway surface.

2. Buried Structures

Buried Structures shall include reinforced concrete three sided structures, box culverts, split box culverts, structural plate pipe, pipe arch, and underpasses.

Loads shall not exceed 24,000 pounds on a single axle and 16,000 pounds each on tandem axles spaced less than 10 feet apart. These limits are permitted only if the embankment has: (a) been built to Specifications, and (b) reached at least 3 feet above the top of the buried structure.

When the embankment has reached 5 feet above the top of the buried structure, the Contractor may increase per-axle loads up to 100,000 pounds if outside wheel spacing is at least 7 feet on axle centers.

3. **Pipe Culverts and Sewer Pipes**

Pipe culverts and sewer pipes shall include pipe for drainage, storm sewers, and sanitary sewers.

Loads over pipe culverts and sewer pipes shall not exceed 24,000 pounds on a single axle and 16,000 pounds each on tandem axles spaced less than 10 feet apart. These limits are permitted only if: (a) the culvert or pipe has been installed and backfilled to Specifications, and (b) the embankment has reached at least 2 feet above the top limit of pipe compaction.

When the embankment has reached 5 feet above the top limit of pipe compaction, the Contractor may increase per-axle loads up to 100,000 pounds if outside wheel spacing is at least 7 feet on axle centers, except that:

a. For Class III reinforced concrete pipes, the embankment shall have risen above the top limit of compaction at least 6 feet.

b. For Class II reinforced concrete pipes, the maximum load for each axle shall be 80,000 pounds if outside wheel spacing is at least 7 feet on axle centers. In this case, the embankment shall have risen above the top limit of compaction at least 6 feet.

4. Retaining Walls

   Loads above existing and completed retaining walls designed for vehicular loads, where any part of the load is located within half the retaining wall height, shall not exceed the following load restrictions:

   a. The gross vehicle weight or maximum load on each axle shall not exceed the legal load limit.

   b. Construction equipment and material shall not exceed 250 pounds per square foot.

   If necessary and safe to do so, the Engineer may allow higher loads than those allowed under these load-limit restrictions. For loads on or over structures designed for direct bearing of live load, the Contractor shall submit Type 3E Working Drawings consisting of calculations and other supporting information in accordance with the requirements of Section 6-01.6. For loads on or over pipes, culverts, buried structures, and retaining walls the Contractor shall submit Type 2E Working Drawings. All submittals shall contain the following information: a description of the loading details; arrangement, movement and position of all vehicles, equipment and materials on the Structure, culvert or pipe; and statement that the Contractor assumes all risk for damage.

1-07.8 High-Visibility Apparel

The Contractor shall require all personnel under their control (including service providers, Subcontractors, and lower tier subcontractors) that are on foot in the work zone and are exposed to vehicle traffic or construction equipment to wear the high-visibility apparel described in this section.

The Contractor shall ensure that a competent person as identified in the MUTCD selects the appropriate high-visibility apparel suitable for the jobsite conditions.

High-visibility garments shall always be the outermost garments.

High-visibility garments shall be labeled as, and in a condition compliant with the ANSI/ISEA 107 (2004 or later version) and shall be used in accordance with manufacturer recommendations.

1-07.8(1) Traffic Control Personnel

All personnel performing the Work described in Section 1-10 (including traffic control supervisors, flaggers, spotters, and others performing traffic control labor of any kind) shall comply with the following:

1. During daylight hours with clear visibility, workers shall wear a high-visibility ANSI/ISEA 107 Class 2 or 3 vest or jacket, and hardhat meeting the high-visibility headwear requirements of WAC 296-155-305; and

2. During hours of darkness (½ hour before sunset to ½ hour after sunrise) or other low-visibility conditions (snow, fog, etc.), workers shall wear a high-visibility ANSI/ISEA 107 Class 2 or 3 vest or jacket, high-visibility lower garment meeting ANSI/ISEA 107 Class E, and hardhat meeting the high-visibility headwear requirements of WAC 296-155-305.

1-07.8(2) Non-Traffic Control Personnel

All personnel, except those performing the Work described in Section 1-10, shall wear high-visibility apparel meeting the ANSI/ISEA 107 Class 2 or 3 standard.

1-07.9 Wages

1-07.9(1) General

This Contract is subject to the minimum wage requirements of RCW 39.12 and to RCW 49.28 (as amended or supplemented). On Federal-aid projects, Federal wage laws and rules also apply. The hourly minimum rates for wages and fringe benefits are listed in the Contract Provisions. When Federal wage and fringe benefit rates are listed, the rates match those identified by the U.S. Department of Labor's "Decision Number" shown in the Contract Provisions.

The Contractor, any Subcontractor, and all individuals or firms required by RCW 39.12, WAC 296-127, or the Federal Davis-Bacon and Related Acts (DBRA) to pay minimum prevailing wages, shall not pay any worker less than the minimum hourly wage rates and fringe benefits required by RCW 39.12 or the DBRA. Higher wages and benefits may be paid.

By including the hourly minimum rates for wages and fringe benefits in the Contract Provisions, the Contracting Agency does not imply that the Contractor will find labor available at those rates. The Contractor shall be responsible for any amounts above the minimums that will actually have to be paid. The Contractor shall bear the cost of paying wages above those shown in the Contract Provisions.

When the project is subject to both State and Federal hourly minimum rates for wages and fringe benefits and when the two rates differ for similar kinds of labor, the Contractor shall not pay less than the higher rate unless the State rates are specifically preempted by Federal law. When the project involves highway Work, heavy Work, and building Work, the Contract Provisions may list a Federal wage and fringe benefit rate for the highway Work, and a separate Federal wage and fringe benefit rate for both heavy Work and building Work. The area in which the worker is physically employed shall determine which Federal wage and fringe benefit rate shall be used to compare against the State wage and fringe benefit rate.

If employing labor in a class not listed in the Contract Provisions on state funded projects only, the Contractor shall request a determination of the correct wage and benefits rate for that class and locality from the Industrial Statistician, Washington State Department of Labor and Industries (State L&I), and provide a copy of those determinations to the Engineer.

If employing labor in a class not listed in the Contract Provisions on federally funded projects, the Contractor shall request a determination of the correct wage and benefit for that class and locality from the U.S. Secretary of Labor through the Engineer. Generally, the Contractor initiates the request by preparing standard form 1444 Request for Authorization of Additional Classification and Rate, available at www.gsa.gov/reference/forms, and submitting it to the Engineer for further action.

The Contractor shall ensure that any firm (Supplier, Manufacturer, or Fabricator) that falls under the provisions of RCW 39.12 because of the definition "Contractor" in WAC 296-127-010, complies with all the requirements of RCW 39.12.

The Contractor shall be responsible for compliance with the requirements of the DBRA and RCW 39.12 by all firms (Subcontractors, lower tier subcontractors, Suppliers, Manufacturers, or Fabricators) engaged in any part of the Work necessary to complete this Contract. Therefore, should a violation of this Subsection occur by any firm that is providing Work or materials for completion of this Contract whether directly or indirectly responsible to the Contractor, the Contracting Agency will take action against the Contractor, as provided by the provisions of the Contract, to achieve compliance, including but not limited to, withholding payment on the Contract until compliance is achieved.

In the event the Contracting Agency has an error (omissions are not errors) in the listing of the hourly minimum rates for wages and fringe benefits in the Contract Provisions, the Contractor, any Subcontractor, any lower tier subcontractor, or any other firm that is required to pay prevailing wages, shall be required to pay the rates as determined to be correct by State L&I (or by the U.S. Department of Labor when that agency sets the rates). A change order will be prepared to ensure that this occurs. The Contracting Agency will reimburse the Contractor for the actual cost to pay the difference between the correct rates and the rates included in the Contract Provisions, subject to the following conditions:

1. The affected firm relied upon the rates included in the Contract Provisions to prepare its Bid and certifies that it did so;
2. The allowable amount of reimbursement will be the difference between the rates listed and rates later determined to be correct plus only appropriate payroll markup the employer must pay, such as, social security and other payments the employer must make to the Federal or State Government;
3. The allowable amount of reimbursement may also include some overhead cost, such as, the cost for bond, insurance, and making supplemental payrolls and new checks to the employees because of underpayment for previously performed Work; and
4. Profit will not be an allowable markup.

Firms that anticipated, when they prepared their Bids, paying a rate equal to, or higher than, the correct rate as finally determined will not be eligible for reimbursement.

There are many work-ready pre-apprentices who are currently looking for work in the highway construction trades all across the state of Washington. Contractors may have apprenticeship utilization commitments as part of their business practices and as part of their Contract. Contractors may be subject to hiring commitments such as Equal Employment Opportunity, union commitments, and apprenticeship utilization requirements on Contracts receiving Federal or State funds. As part of a Contractor's Good Faith Efforts, contacting the Office of Equal Opportunity's On the Job Training Support Services (OJT/SS) Program Coordinator is highly encouraged. The OJT/SS Program Coordinator can connect Contractors with Washington State Apprenticeship Training Council recognized Pre-Apprenticeship training providers throughout the state, who give training to individuals in highway construction trades. These training providers can identify work-ready individuals in the necessary trades. Contractors who have been awarded WSDOT Contracts should be prepared to discuss their recruitment plans and how coordination with the OJT/SS Program Coordinator will be incorporated into that effort if needed. The Contractor may contact the OJT/SS Program Coordinator at 360-704-6314, or by email at ojtssinfo@wsdot.wa.gov.

1-07.9(2) Posting Notices

Notices and posters shall be placed in areas readily accessible to read by employees. The Contractor shall ensure the most current edition of the following are posted:

1. EEOC - P/E-1 – **Equal Employment Opportunity IS THE LAW** published by US Department of Labor. Post for projects with federal-aid funding.
2. Mandatory Supplement to EEOC P/E-1 published by US Department of Labor. Post for projects with federal-aid funding.
3. Pay Transparency Nondiscrimination Provision published by US Department of Labor. Post for projects with federal-aid funding.
4. FHWA 1022 – **NOTICE Federal-Aid Project** published by Federal Highway Administration (FHWA). Post for projects with federal-aid funding.
5. WH 1321 – **Employee Rights Under the Davis-Bacon Act** published by US Department of Labor. Post for projects with federal-aid funding.
6. WHD 1088 – **Employee Rights Under the Fair Labor Standards Act** published by US Department of Labor. Post on all projects.
7. WHD 1420 – **Employee Rights and Responsibilities Under The Family And Medical Leave Act** published by US Department of Labor. Post on all projects.
8. WHD 1462 – **Employee Polygraph Protection Act** published by US Department of Labor. Post on all projects.
9. F416-081-909 – **Job Safety and Health Law** published by Washington State Department of Labor and Industries. Post on all projects.
10. F242-191-909 – **Notice To Employees** published by Washington State Department of Labor and Industries. Post on all projects.
11. F700-074-909 – **Your Rights as a Worker in Washington State** by Washington State Department of Labor and Industries (L&I). Post on all projects.

12. EMS 9874 – **Unemployment Benefits** published by Washington State Employment Security Department. Post on all projects.
13. Post one copy of the approved "Statement of Intent to Pay Prevailing Wages" for the Contractor, each Subcontractor, each lower tier subcontractor, and any other firm (Supplier, Manufacturer, or Fabricator) that falls under the provisions of RCW 39.12 because of the definition of "Contractor" in WAC 296-127-010.
14. Post one copy of the prevailing wage rates for the project.

1-07.9(3) Apprentices

If employing apprentices, the Contractor shall submit to the Engineer written evidence showing:

1. Each apprentice is enrolled in a program approved by the Washington State Apprenticeship and Training Council;
2. The progression schedule for each apprentice; and
3. The established apprentice-journey level ratios and wage rates in the project locality upon which the Contractor will base such ratios and rates under the Contract.
   Any worker for whom an apprenticeship agreement has not been registered and approved by the Washington State Apprenticeship and Training Council shall be paid at the prevailing hourly journey level rate as provided in RCW 39.12.021.

1-07.9(4) Disputes

If labor and management cannot agree in a dispute over the proper prevailing wage rates, the Contractor shall refer the matter to the Director of State L&I (or to the U.S. Secretary of Labor when that agency sets the rates). The Director's (or Secretary's) decision shall be final, conclusive, and binding on all parties.

1-07.9(5) Required Documents

1-07.9(5)A General

All Statements of Intent to Pay Prevailing Wages, Affidavits of Wages Paid and Certified Payrolls shall be submitted to the Engineer using the L&I online Prevailing Wage Intent & Affidavit (PWIA) system.

1-07.9(5)B Intents and Affidavit

On forms provided by the Industrial Statistician of the Washington State Department of Labor and Industries (State L&I), the Contractor shall submit to the Engineer the following for themselves and for each firm covered under RCW 39.12 that will or has provided Work and materials for the Contract:

1. The approved "Statement of Intent to Pay Prevailing Wages" State L&I's form number F700-029-000. The Contracting Agency will make no payment under this Contract for the Work performed until this statement has been approved by State L&I and reviewed by the Engineer.

2. The approved "Affidavit of Prevailing Wages Paid", State L&I's form number F700-007-000. The Contracting Agency will not grant Completion until all approved Affidavit of Wages paid for the Contractor and all Subcontractors have been received by the Engineer. The Contracting Agency will not release to the Contractor any funds retained under RCW 60.28.011 until all of the "Affidavit of Prevailing Wages Paid" forms have been approved by State L&I and all of the approved forms have been submitted to the Engineer for every firm that worked on the Contract.

The Contractor is responsible for requesting these forms from State L&I and for paying any approval fees required by State L&I.

1-07.9(5)C Certified Payrolls

Certified payrolls are required to be submitted by the Contractor for themselves, all Subcontractors and all lower tier subcontractors. The payrolls shall be submitted weekly on all Federal-aid projects and no less than monthly on State funded projects.

1-07.9(5)D Penalties for Noncompliance

The Contractor is advised, if these payrolls are not supplied within the prescribed deadlines, any or all payments may be withheld until compliance is achieved. In addition, failure to provide these payrolls may result in other sanctions as provided by State laws (RCW 39.12.050) and/or Federal regulations (29 CFR 5.12).

1-07.9(6) Audits

The Contracting Agency may inspect or audit the Contractor's wage and payroll records as provided in Section 1-09.12.

1-07.10 Worker's Benefits

The Contractor shall make all payments required for unemployment compensation under Title 50 RCW and for industrial insurance and medical aid required under Title 51 RCW. If any payment required by Title 50 or Title 51 is not made when due, the Contracting Agency may retain such payments from any money due the Contractor and pay the same into the appropriate fund. Such payment will be made only after giving the Contractor 15 days prior written notice of the Contracting Agency's intent to disburse the funds to the Washington State Department of Labor and Industries or Washington State Employment Security Department as applicable. The payment will be made upon expiration of the 15 calendar day period if no legal action has been commenced to resolve the validity of the claim. If legal action is instituted to determine the validity of the claim prior to the expiration of the 15-day period, the Contracting Agency will hold the funds until determination of the action or written settlement agreement of the appropriate parties.

For Work on or adjacent to water, the Contractor shall make the determination as to whether workers are to be covered under the Longshoremen's and Harbor Worker's Compensation Act administered by the U.S. Department of Labor, or the State Industrial Insurance coverage administered by the Washington State Department of Labor and Industries.

The Contractor shall include in the various items in the Bid Proposal all costs for payment of unemployment compensation and for providing either or both of the insurance coverages. The Contractor will not be entitled to any additional payment for: (1) failure to include such costs, or (2) determinations made by the U.S. Department of Labor or the Washington State Department of Labor and Industries regarding the insurance coverage.

The Public Works Contract Division of the Washington State Department of Labor and Industries will provide the Contractor with applicable industrial insurance and medical aid classification and premium rates. After receipt of a *Revenue Release* from the Washington State Department of Revenue, the Contracting Agency will verify through the Department of Labor and Industries that the Contractor is current with respect to the payments of industrial insurance and medical aid premiums.

1-07.11 Requirements for Nondiscrimination

1-07.11(1) General Application

Discrimination in all phases of contracted employment, contracting activities and training is prohibited by Title VI of the Civil Rights Act of 1964, Section 162(a) of the Federal-Aid Highway Act of 1973, Section 504 of the Rehabilitation Act of 1973, the Age Discrimination Act of 1975, the Justice System Improvement Act of 1979, the American with Disabilities Act of 1990, the Civil Rights Restoration Act of 1987, 49 CFR Part 21, RCW 49.60 and other related laws and statutes. The referenced legal citations establish the minimum requirements for affirmative action efforts and define the basic nondiscrimination provisions as required by this section of these *Standard Specifications*.

1-07.11(2) Contractual Requirements

1. The Contractor shall maintain a Work site that is free of harassment, humiliation, fear, hostility and intimidation at all times. Behaviors that violate this requirement include but are not limited to:
    a. Persistent conduct that is offensive and unwelcome.
    b. Conduct that is considered to be hazing.
    c. Jokes about race, gender, or sexuality that are offensive.
    d. Unwelcome, unwanted, rude or offensive conduct or advances of a sexual nature which interferes with a person's ability to perform their job or creates an intimidating, hostile, or offensive work environment.
    e. Language or conduct that is offensive, threatening, intimidating or hostile based on race, gender, or sexual orientation.
    f. Repeating rumors about individuals in the Work Site that are considered to be harassing or harmful to the individual's reputation.
2. The Contractor shall not discriminate against any employee or applicant for contracted employment because of race, religion, color, national origin, sex, age, marital status, or the presence of any physical, sensory or mental disability.

3. The Contractor shall, in all solicitations or advertisements for employees, state that all qualified applicants will be considered for employment, without regard to race, religion, color, national origin, sex, age, marital status, or the presence of any physical, sensory, or mental disability.

4. The Contractor shall insert the following notification in all solicitations for bids for Work or material subject to federal laws and regulations and made in connection with all program and activities and, in adapted form in all proposals for negotiated agreements:

   The Contractor in accordance to Title VI of the Civil Rights Act of 1964, 78 Stat.252, 42 U.S. Code 2000d to 2000d-4, and Title 49 Code of Federal Regulations, Part 21, hereby notifies all bidders that it will affirmatively ensure that in any contract entered into pursuant to this advertisement, minority business enterprises will be afforded full opportunity to submit bids in response to this invitation and will not be discriminated against on the grounds of race, color national origin and sex in consideration for an award.

5. The Contractor shall make decisions with regard to selection and retention of subcontractors, procurement of materials and equipment and similar actions related to the Contract without regard to race, religion, color, national origin, sex, age, marital status, or the presence of any physical, sensory, or mental disability.

6. The Contractor shall send to each labor union, employment agency, or representative of workers with which the Contractor has a collective bargaining agreement or other contract or understanding, a notice advising the labor union, employment agency or worker's representative, of the Contractor's commitments under this Contract with regard to nondiscrimination.

7. The Contractor shall permit access to its books, records and accounts by the Contracting Agency for the purpose of investigating to ascertain compliance with these Specifications. In the event that information required of a Contractor is in the possession of another who fails or refuses to furnish this information, the Contractor shall describe, in writing, what efforts were made to obtain the information.

8. The Contractor shall maintain records with the name and address of each minority/female worker referred to the Contractor and what action was taken with respect to the referred worker.

9. The Contractor shall notify the Contracting Agency whenever the union with which the Contractor has a collective bargaining agreement has impeded the Contractor's efforts to effect minority/female workforce utilization. This being the case, the Contractor shall show what relief they have sought under such collective bargaining agreements.

10. The Contractor is encouraged to participate in Contracting Agency and Washington State Human Rights Commission approved program(s) designed to train craft-workers for the construction trades.

1-07.11(2)A Equal Employment Opportunity (EEO) Responsibilities

Title VI Responsibilities

During the performance of this Contract, the Contractor, for itself, its assignees and successors in interest (hereinafter referred to as the "Contractor") agrees as follows:

1. **Compliance With Regulations** – The Contractor shall comply with the Regulations relative to nondiscrimination in federally assisted programs of the Department of Transportation (hereinafter DOT), Title 49, Code of Federal Regulations, part 21, as they may be amended from time to time, (hereinafter referred to as the Regulations), which are herein incorporated by reference and made a part of this Contract.

2. **Nondiscrimination** – The Contractor, with regard to the Work performed by it during the Contract, shall not discriminate on the grounds of race, color, sex, or national origin in the selection and retention of Subcontractors, including procurement of materials and leases of equipment. The Contractor shall not participate either directly or indirectly in the discrimination prohibited by Section 21.5 of the Regulations, including employment practices when the Contract covers a program set forth in Appendix B of the Regulations.

3. **Solicitations for Subcontracts, Including Procurement of Materials and Equipment** – In all solicitations either by competitive bidding or negotiations made by the Contractor for Work to be performed under a subcontract, including procurement of materials or leases of equipment, each potential Subcontractor or supplier shall be notified by the Contractor of the Contractor's obligations under this Contract and the Regulations relative to nondiscrimination on the ground of race, color, sex, or national origin.

4. **Information and Reports** – The Contractor shall provide all information and reports required by the Regulations or directives issued pursuant thereto, and shall permit access to its books, records, accounts, other sources of information, and its facilities as may be determined by the Washington State Department of Transportation or the Federal Highway Administration to be pertinent to ascertain compliance with such Regulations, orders and instructions. Where any information required of a Contractor is in the exclusive possession of another who fails or refuses to furnish this information, the Contractor shall so certify to the Washington State Department of Transportation, or the Federal Highway Administration as appropriate, and shall set forth what efforts it has made to obtain the information.

5. **Sanctions for Noncompliance** – In the event of the Contractor's noncompliance with the nondiscrimination provisions of this Contract, the Washington State Department of Transportation shall impose such Contract sanctions as it or the Federal Highway Administration may determine to be appropriate, including, but not limited to:

    a. Withholding of payments to the Contractor under the Contract until the Contractor complies, and/or;

    b. Cancellation, termination, or suspension of the Contract, in whole or in part.

6. **Incorporation of Provisions** – The Contractor shall include the provisions of paragraphs (1) through (5) in every subcontract, including procurement of materials and leases of equipment, unless exempt by the Regulations, or directives issued pursuant thereto. The Contractor shall take such action with respect to any Subcontractor or procurement as the Washington State Department of Transportation or the Federal Highway Administration may direct as a means of enforcing such provisions including sanctions for noncompliance.

   Provided, however, that in the event a Contractor becomes involved in, or is threatened with, litigation with a Subcontractor or supplier as a result of such direction, the Contractor may request the Washington State Department of Transportation enter into such litigation to protect the interests of the state and, in addition, the Contractor may request the United States to enter into such litigation to protect the interests of the United States.

1-07.11(3) Equal Employment Opportunity Officer

The Contractor shall officially designate and make known to the Engineer during the preconstruction conference and discussions the firm's Equal Employment Opportunity Officer (hereinafter referred to as the EEO Officer). The EEO Officer will also be responsible for making him/herself known to each of the Contractor's employees. The EEO Officer must possess the responsibility, authority, and capability for administering and promoting an active and effective Contractor program of equal employment opportunity.

1-07.11(4) Dissemination of Policy

1-07.11(4)A Supervisory Personnel

All members of the Contractor's staff who are authorized to hire, supervise, promote, and discharge employees, or who recommend such action, or who are substantially involved in such action, shall be made fully cognizant of, and shall implement the Contractor's equal employment opportunity policy and contractual responsibilities to provide equal employment opportunity in each grade and classification of employment. To ensure that the above agreement will be met, the following actions shall be taken as a minimum:

1. **EEO Meetings** – Periodic meetings of supervisory and personnel office employees shall be conducted before the start of Work and then not less often than once every 6 months, at which time the Contractor's equal employment opportunity policy and its implementation shall be reviewed and explained. The meetings shall be conducted by the EEO Officer or other knowledgeable company official.

2. **EEO Indoctrination** – All new supervisory or personnel office employees shall be given a thorough indoctrination by the EEO Officer or other knowledgeable company official covering all major aspects of the Contractor's equal employment opportunity obligations within 30 days following their reporting for duty with the Contractor.

3. **Internal EEO Procedures** – All personnel who are engaged in direct recruitment for the project shall be instructed by the EEO Officer or appropriate company official in the Contractor's procedures for locating and hiring minority group and female employees.

1-07.11(4)B Employees, Applicants, and Potential Employees

In order to make the Contractor's equal employment opportunity policy known to all employees, prospective employees, and potential sources of employees, e.g., schools, employment agencies, labor unions (where appropriate), college placement officers, and community organizations, the Contractor shall take the following actions:

1. **Notices and Posters** – Notices and posters setting forth the Contractor's equal employment opportunity policy shall be placed in areas readily accessible to employees, applicants for employment, and potential employees.
2. **EEO Indoctrination** – The Contractor's equal employment opportunity policy and the procedures to implement such policy shall be brought to the attention of employees by means of meetings, employee handbooks, or other appropriate means.

1-07.11(5) Sanctions

In the event of the Contractor is found in noncompliance with the provisions of Section 1-07.11, the Contracting Agency may impose such Contract sanctions as it or the Federal Highway Administration may determine necessary to gain compliance including, but not limited to:

1. Progress payment requests may not be honored until the noncompliance is remedied to the satisfaction of the Contracting Agency.
2. The Contract may be suspended, in whole or in part, until such time as the Contractor is determined to be in compliance by the Contracting Agency.
3. The Contractor's pre-qualification may be suspended or revoked pursuant to WAC 468-16. The Contracting Agency may refer the matter to the Federal Highway Administration (FHWA) for possible federal sanctions.
4. The Contract may be terminated.

Immediately upon the Engineer's request, the Contractor shall remove from the Work site any employee engaging in behaviors that promote harassment, humiliation, fear or intimidation including but not limited to those described in these specifications.

1-07.11(6) Incorporation of Provisions

The Contractor shall include the provisions of Section 1-07.11(2) Contractual Requirements (1) through (5) and the Section 1-07.11(5) Sanctions in every subcontract including procurement of materials and leases of equipment. The Contractor shall take such action or enforce sanctions with respect to a Subcontractor or supplier as the Contracting Agency or the FHWA may direct as a means of enforcing such provisions. In the event a Contractor becomes involved in litigation with a Subcontractor or supplier as a result of such direction, the Contractor may request the Contracting Agency enter into such litigation to protect their interests and the Contracting Agency may request the federal government to enter into such litigation to protect the interests of the United States.

1-07.11(7) Vacant

1-07.11(8) Vacant

1-07.11(9) Subcontracting, Procurement of Materials, and Leasing of Equipment

Nondiscrimination – The Contractor shall not discriminate on the grounds of race, color, religion, sex, national origin, age, or disability in the selection and retention of Subcontractors, including procurement of materials and leases of equipment.

Solicitation and Utilization – The Contractor shall use their best effort to solicit bids from, and to utilize, disadvantaged, minority, and women Subcontractors, or Subcontractors with meaningful minority and women representation among their employees.

Subcontractor EEO Obligations – The Contractor shall notify all potential Subcontractors and suppliers of the EEO obligations required by the Contract. The Contractor shall use their efforts to ensure Subcontractors compliance with their equal employment opportunity obligations.

1-07.11(10) Records and Reports

1-07.11(10)A General

The Contractor shall keep such records as are necessary to determine compliance with the Contractor's equal employment opportunity obligations. The records kept by the Contractor shall be designated to indicate:

1. **Work Force Data** – The number of minority and nonminority group members and women employed in each work classification on the project.
2. **Good Faith Efforts – Unions** – The progress and efforts being made in cooperation with unions to increase employment opportunities for minorities and women (applicable only to contractors who rely in whole or in part on unions as a source of their work force).

3. **Good Faith Efforts – Recruitment** – The progress and efforts being made in locating, hiring, training, qualifying, and upgrading minority and female employees.
4. **Subcontracting** – The progress and efforts being made in securing the services of disadvantaged, minority, and women Subcontractors or Subcontractors with meaningful minority and female representation among their employees.

1-07.11(10)B Required Records and Retention

All records must be retained by the Contractor for a period of three years following acceptance of the Contract Work. All records shall be available at reasonable times and places for inspection by authorized representatives of either the Washington State Department of Transportation or the Federal Highway Administration.

Federal-Aid Highway Construction Contractors Annual EEO Report

FHWA #1391 – This form is required for all federally assisted projects provided the Contract is equal to or greater than $10,000 and for every associated subcontract equal to or greater than $10,000. Each Contract requires separate reports filed for the Contractor and each Subcontractor (subject to the above noted criteria). These forms are due by August 25th in every year during which Work was performed in July. The payroll period to be reflected in the report is the last payroll period in July in which Work was performed. This report is required of each Contractor and Subcontractor for each federally assisted Contract on which the Contractor or Subcontractor performs Work during the month of July.

Monthly Employment Utilization Reports

WSDOT Form 820-010 – This form (or substitute form as approved by the Contracting Agency) is required for all federally assisted projects if the Contract is equal to or greater then $10,000 and for every associated subcontract equal to or greater than $10,000. These monthly reports are to be maintained in the respective Contractor or Subcontractor's records.

1-07.12 Federal Agency Inspection

Federal laws, rules, and regulations shall be observed by the Contractor on Federal-aid projects. This Work is subject to inspection by the appropriate Federal agency. The Contractor shall cooperate with the Federal agencies in these inspections. These inspections shall not make the Federal Government a party to the Contract and shall not constitute an interference with the rights of the Contracting Agency or the Contractor.

1-07.13 Contractor's Responsibility for Work

1-07.13(1) General

All Work and material for the Contract, including any change order Work, shall be at the sole risk of the Contractor until the entire improvement has been completed as determined by the Engineer, except as provided in this section.

The Contractor shall rebuild, repair, restore, and make good all damages to any portion of the permanent or temporary Work occurring before the Physical Completion Date and shall bear all the expense to do so, except damage to the permanent Work caused by: (a) acts of God, such as earthquake, floods, or other cataclysmic phenomenon of nature, or (b) acts of the public enemy or of governmental authorities; or (c) slides in cases where Section 2-03.3(11) is applicable; Provided, however, that these exceptions shall not apply should damages result from the Contractor's failure to take reasonable precautions or to exercise sound engineering and construction practices in conducting the Work.

If the performance of the Work is delayed as a result of damage by others, an extension of time will be evaluated in accordance with Section 1-08.8.

Nothing contained in this section shall be construed as relieving the Contractor of responsibility for, or damage resulting from, the Contractor's operations or negligence, nor shall the Contractor be relieved from full responsibility for making good any defective Work or materials as provided for under Section 1-05.

1-07.13(2) Relief of Responsibility for Completed Work

Upon written request, the Contractor may be relieved of the duty of maintaining and protecting certain portions of the Work, as described below, which have been completed in all respects in accordance with the requirements of the Contract. If the Engineer provides written approval, the Contractor will be relieved of the responsibility for damage to said completed portions of the Work resulting from use by public traffic or from the action of the elements or from any other cause, but not from damage resulting from the Contractor's operations or negligence.

Portions of the Work for which the Contractor may be relieved of the duty of maintenance and protection as provided in the above paragraph include but are not limited to the following:

1. The completion of ¼ mile of Roadway or ¼ mile of one Roadway of a divided Highway or a frontage road including the Traveled Way, Shoulders, drainage control facilities, planned Roadway protection Work, lighting, and any required traffic control and access facilities.
2. A bridge or other Structure of major importance.
3. A complete unit of a traffic control signal system or of a Highway lighting system.
4. A complete unit of permanent Highway protection Work.

5. A building that is functionally complete and open to the public.
6. Any Contract Proposal item.

1-07.13(3) Relief of Responsibility for Damage by Public Traffic

When it is necessary for public traffic to utilize a Highway facility during construction, the Contractor will be relieved of responsibility for damages to permanent Work by public traffic under the following circumstances:

1. The Work is in accordance with the Contract Plans or approved stage construction plans,
2. The Work is on a section of Roadway required by the Contract to be opened to public traffic, and
3. The traffic control is in accordance with the approved traffic control plans.

If traffic is relocated to another section of Roadway, the Contractor shall resume responsibility for the Work until such time as the section of Roadway is again open to public traffic or the Contractor submits a written request for Work that is completed to a point where relief can be granted in accordance with Section 1-07.13(2).

1-07.13(4) Repair of Damage

The Contractor shall promptly repair all damage to either temporary or permanent Work as ordered by the Engineer. For damage qualifying for relief under Sections 1-07.13(1), 1-07.13(2), 1-07.13(3), or 8-17.5, payment will be made in accordance with Section 1-09.4, using the estimated Bid item "Reimbursement for Third Party Damage".

In the event the Contracting Agency pays for damage to the Contractor's Work or for damage to the Contractor's equipment caused by third parties, any claim the Contractor had or may have had against the third party shall be deemed assigned to the Contracting Agency, to the extent of the Contracting Agency's payment for such damage.

Payment will be limited to repair of damaged Work only. No payment will be made for delay or disruption of Work.

For the purpose of providing a common Proposal for all Bidders, the Contracting Agency has entered an amount for "Reimbursement for Third Party Damage" in the Proposal to become a part of the total Bid by the Contractor.

1-07.14 Responsibility for Damage

The State, Governor, Commission, Secretary, and all officers and employees of the State, including but not limited to those of the Department, will not be responsible in any manner: for any loss or damage that may happen to the Work or any part; for any loss of material or damage to any of the materials or other things used or employed in the performance of Work; for injury to or death of any persons, either workers or the public; or for damage to the public for any cause which might have been prevented by the Contractor, or the workers, or anyone employed by the Contractor.

The Contractor shall be responsible for any liability imposed by law for injuries to, or the death of, any persons or damages to property resulting from any cause whatsoever during the performance of the Work, or before final acceptance.

Subject to the limitations in this section, and RCW 4.24.115, the Contractor shall indemnify, defend, and save harmless the State, Governor, Commission, Secretary, and all officers and employees of the State from all claims, suits, or actions brought for injuries to, or death of, any persons or damages resulting from construction of the Work or in consequence of any negligence or breach of Contract regarding the Work, the use of any improper materials in the Work, caused in whole or in part by any act or omission by the Contractor or the agents or employees of the Contractor during performance or at any time before final acceptance. In addition to any remedy authorized by law, the State may retain so much of the money due the Contractor as deemed necessary by the Engineer to ensure the defense and indemnification obligations of this section until disposition has been made of such suits or claims.

Subject to the limitations in this section and RCW 4.24.115, the Contractor shall indemnify, defend, and save harmless any county, city, or region, its officers, and employees connected with the Work, within the limits of which county, city, or region the Work is being performed, all in the same manner and to the same extent as provided above for the protection of the State, its officers and employees, provided that no retention of money due the Contractor be made by the State except as provided in RCW 60.28, pending disposition of suits or claims for damages brought against the county, city, or district.

Pursuant to RCW 4.24.115, if such claims, suits, or actions result from the concurrent negligence of (a) the indemnitee or the indemnitee's agents or employees and (b) the Contractor or the Contractor's agent or employees, the indemnity provisions provided in the preceding paragraphs of this section shall be valid and enforceable only to the extent of the Contractor's negligence or the negligence of its agents and employees.

The Contractor shall bear sole responsibility for damage to completed portions of the project and to property located off the project caused by erosion, siltation, runoff, or other related items during the construction of the project. The Contractor shall also bear sole responsibility for any pollution of rivers, streams, ground water, or other waters that may occur as a result of construction operations.

The Contractor shall exercise all necessary precautions throughout the life of the Project to prevent pollution, erosion, siltation, and damage to property.

The Contracting Agency will forward to the Contractor all claims filed against the State according to RCW 4.92.100 that are deemed to have arisen in relation to the Contractor's Work or activities under this Contract, and, in the opinion of the Contracting Agency, are subject to the defense, indemnity, and insurance provisions of these *Standard Specifications*. Claims will be deemed tendered to the Contractor and insurer, who has named the State as a named insured or an additional insured under the Contract's insurance provisions, once the claim has been forwarded via certified mail to the Contractor. The Contractor shall be responsible to provide a copy of the claim to the

Contractor's designated insurance agent who has obtained/met the Contract's insurance provision requirements.

Within 60 calendar days following the date a claim is sent by the Contracting Agency to the Contractor, the Contractor shall notify the Claimant and WSDOT (Risk Management Office, PO Box 47418, Olympia, WA 98504-7418) of the following:

a. Whether the claim is allowed or is denied in whole or in part, and, if so, the specific reasons for the denial of the individual claim, and if not denied in full, when payment has been or will be made to the claimant(s) for the portion of the claim that is allowed, or

b. If resolution negotiations are continuing. In this event, status updates will be reported no longer than every 60 calendar days until the claim is resolved or a lawsuit is filed.

If the Contractor fails to provide the above notification within 60 calendar days, then the Contractor shall yield to the Contracting Agency sole and exclusive discretion to allow all or part of the claim on behalf of the Contractor, and the **Contractor shall be deemed to have WAIVED any and all defenses, objections, or other avoidances to the Contracting Agency's allowance of the claim, or the amount allowed by the Contracting Agency**, under common law, constitution, statute, or the Contract and these *Standard Specifications*. If all or part of a claim is allowed, the Contracting Agency will notify the Contractor via certified mail that it has allowed all or part of the claim and make appropriate payments to the claimant(s) with State funds.

Payments of State funds by the Contracting Agency to claimant(s) under this section will be made on behalf of the Contractor and at the expense of the Contractor, and the Contractor shall be unconditionally obligated to reimburse the Contracting Agency for the "total reimbursement amount", which is the sum of the amount paid to the claimant(s), plus all costs incurred by the Contracting Agency in evaluating the circumstances surrounding the claim, the allowance of the claim, the amount due to the claimant, and all other direct costs for the Contracting Agency's administration and payment of the claim on the Contractor's behalf. The Contracting Agency will be authorized to withhold the total reimbursement amount from amounts due the Contractor, or, if no further payments are to be made to the Contractor under the Contract, the Contractor shall directly reimburse the Contracting Agency for the amounts paid within 30 days of the date notice that the claim was allowed was sent to the Contractor. In the event reimbursement from the Contractor is not received by the Contracting Agency within 30 days, interest shall accrue on the total reimbursement amount owing at the rate of 12 percent per annum calculated at a daily rate from the date the Contractor was notified that the claim was allowed. The Contracting Agency's costs to enforce recovery of these amounts are additive to the amounts owing.

The Contractor specifically assumes all potential liability for actions brought by employees of the Contractor and, solely for the purpose of enforcing the defense and indemnification obligations set forth in Section 1-07.14, the Contractor specifically waives any immunity granted under the State industrial insurance law, Title 51 RCW. This waiver has been mutually negotiated by the parties. The Contractor shall similarly require that each

Subcontractor it retains in connection with the project comply with the terms of this paragraph, waive any immunity granted under Title 51 RCW, and assume all liability for actions brought by employees of the Subcontractor.

1-07.15 Temporary Water Pollution Prevention

1-07.15(1) Spill Prevention, Control, and Countermeasures Plan

The Contractor shall prepare a Type 2 Working Drawing consisting of a project-specific spill prevention, control, and countermeasures plan (SPCC Plan), and shall implement the plan for the duration of the project. No on-site construction activities may commence until the Contracting Agency accepts an SPCC Plan for the project. An SPCC Plan template and guidance information is available at www.wsdot.wa.gov/environment/technical/disciplines/hazardous-materials/spill-prevent-report.

The SPCC Plan shall address all fuels, petroleum products, hazardous materials, and other materials defined in Chapter 447 of the WSDOT *Environmental Manual* M 31-11. Occupational safety and health requirements that may pertain to SPCC Plan implementation are contained in, but not limited to, WAC 296-824 and WAC 296-843. The SPCC Plan shall address conditions that may be required by Section 3406 of the current International Fire Code, or as approved by the local Fire Marshal.

Implementation Requirements

The Contractor shall update the SPCC Plan throughout project construction so that the written plan reflects actual site conditions and practices. The Contractor shall update the SPCC Plan at least annually and maintain a copy of the updated SPCC Plan on the project site. The Contractor shall fully implement the SPCC Plan, as accepted and updated, at all times.

SPCC Plan Element Requirements

The SPCC Plan shall set forth the following information in the following order:

1. **Responsible Personnel** – Identify the names, titles, and contact information for the personnel responsible for implementing and updating the plan and for responding to spills.
2. **Spill Reporting –** List the names and telephone numbers of the Federal, State, and local agencies the Contractor shall notify in the event of a spill.
3. **Project and Site Information** – Describe the following items:
    a. The project Work.
    b. The site location and boundaries.
    c. The drainage pathways from the site.
    d. Nearby waterways and sensitive areas and their distances from the site.

4. **Potential Spill Sources** – Describe each of the following for all potentially hazardous materials brought or generated on-site including but not limited to materials used for equipment operation, refueling, maintenance, or cleaning:

    a. Name of material and its intended use.

    b. Estimated maximum amount on-site at any one time.

    c. Location(s) (including any equipment used below the ordinary high water line) where the material will be staged, used, and stored and the distance(s) from nearby waterways and sensitive areas.

5. **Preexisting Contamination** – Describe any preexisting contamination and contaminant sources (such as buried pipes or tanks) in the project area that are described in the Contract provisions and Plans. Identify equipment and Work practices that shall be used to prevent the release of contamination.

6. **Spill Prevention and Response Training** – Describe how and when all project personnel, including refueling personnel and other Subcontractors, shall be trained in spill prevention, containment, and response and in the location of spill response kits.

7. **Spill Prevention** – Describe the following items:

    a. The contents and locations of spill response kits that the Contractor shall supply and maintain that are appropriately stocked, located in close proximity to hazardous materials and equipment, and immediately accessible.

    b. Security measures for potential spill sources to prevent accidental spills and vandalism.

    c. Methods used to prevent stormwater from contacting hazardous materials.

    d. Secondary containment for each potential spill source listed in 4, above. Secondary containment structures shall be in accordance with Section S9.D.9 of Ecology's Construction Stormwater General NPDES Permit, where secondary containment means placing tanks or containers within an impervious structure capable of containing 110 percent of the volume contained in the largest tank within the containment structure. Double-walled tanks do not require additional secondary containment.

    e. BMP methods and locations where they are used to prevent discharges to ground or water during mixing and transfer of hazardous materials and fuel. Methods to control pollutants shall use BMPs in accordance with Ecology's Construction Stormwater General NPDES Permit. BMP guidance is provided in Ecology's Stormwater Management Manuals, such as Volume II – Construction Stormwater Pollution Prevention, BMP C153, and Volume IV – Source Control BMPs.

    f. Refueling procedures for equipment that cannot be moved from below the ordinary high water line.

    g. Daily inspection and cleanup procedures that ensure all equipment used below the ordinary high water line is free of all external petroleum-based products.

h. Routine equipment, storage area, and structure inspection and maintenance practices to prevent drips, leaks, or failures of hoses, valves, fittings, containers, pumps, or other systems that contain or transfer hazardous materials.

i. Site inspection procedures and frequency.

8. **Spill Response** – Outline the response procedures the Contractor shall follow for each scenario listed below, indicating that if hazardous materials are encountered or spilled during construction, the Contractor shall do everything possible to control and contain the material until appropriate measures can be taken. Include a description of the actions the Contractor shall take and the specific on-site spill response equipment that shall be used to assess the spill, secure the area, contain and eliminate the spill source, clean up spilled material, decontaminate equipment, and dispose of spilled and contaminated material:

   a. A spill of each type of hazardous material at each location identified in 4, above.

   b. Stormwater that has come into contact with hazardous materials.

   c. A release or spill of any preexisting contamination and contaminant source described in 5, above.

   d. A release or spill of any unknown preexisting contamination and contaminant sources (such as buried pipes or tanks) encountered during project Work.

   e. A spill occurring during Work with equipment used below the ordinary high water line.

   If the Contractor will use a Subcontractor for spill response, provide contact information for the Subcontractor under item 1 (above), identify when the Subcontractor shall be used, and describe actions the Contractor shall take while waiting for the Subcontractor to respond.

9. **Project Site Map** – Provide a map showing the following items:

   a. Site location and boundaries.

   b. Site access roads.

   c. Drainage pathways from the site.

   d. Nearby waterways and sensitive areas.

   e. Hazardous materials, equipment, and decontamination areas identified in 4, above.

   f. Preexisting contamination or contaminant sources described in 5, above.

   g. Spill prevention and response equipment described in 7 and 8, above.

10. **Spill Report Forms** – Provide a copy of the spill report form(s) that the Contractor shall use in the event of a release or spill.

Payment

Payment will be made for the following Bid item when it is included in the Proposal:

"SPCC Plan", lump sum.

When the written SPCC Plan is accepted by the Contracting Agency, the Contractor shall receive 50 percent of the lump sum Contract price for the plan.

The remaining 50 percent of the lump sum price will be paid after the materials and equipment called for in the plan are mobilized to the project.

The lump sum payment for the "SPCC Plan" shall be full pay for all costs associated with creating and updating the accepted SPCC Plan, and all costs associated with the set up of prevention measures and for implementing the current SPCC Plan as required by this Specification.

1-07.16 Protection and Restoration of Property

1-07.16(1) Private/Public Property

The Contractor shall not use Contracting Agency owned or controlled property other than that directly affected by the Contract Work without the approval of the Engineer. If the Engineer grants such approval, the Contractor shall then vacate the area when ordered to do so by the Engineer. Approval to temporarily use the property shall not create any entitlement to further use or to compensation for any conditions or requirements imposed.

The Contractor shall protect private or public property on or in the vicinity of the Work site. The Contractor shall ensure that it is not removed, damaged, destroyed, or prevented from being used unless the Contract so specifies.

Property includes land, utilities, trees, landscaping, improvements legally on the right of way, markers, monuments, buildings, Structures, pipe, conduit, sewer or water lines, signs, and other property of all description whether shown on the Plans or not.

If the Engineer orders, or if otherwise necessary, the Contractor shall install protection, acceptable to the Engineer, for property such as that listed in the previous paragraph. The Contractor is responsible for locating and protecting all property that is subject to damage by the construction operation.

If the Contractor (or agents/employees of the Contractor) damage, destroy, or interfere with the use of such property, the Contractor shall restore it to original condition. The Contractor shall also halt any interference with the property's use. If the Contractor refuses or does not respond immediately, the Engineer may have such property restored by other means and subtract the cost from money that will be or is due the Contractor.

The Contractor may access the worksite from adjacent properties. The Contractor shall not use or allow others to use this access to merge with public traffic. During non-working hours, the Contractor shall provide a physical barrier that is either locked or physically unable to be moved without equipment. The access shall not go through any

existing Structures. The access may go through fencing. The Contractor shall control or prevent animals from entering the worksite to the same degree that they were controlled before the fence was removed. The Contractor shall prevent persons not involved in the Contract Work from entering the worksite through the access or through trails and pathways intersected by the access. If the Contract documents require that existing trails or pathways be maintained during construction, the Contractor will insure the safe passage of trail or pathway users. The Contractor shall effectively control airborne particulates that are generated by use of the access. The location and use of the access shall not adversely affect wetlands or sensitive areas in any manner. The Contractor shall be responsible for obtaining all haul road agreements, permits and/or easements associated with the access. The Contractor shall replace any fence, repair any damage and restore the site to its original state when the access is no longer needed. The Contractor shall bear all costs associated with this worksite access.

1-07.16(2) Vegetation Protection and Restoration

Existing vegetation, where shown in the Plans or designated by the Engineer, shall be saved and protected through the life of the Contract. The Engineer will designate the vegetation to be saved and protected by a site preservation line, high visibility fencing, or individual flagging.

Damage which may require replacement of vegetation includes torn bark stripping, broken branches, exposed root systems, cut root systems, poisoned root systems, compaction of surface soil and roots, puncture wounds, drastic reduction of surface roots or leaf canopy, changes in grade greater than 6 inches, or any other changes to the location that may jeopardize the survival or health of the vegetation to be preserved.

When large roots of trees designated to be saved are exposed by the Contractor's operation, they shall be wrapped with heavy, moist material, such as burlap or canvas, for protection and to prevent excessive drying. The material shall be kept moist and securely fastened until the roots are covered to finish grade. All material and fastening material shall be removed from the roots before covering. All roots 1 inch or larger in diameter, that are damaged, shall be pruned with a sharp saw or pruning shear. Damaged, torn, or ripped bark shall be removed as ordered by the Engineer at no additional cost to the Contracting Agency.

Any pruning activity required to complete the Work as specified shall be performed by a Certified Arborist at the direction of the Engineer.

If due to, or for any reason related to the Contractor's operation, any tree, shrub, ground cover or herbaceous vegetation designated to be saved is destroyed, disfigured, or damaged to the extent that continued life is questionable as determined by the Engineer, it shall be removed by the Contractor at the direction of the Engineer.

The Contractor will be assessed damages equal to triple the value of the vegetation as determined in the *Guide for Plant Appraisal*, Current Edition, published by the International Society of Arboriculture or the estimated cost of restoration with a similar species. Shrub, ground cover, and herbaceous plant values will be determined using the Cost of Cure

Method. Any damage so assessed will be deducted from the monies due or that may become due the Contractor.

1-07.16(2)A Wetland and Sensitive Area Protection

Existing wetland and other sensitive areas, where shown in the Plans or designated by the Engineer, shall be saved and protected through the life of the Contract. When applicable, a site preservation line has been established as a boundary between work zones and sensitive environmental areas.

The Contractor shall install high visibility fence as shown in the Plans or designated by the Engineer in accordance with Section 8-01.3(1). The areas to be protected include critical environmental areas, buffer zones, and other areas of vegetation to be preserved. The Contractor shall keep areas identified by the site preservation lines free of construction equipment, construction materials, debris, and runoff. No access, including, but not limited to, excavation, clearing, staging, or stockpiling, shall be performed inside the protected area.

1-07.16(3) Fences, Mailboxes, Incidentals

The Contractor shall maintain any temporary fencing to prevent pedestrians from entering the worksite and to preserve livestock, crops, or property when working through or adjacent to private property. The Contractor is liable for all damages resulting from not complying with this requirement.

The usefulness of existing mail or paper boxes shall not be impaired. If the Contract anticipates removing and reinstalling the mail or paper boxes, the provisions of Section 8-18 will apply. If the mail or paper boxes are rendered useless solely by acts (or inaction) of the Contractor or for the convenience of the Contractor, the Work shall be performed as provided in Section 8-18 at the Contractor's expense.

1-07.16(4) Archaeological and Historical Objects

Archaeological or historical objects, such as ruins, sites, buildings, artifacts, fossils, or other objects of antiquity that may have significance from a historical or scientific standpoint, which may be encountered by the Contractor, shall not be further disturbed. The Contractor shall immediately notify the Engineer of any such finds.

The Engineer will determine if the material is to be salvaged. The Contractor may be required to stop Work in the vicinity of the discovery until such determination is made. The Engineer may require the Contractor to suspend Work in the vicinity of the discovery until salvage is accomplished.

If the Engineer finds that the suspension of Work in the vicinity of the discovery increases or decreases the cost or time required for performance of any part of the Work under this Contract, the Engineer will make an adjustment in payment or the time required for the performance of the Work in accordance with Sections 1-04.4 and 1-08.8.

1-07.16(4)A Inadvertent Discovery of Human Skeletal Remains

If human skeletal remains are encountered by the Contractor, they shall not be further disturbed. The Contractor shall immediately notify the Engineer of any such finds, and shall cease all work adjacent to the discovery, in an area adequate to provide for the total security and protection of the integrity of the skeletal remains. The Engineer may require the Contractor to suspend Work in the vicinity of the discovery until final determinations are made and removal of the skeletal remains is completed.

If the Engineer finds that the suspension of Work in the vicinity of the discovery increases or decreases the cost or time required for performance of any part of the Work under this Contract, the Engineer will make an adjustment in payment or the time required for the performance of the Work in accordance with Sections 1-04.4 and 1-08.8.

1-07.16(5) Payment

All costs to comply with this section and for the protection and repair specified in this section, unless otherwise stated, are incidental to the Contract and are the responsibility of the Contractor. The Contractor shall include all related costs in the unit Bid prices of the Contract.

1-07.17 Utilities and Similar Facilities

The Contractor shall protect all private and public utilities from damage resulting from the Work. Among others, these utilities include: telephone, telegraph, and power lines; pipelines, sewer and water lines; railroad tracks and equipment; and highway lighting and signing systems, and intelligent transportation systems (ITS). All costs required to protect public and private utilities shall be at the Contractor's expense, except as provided otherwise in this section.

RCW 19.122 relates to underground utilities. In accordance with this RCW, the Contractor shall call the One-Number Locator Service for field location of utilities. If no locator service is available for the area, notice shall be provided individually to those owners of utilities known to, or suspected of, having underground facilities within the area of the proposed excavation.

1-07.17(1) Utility Construction, Removal, or Relocation by the Contractor

If the Work requires removing or relocating a utility, the Contract will assign the task to the Contractor or the utility owner. When the task is assigned to the Contractor it shall be performed in accordance with the Plans and Special Provisions. New utility construction shall be performed according to the appropriate Contract requirements.

To ease or streamline the Work for its own convenience, the Contractor may desire to ask utility owners to move, remove, or alter their equipment in ways other than those listed in the Plans or Special Provisions. The Contractor shall make the arrangements and pay all costs that arise from work performed by the utility owner at the Contractor's request. The Contractor shall submit a Type 2 Working Drawing consisting of plans and details describing the scope and schedule of all work performed at the Contractor's request by the utility owner.

In some cases, the Plans or Special Provisions may not show all underground facilities. If the Work requires these to be moved or protected, the Engineer will assign the task to others or issue a written change order requiring the Contractor to do so as provided in Section 1-04.4.

1-07.17(2) Utility Construction, Removal, or Relocation by Others

Any authorized agent of the Contracting Agency or utility owners may enter the Highway right of way to repair, rearrange, alter, or connect their equipment. The Contractor shall cooperate with such effort and shall avoid creating delays or hindrances to those doing the work. As needed, the Contractor shall arrange to coordinate work schedules.

If the Contract provides notice that utility work (including furnishing, adjusting, relocating, replacing, or constructing utilities) will be performed by others during the prosecution of the Work, the Special Provisions will establish the utility owner's anticipated completion. The Contractor shall carry out the Work in a way that will minimize interference and delay for all forces involved. Any costs incurred prior to the utility owners anticipated completion (or if no completion is specified, within a reasonable period of time) that results from the coordination and prosecution of the Work regarding utility adjustment, relocation, replacement, or construction shall be at the Contractor's expense as provided in Section 1-05.14.

When others delay the Work through late performance of utility work, the Contractor shall adhere to the requirements of Section 1-04.5.The Contracting Agency will either suspend Work according to Section 1-08.6, or order the Contractor to coordinate the Work with the work of the utility owner in accordance with Section 1-04.4. When ordered to coordinate the Work with the work of the utility owner, the Contractor shall prosecute the Work in a way that will minimize interference and delay for all forces involved.

1-07.18 Public Liability and Property Damage Insurance

The Contractor shall obtain and keep in force the following policies of insurance. The policies shall be with companies or through sources approved by the State Insurance Commissioner pursuant to RCW 48.05. Unless otherwise indicated below, the policies shall be kept in force from the execution date of the Contract until the date of acceptance by the Secretary (Section 1-05.12).

1. Owners and Contractors Protective (OCP) Insurance providing bodily injury and property damage liability coverage, with limits of $3,000,000 per occurrence and per project in the aggregate for each policy period, written on Insurance Services Office (ISO) form CG0009 1204, together with Washington State Department of Transportation amendatory endorsement CG 2908 1195, specifying the Contracting Agency, the State, the Governor, the Commission, the Secretary, the Department, and all officers and employees of the State as named insured. This policy shall be kept in force from the execution date of the Contract until the Physical Completion Date.

2. Commercial General Liability (CGL) Insurance written under ISO Form CG0001 or its equivalent, with minimum limits of $3,000,000 per occurrence and in the aggregate for each 1-year policy period. This coverage may be any combination of primary, umbrella, or excess liability coverage affording total liability limits of not less than $3,000,000 per occurrence and in the aggregate. Products and completed operations coverage shall be provided for a period of 3 years following Substantial Completion of the Work.

3. Commercial Automobile Liability Insurance providing bodily injury and property damage liability coverage for all owned and nonowned vehicles assigned to or used in the performance of the Work, with a combined single limit of not less than $1,000,000 per occurrence. This coverage may be any combination of primary, umbrella, or excess liability coverage affording total liability limits of not less than $1,000,000 per occurrence, with the State named as an additional insured or designated insured in connection with the Contractor's Performance of the Contract. If pollutants are to be transported, MCS 90 and CA 99 48 endorsements are required on the Commercial Automobile Liability insurance policy unless in-transit pollution risk is covered under a Pollution Liability insurance policy.

4. The Contractor shall be Named Insured and the Contracting Agency, the State, the Governor, the Commission, the Secretary, the Department, all officers and employees of the State, and their respective members, directors, officers, employees, agents, and consultants (collectively the "Additional Insureds") shall be included as Additional Insureds for all policies and coverages specified in this section, with the exception of the OCP policy. Said insurance coverage shall be primary and noncontributory insurance with respect to the insureds and the Additional Insureds. Any insurance or self-insurance beyond that specified in this Contract that is maintained by any Additional Insured shall be in excess of such insurance and shall not contribute with it. All insurance coverage required by this section shall be written and provided by "occurrence-based" policy forms rather than by "claims made" forms.

   All endorsements adding Additional Insureds to required policies shall be issued on (i) form CG 20 10 11 85 or a form deemed equivalent by the Contracting Agency, providing the Additional Insureds with all policies and coverages set forth in this section, with the exception of the OCP and Commercial Auto policies or (ii) form CA 20 48 or forms deemed equivalent by Contracting Agency, providing the Additional Insureds with all coverages required under the Commercial Automobile Liability.

5. The coverage limits to be provided by the Contractor for itself and to the Contracting Agency and Additional Insureds pursuant to this section or any Special Provision, shall be on a "per project" aggregate basis with the minimum limits of liability as set forth herein for both general liability and products/completed operations claims. The additional insured coverage required under this section for products/completed operations claims shall remain in full force and effect for not less than 3 years following Substantial Completion of the project. If the Contractor maintains, at any time, coverage limits for itself in excess of limits set forth in this Section 1-07.18 or any Special Provision, then those additional coverage limits shall also apply to the Contracting Agency and the Additional Insured. This includes, but is not limited to,

any coverage limits provided under any risk financing program of any description, whether such limits are primary, excess, contingent, or otherwise.

6. All insurance policies and coverages required under Sections 1-07.18 and 1-07.10 shall contain a waiver of subrogation against the Contracting Agency, the State, and any Additional Insureds, and their respective departments, agencies, boards, and commissions, and their respective officers, officials, agents, and employees for losses arising from Work performed by or on behalf of the Contractor. This waiver has been mutually negotiated by the parties.

7. Where applicable, the Contractor shall cause each Subcontractor to provide insurance that complies with all applicable requirements of the Contractor-provided insurance as set forth herein, in circumstances where the Subcontractor is not covered by the Contractor-provided insurance. The Contractor shall have sole responsibility for determining the limits of coverage required, if any, to be obtained by Subcontractors, which determination shall be made in accordance with reasonable and prudent business practices. In the event that a Subcontractor is required to add the Contractor as an Additional Insured pursuant to its contract for Work at the Project, then the Contractor shall also cause each Subcontractor to include the Contracting Agency and the Additional Insureds, as Additional Insureds as well, for primary and noncontributory limits of liability under each Subcontractor's Commercial General Liability, Commercial Automobile Liability, and any other coverages that may be required pursuant to a "Special Provision".

8. Unless specifically noted otherwise in the Contract Documents, the parties to this Contract do not intend by any of the provisions of this Contract to cause the public or any member thereof or any other Person to be a third-party beneficiary of the Contract Documents. Nothing in this Contract authorizes anyone not a party to this Contract or a designated third-party beneficiary to this Contract to maintain a suit for personal injuries or property damage pursuant to the terms or provisions of this Contract. It is the further intent of the Contracting Agency and the Contractor in executing the Form of Contract that no individual, firm, corporation, or any combination thereof that supplies materials, labor, services, or equipment to the Contractor for the performance of the Work shall become thereby a third-party beneficiary of this Contract.

   The Contract Documents shall not be construed to create a contractual relationship of any kind between the Contracting Agency and a Subcontractor or any other Person except the Contractor.

9. The Owners and Contractors Protective Insurance policy shall not be subject to a deductible or contain provisions for a deductible. The Commercial General Liability policy and the Commercial Automobile Liability Insurance policy may, at the discretion of the Contractor, contain such provisions. If a deductible applies to any claim under these policies, then payment of that deductible will be the responsibility of the Contractor, notwithstanding any claim of liability against the Contracting Agency. However, in no event shall any provision for a deductible provide for a deductible in excess of $50,000.00.

10. With the exception of the Commercial Automobile liability coverage, no policies of insurance required under this section shall contain an arbitration or alternative dispute resolution clause applicable to disputes between the insurer and its insureds. Any and all disputes concerning (i) terms and scope of insurance coverage afforded by the policies required hereunder and/or (ii) extra contractual remedies and relief, which may be afforded policy holders in connection with coverage disputes, shall be resolved in Washington Superior Court, applying Washington law.
11. Prior to Contract execution, the Contractor shall file with the Department of Transportation, Contract Payment Section, PO Box 47420, Olympia, WA 98504-7420, ACORD Form Certificates of Insurance evidencing the minimum insurance coverages required under these Specifications. Within 30 days of being awarded a Contract, the Contractor shall provide the Department with complete copies, which may be electronic copies, of all insurance policies required under this section and any Special Provisions.
12. The Contractor shall provide written notice to the Engineer of any policy cancellations and provide the Department of Transportation, Contract Payment Section, PO Box 47420, Olympia, WA 98504-7420, by U.S. Mail, notice of any policy cancellation within two business days of receipt of cancellation.
13. Failure on the part of the Contractor to maintain the insurance as required, or not to provide certification and copies of the insurance prior to the time specified in Subsection 11 above, shall constitute a material breach of Contract upon which the Contracting Agency may, after giving 5-business days notice to the Contractor to correct the breach, immediately terminate the Contract or, at its discretion, procure or renew such insurance and pay any and all premiums in connection therewith, with any sums so expended to be repaid to the Contracting Agency on demand, or at the sole discretion of the Contracting Agency, offset against funds due the Contractor from the Contracting Agency. All costs for insurance, including any payments of deductible amounts, shall be considered incidental to and included in the unit Contract prices and no additional payment will be made.

1-07.19 Gratuities

The Contractor shall not extend any loan, gratuity, or gift of money in any form whatsoever to any employee or officer of the Contracting Agency; nor will the Contractor rent or purchase any equipment or materials from any employee or officer of the Contracting Agency. Before payment of the final estimate will be made, the Contractor shall execute and furnish the Contracting Agency an affidavit certifying compliance with these provisions of the Contract.

The Contractor shall comply with all applicable sections of the State Ethics law, RCW 42.52, which regulates gifts to State officers and employees. Under that statute, any Contracting Agency officer or employee who has or will participate with the Contractor regarding any aspect of this Contract is prohibited from seeking or accepting any gift, gratuity, favor or anything of economic value from the Contractor. Accordingly, neither the Contractor nor any agent or representative shall offer anything of economic value as a gift, gratuity, or favor directly or indirectly to any such officer or employee.

1-07.20 Patented Devices, Materials, and Processes

The Contractor shall assume all costs arising from the use of patented devices, materials, or processes used on or incorporated in the Work, and agrees to indemnify, defend, and save harmless the State, Governor, Commission, Secretary, and their duly authorized agents and employees from all actions of any nature for, or on account of the use of any patented devices, materials, or processes.

1-07.21 Rock Drilling Safety Requirements

It shall be the Contractor's responsibility to maintain safe working conditions during rock drilling, by keeping dust concentration below the threshold limit value or by providing those protective devices that may be required by the State Department of Labor and Industries.

1-07.22 Use of Explosives

When using explosives, the Contractor shall use the utmost care to protect life and property, to prevent slides, and to leave undisturbed all materials, outside the neat lines of the cross-section.

Explosives shall be handled, marked, stored, and used in compliance with WAC 296-52 and such local laws, rules, and regulations that may apply. The stricter provisions shall apply.

All explosives shall be stored securely as required by all laws and ordinances that apply. Each storage place shall be clearly marked: "Dangerous-Explosives". No explosives shall be left unprotected.

If public utilities or railroads own equipment near the blast site, the Contractor shall notify the owners of the location, date, time, and approximate duration of the blasting. This notice shall be given sufficiently in advance to enable all owners to take any steps as they deem necessary to protect their property from injury.

Blasting near proposed Structures shall be completed before Work on them begins. When the use of explosives is necessary for the prosecution of the Work, the Contractor's insurance shall contain a special clause permitting the blasting.

1-07.23 Public Convenience and Safety

The Contractor shall be responsible for providing adequate safeguards, safety devices, protective equipment, and any other needed actions to protect the life, health, and safety of the public, and to protect property in connection with the performance of the Work covered by the Contract. The Contractor shall perform any measures or actions the Engineer may deem necessary to protect the public and property. The responsibility and expense to provide this protection shall be the Contractor's except that which is to be furnished by the Contracting Agency as specified in other sections of these Specifications. Nothing contained in this Contract is intended to create any third-party beneficiary rights in favor of the public or any individual utilizing the Highway facilities being constructed or improved under this Contract.

1-07.23(1) Construction Under Traffic

The Contractor shall conduct all operations with the least possible obstruction and inconvenience to the public. The Contractor shall have under construction no greater length or amount of Work than can be prosecuted properly with due regards to the rights of the public. To the extent possible, the Contractor shall finish each section before beginning Work on the next. The Contractor shall enter interstate Highways only through legal movements from existing roads, streets, and through other access points specifically allowed by the Contract documents.

To disrupt public traffic as little as possible, the Contractor shall permit traffic to pass through the Work with the least possible inconvenience or delay. The Contractor shall maintain existing roads, streets, sidewalks, and paths within the project limits, keeping them open and in good, clean, safe condition at all times. Accessibility to existing or temporary pedestrian push buttons shall not be impaired. Deficiencies caused by the Contractor's operations shall be repaired at the Contractor's expense. The Contractor shall also maintain roads, streets, sidewalks, and paths adjacent to the project limits when affected by the Contractor's operations. Snow and ice control will be performed by the Contracting Agency on all projects. Cleanup of snow and ice control debris will be at the Contracting Agency's expense. The Contractor shall perform the following:

1. Remove or repair any condition resulting from the Work that might impede traffic or create a hazard.
2. Keep existing traffic signal and Highway lighting systems in operation as the Work proceeds. (The Contracting Agency will continue the routine maintenance on such system.)
3. Maintain the striping on the Roadway at the Contracting Agency's expense. The Contractor shall be responsible for scheduling when to renew striping, subject to the approval of the Engineer. When the scope of the project does not require Work on the Roadway, the Contracting Agency will be responsible for maintaining the striping.
4. Maintain existing permanent signing. Repair of signs will be at the Contracting Agency's expense, except those damaged due to the Contractor's operations.
5. Keep drainage Structures clean to allow for free flow of water. Cleaning of existing drainage Structures will be at the Contracting Agency's expense when approved by the Engineer, except when flow is impaired due to the Contractor's operations.

To protect the rights of abutting property owners, the Contractor shall:

1. Conduct the construction so that the least inconvenience as possible is caused to abutting property owners;
2. Maintain ready access to driveways, houses, and buildings along the line of Work;
3. Provide temporary approaches to crossing or intersecting roads and keep these approaches in good condition; and
4. Provide another access before closing an existing one whenever the Contract calls for removing and replacing an abutting owner's access.

When traffic must pass through grading areas, the Contractor shall:

1. Make cuts and fills that provide a reasonably smooth, even Roadbed;
2. Place, in advance of other grading Work, enough fill at all culverts and bridges to permit traffic to cross;
3. Make Roadway cuts and fills, if ordered by the Engineer, in partial-width lifts, alternating lifts from side to side to permit traffic to pass on the side opposite the Work;
4. Install culverts on half the width of the Traveled Way, keeping the other half open to traffic and unobstructed until the first half is ready for use;
5. After rough grading or placing any subsequent layers, prepare the final Roadbed to a smooth, even surface (free of humps and dips) suitable for use by public traffic; and
6. Settle dust with water, or other dust palliative, as the Engineer may order.

If grading Work is on or next to a Roadway in use, the Contractor shall finish the grade immediately after rough grading and place surfacing materials as the Work proceeds.

The Contractor shall conduct all operations to minimize any drop-offs (abrupt changes in roadway elevation) left exposed to traffic during nonworking hours. Unless otherwise specified in the Traffic Control Plan, drop-offs left exposed to traffic during nonworking hours shall be protected as follows:

1. Drop-offs up to 0.20 foot, unless otherwise ordered by the Engineer, may remain exposed with appropriate warning signs alerting motorists of the condition.
2. Drop-offs more than 0.20 foot that are in the Traveled Way or Auxiliary Lane will not be allowed unless protected with appropriate warning signs and further protected as indicated in 3b or 3c below.
3. Drop-offs more than 0.20 foot, but no more than 0.50 foot, that are not within the Traveled Way shall be protected with appropriate warning signs and further protected by having one of the following:
    a. A wedge of compacted stable material placed at a slope of 4:1 or flatter.
    b. Channelizing devices (Type I barricades, plastic safety drums, or other devices 36 inches or more in height) placed along the traffic side of the drop-off and a new edge of pavement stripes placed a minimum of 3 feet from the drop-off. The maximum spacing between the devices in feet shall be the posted speed in miles per hour. Pavement drop-off warning signs shall be placed in advance and throughout the drop-off treatment.

c. Temporary concrete barrier, temporary steel barrier, or other approved traffic barrier installed on the traffic side of a drop-off is required to have a lateral offset from the edge of the drop-off to the back of the barrier following the offset distance shown in the plans. If the lateral offset distance is not shown in the plans, provide lateral offsets as follows:

i. A minimum offset of 3-feet for temporary unanchored concrete barrier.

ii. A minimum offset of 1-foot for temporary anchored barrier.

iii. A minimum offset as shown on WSDOT Standard Plan K-80.35 when anchoring temporary concrete barrier in accordance with the plan.

iv. A minimum offset in accordance with manufacturer recommendations for temporary steel barrier.

If the buffer distance from the face of barrier to the traffic edge line is not shown in the plans, provide an edge line a minimum of 2-feet from the face of the barrier. An approved terminal, flare, or impact attenuator is required at the approach end of the barrier run, and is required at the trailing end of a barrier run in two-way operations when shown in the plans or as directed by the Engineer. For night use, the barrier shall have retroreflective delineation.

4. Drop-offs more than 0.50 foot not within the Traveled Way or Auxiliary Lane shall be protected with appropriate warning signs and further protected as indicated in 3a, 3b, or 3c if all of the following conditions are met:

a. The drop-off is less than 2 feet;

b. The total length throughout the project is less than 1 mile;

c. The drop-off does not remain for more than 3 working days;

d. The drop-off is not present on any of the holidays listed in Section 1-08.5; and

e. The drop-off is only on one side of the Roadway.

5. Drop-offs more than 0.50 foot that are not within the Traveled Way or Auxiliary Lane and are not otherwise covered by No. 4 above shall be protected with appropriate warning signs and further protected as indicated in 3a or 3c.

6. Open trenches within the Traveled Way or Auxiliary Lane shall have a steel-plate cover placed and anchored over them. A wedge of suitable material, if required, shall be placed for a smooth transition between the pavement and the steel plate. Warning signs shall be used to alert motorists of the presence of the steel plates.

1-07.23(2) Construction and Maintenance of Detours

Unless otherwise approved, the Contractor shall maintain two-way traffic during construction. The Contractor shall build, maintain in a safe condition, keep open to traffic, and remove when no longer needed:

1. Detours and detour bridges that will accommodate traffic diverted from the Roadway, bridge, sidewalk, or path during construction;
2. Detour crossings of intersecting Highways; and
3. Temporary approaches.

Unit Contract prices will cover construction, maintenance, and removal of all detours shown in the Plans or proposed by the Contracting Agency.

The Contractor shall pay all costs to build, maintain, and remove any other detours, whether built for the Contractor's convenience or to facilitate construction operations. Any detour proposed by the Contractor shall not be built until the Engineer approves. Surfacing and paving shall be consistent with traffic requirements.

Upon failure of the Contractor to immediately provide, maintain, or remove detours or detour bridges when ordered to do so by the Engineer, the Contracting Agency may, without further notice to the Contractor or the Surety, provide, maintain, or remove the detours or detour bridges and deduct the costs from any payments due or coming due the Contractor.

1-07.24 Rights of Way

All rights of way for the completed facility will be provided by the Contracting Agency in advance of construction. Any exceptions will be noted in the Special Provisions. Should the necessary Right of Way not be available as provided in the Contract, an extension of time will be considered in accordance with Section 1-08.8.

1-07.25 Opening of Sections to Traffic

The Contracting Agency reserves the right to use and open to traffic any portion of the Work before the Physical Completion Date of the entire Contract without constituting acceptance of any of the Work. This action will not cause the Contracting Agency to incur any liability to the Contractor except as may otherwise be provided in the Contract.

If the Contracting Agency opens any portion of the Work prior to the Physical Completion Date of the entire Contract because early opening is specified in the Contract or when the Contractor has failed to prosecute the Work continuously and efficiently, any Work remaining shall be performed by the Contractor at the unit Contract prices for the items of Work involved. No additional payment will be made for costs incurred by the Contractor because of: (1) inconvenience, additional length of travel to conform to established traffic patterns and planned access features; (2) compliance with statutes governing traffic regulations and limitations of loads; or (3) additional flagging costs necessary to protect the operations and the traveling public. The Contractor shall take

all costs due to traffic using portions of the Work into account when submitting the Bid Proposal, and the unit Contract prices for the various items of Work involved shall include these costs.

1-07.26 Personal Liability of Public Officers

Neither the Governor, the Commission, the Secretary, the Engineer, nor any other officer or employee of the State shall be personally liable for any acts or failure to act in connection with the Contract, it being understood that in such matters, they are acting solely as agents of the State.

1-07.27 No Waiver of State's Legal Rights

The State shall not be precluded or estopped by any measurement, estimate, or certificate made either before or after the completion and acceptance of the Work and payment therefore from showing the true amount and character of the Work performed and materials furnished by the Contractor, or from showing that any such measurement, estimate, or certificate is untrue or incorrectly made, or that the Work or materials do not conform in fact to the Contract. The State shall not be precluded or estopped, notwithstanding any such measurement, estimate, or certificate, and payment in accordance therewith, from recovering from the Contractor and the Sureties such damages as it may sustain by reason of the Contractor's failure to comply with the terms of the Contract. Neither the acceptance by the Secretary, nor any payment for the whole or any part of the Work, nor any extension of time, nor any possession taken by the State shall operate as a waiver of any portion of the Contract or of any power herein reserved or any right to damages herein provided, or bar recovery of any money wrongfully or erroneously paid to the Contractor. A waiver of any breach of the Contract shall not be held to be a waiver of any other or subsequent breach.

The Contractor and the State recognize that the impact of overcharges to the State by the Contractor resulting from antitrust law violations by the Contractor's suppliers or Subcontractors adversely affects the State rather than the Contractor. Therefore, the Contractor agrees to assign to the State any and all claims for such overcharges.

1-08 Prosecution and Progress

1-08.1 Subcontracting

Work done by the Contractor's own organization shall account for at least 30 percent of the Awarded Contract price. Before computing this percentage, however, the Contractor may subtract (from the Awarded Contract price) the costs of any subcontracted Work on items the Contract designates as specialty items.

The Contractor shall not subcontract Work unless the Engineer approves in writing. Each request to subcontract shall be on the form the Engineer provides. If the Engineer requests, the Contractor shall provide proof that the Subcontractor has the experience, ability, and equipment the Work requires. The Contractor shall require each Subcontractor to comply with Section 1-07.9 and to furnish all certificates and statements required by the Contract.

Prior to subcontracting any Work, the Contractor shall verify that every first tier Subcontractor meets the responsibility criteria stated below at the time of subcontract execution. The Contractor shall include these responsibility criteria in every subcontract, and require every Subcontractor to:

1. Possess any electrical contractor license required by RCW 19.28 or elevator contractor license required by RCW 70.87, if applicable;
2. Have a certificate of registration in compliance with chapter RCW 18.27;
3. Have a current State unified business identifier number;
4. If applicable, have:
    a. Industrial insurance coverage for the bidder's employees working in Washington (Title 51 RCW);
    b. An employment security department number (Title 50 RCW);
    c. A State excise tax registration number (Title 82 RCW);
5. Not be disqualified from bidding on any public works contract under RCW 39.06.010 or RCW 39.12.065(3).
6. Verify these responsibility criteria for every lower tier subcontractor at the time of subcontract execution; and,
7. Include these responsibility criteria in every lower tier subcontract.

Along with the request to sublet, the Contractor shall submit the names of any contracting firms the Subcontractor proposes to use as lower tier subcontractors. Collectively, these lower tier subcontractors shall not do Work that exceeds 25 percent of the total amount subcontracted to a Subcontractor. When a Subcontractor is responsible for construction of a specific Structure or Structures, the following Work may be performed by lower tier Subcontractors without being subject to the 25 percent limitation:

1. Furnishing and driving of piling, or
2. Furnishing and installing concrete reinforcing and post-tensioning steel.

Except for the 25 percent limit, lower tier subcontractors shall meet the same requirements as Subcontractors.

The Engineer will approve the request only if satisfied with the proposed Subcontractor's record, equipment, experience, and ability. Approval to subcontract shall not:

1. Relieve the Contractor of any responsibility to carry out the Contract,
2. Relieve the Contractor of any obligations or liability under the Contract and the Contractor's bond,
3. Create any contract between the Contracting Agency and the Subcontractor, or
4. Convey to the Subcontractor any rights against the Contracting Agency.

All work that is not performed by the Contractor will be considered as subcontracting except: (1) purchase of sand, gravel, crushed stone, crushed slag, batched concrete aggregates, ready-mix concrete, off-site fabricated structural steel, other off-site fabricated items, and any other materials supplied by established and recognized commercial plants; or (2) delivery of these materials to the Work site in vehicles owned or operated by such plants or by recognized independent or commercial hauling companies hired by those commercial plants. However, the Washington State Department of Labor and Industries may determine that RCW 39.12 applies to the employees of such firms identified in 1 and 2 above in accordance with WAC 296-127. If this should occur, the provisions of Section 1-07.9, as modified or supplemented, shall apply.

The Contractor shall not use businesses (material suppliers, vendors, subcontractors, etc.) with federal purchasing exclusions. Businesses with exclusions are identified using the System for Award Management web page at www.SAM.gov.

On all projects, the Contractor shall certify to the actual amounts paid to all firms that were used as Subcontractors, lower tier subcontractors, manufacturers, regular dealers, or service providers on the Contract. This includes all Disadvantaged, Minority, Small, Veteran or Women's Business Enterprise firms. This Certification shall be submitted to the Engineer on a monthly basis each month between Execution of the Contract and Physical Completion of the Contract using the application available at: https://wsdot.diversitycompliance.com. A monthly report shall be submitted for every month between Execution of the Contract and Physical Completion regardless of whether payments were made or work occurred.

The Contractor shall comply with the requirements of RCW 39.04.250, 39.76.011, 39.76.020, and 39.76.040, in particular regarding prompt payment to Subcontractors. Whenever the Contractor withholds payment to a Subcontractor for any reason including disputed amounts, the Contractor shall provide notice within 10 calendar days to the Subcontractor with a copy to the Contracting Agency identifying the reason for the withholding and a clear description of what the Subcontractor must do to have the withholding released. Retainage withheld by the Contractor prior to completion of the

Subcontractors work is exempt from reporting as a payment withheld and is not included in the withheld amount. The Contracting Agency's copy of the notice to Subcontractor for deferred payments shall be submitted to the Engineer concurrently with notification to the Subcontractor.

If dissatisfied with any part of the subcontracted Work, the Engineer may request in writing that the Subcontractor be removed. The Contractor shall comply with this request at once and shall not employ the Subcontractor for any further Work under the Contract.

1-08.1(1) Prompt Payment, Subcontract Completion and Return of Retainage Withheld

The following procedure shall apply to all subcontracts entered into as a part of this Contract:

Requirements

1. Upon request, the Engineer will provide a copy of any or all progress payment estimates, with regard to contract payments to any interested party to the project.
2. The Contractor shall make payment to the Lower Tier Subcontractor not later than ten calendar days after receipt of payment for work satisfactorily completed by the Lower Tier Subcontractor, to the extent of the Lower Tier Subcontractor's interest therein.
3. In the event the Contractor believes they have the right under the Contract or Subcontract to withhold payment in part or whole from a Lower Tier Subcontractor they shall provide immediate notification to that Lower Tier Subcontractor and the Engineer. The notice shall include an accounting of payments to date, the value and reason for the withheld amount, and an explanation of what must be done to have the withheld amount released. The Lower Tier Subcontractor shall be paid within eight calendar days after the Subcontractor completes the remedial action identified.
4. Every subcontract and lower tier subcontract shall have a dispute resolution process incorporated for resolving issues between the parties to the subcontract, or one shall be established as necessary.
5. If the parties agree, the Contracting Agency will make a third party neutral available provided the parties to the dispute agree that the cost of doing so is split between them.
6. The Engineer will withhold the same amount of funds from the Contractor as was withheld if the issue is not resolved by the next progress estimate.
7. Failure by a Contractor or Subcontractor to comply with these requirements may result in one or more of the following:
    a. Reflected in the Prime Contractor's Performance Evaluation.
    b. Cancellation, termination or suspension of the Contract, in whole or in part.
    c. Sanctions as provided by the Contract; subcontract; or by law under applicable prompt payment statutes including RCW 39.04.250.

8. The Subcontractor shall make a written request to the Contractor for the release of the Subcontractor's retainage or retainage bond.
9. Within 10 calendar days of the request, the Contractor shall determine if the subcontract has been satisfactorily completed including any required lien releases, documentation and material testing and shall inform the Subcontractor, in writing, of the Contractor's determination.
10. If the Contractor determines that the subcontract has been satisfactorily completed, the Subcontractor's retainage or retainage bond shall be released by the Contractor within 10 calendar days from the date of the written notice. If the Contractor determines that the Subcontractor has not achieved satisfactory completion of the subcontract, the Contractor must provide the Subcontractor with written notice, stating specifically why the subcontract Work is not satisfactorily completed and what has to be done to achieve completion. The Contractor shall release the Subcontractor's retainage or retainage bond within 10 calendar days after the Subcontractor has satisfactorily completed the Work identified in the notice.
11. In determining whether satisfactory completion has been achieved, the Contractor may require the Subcontractor to provide documentation such as certifications and releases, showing that all laborers, lower-tiered Subcontractors, suppliers of material and equipment, and others involved in the Subcontractor's Work have been paid in full. The Contractor may also require any documentation from the Subcontractor that is required by the subcontract or by the Contract between the Contractor and Contracting Agency or by law such as affidavits of wages paid, and material acceptance certifications to the extent that they relate to the Subcontractor's Work.
12. If the Contractor fails to comply with the requirements of the Specification and the Subcontractor's retainage or retainage bond is wrongfully withheld, the Contractor will be subject to the actions described in No. 7 listed above. The Subcontractor may also seek recovery against the Contractor under applicable prompt pay statutes in addition to any other remedies provided for by the subcontract or by law.

Conditions

1. This clause does not create a contractual relationship between the Contracting Agency and any Subcontractor as stated in Section 1-08.1. Also, it is not intended to bestow upon any Subcontractor, the status of a third-party beneficiary to the Contract between the Contracting Agency and the Contractor.
2. This section of the Contract does not apply to retainage withheld by the Contracting Agency from monies earned by the Contractor. The Contracting Agency shall continue to process the release of that retainage based upon the Completion Date of the project as defined in Section 1-08.5 Time for Completion and in accordance with the requirements and procedures set forth in RCW 60.28.

Payment

The Contractor shall be solely responsible for any additional costs involved in paying retainage to the Subcontractors prior to total project completion. Those costs shall be incidental to the respective Bid items.

1-08.2 Assignment

The Contractor shall not assign all or any part of the Work unless the Engineer approves in writing. The Engineer will not approve any proposed assignment that would relieve the original Contractor or Surety of responsibility under the Contract.

Money due (or that will become due) to the Contractor may be assigned. If given written notice, the Contracting Agency will honor such an assignment to the extent the law permits. But the assignment shall be subject to all setoffs, withholdings, and deductions required by law and the Contract.

1-08.3 Progress Schedule

1-08.3(1) General Requirements

The Contractor shall submit Type A or Type B Progress Schedules and Schedule Updates to the Engineer for approval. Schedules shall show Work that complies with all time and order of Work requirements in the Contract. Scheduling terms and practices shall conform to the standards established in *Construction Planning and Scheduling, Second Editio*n, published by the Associated General Contractors of America. Except for Weekly Look-Ahead Schedules, all schedules shall meet these General Requirements, and provide the following information:

1. Include all activities necessary to physically complete the project.
2. Show the planned order of Work activities in a logical sequence.
3. Show durations of Work activities in working days as defined in Section 1-08.5.
4. Show activities in durations that are reasonable for the intended Work.
5. Define activity durations in sufficient detail to evaluate the progress of individual activities on a daily basis.
6. Show the Physical Completion of all Work within the authorized Contract time.

Total float belongs to the project and shall not be for the exclusive benefit of any party.

The Contracting Agency allocates its resources to a Contract based on the total time allowed in the Contract. The Contracting Agency may accept a Progress Schedule indicating an early Physical Completion Date but cannot guarantee the Contracting Agency's resources will be available to meet an accelerated schedule. No additional compensation will be allowed if the Contractor is not able to meet their accelerated schedule due to the unavailability of Contracting Agency's resources or for other reasons beyond the Contracting Agency's control.

If the Engineer determines that the Progress Schedule or any necessary Schedule Update does not provide the required information, then the schedule will be returned to the Contractor for correction and resubmittal.

The Engineer's approval of any schedule shall not transfer any of the Contractor's responsibilities to the Contracting Agency. The Contractor alone shall remain responsible for adjusting forces, equipment, and Work schedules to ensure completion of the Work within the time(s) specified in the Contract.

1-08.3(2) Progress Schedule Types

Type A Progress Schedules are required on all projects that do not contain the Bid item for Type B Progress Schedule. Type B Progress Schedules are required on all projects that contain the Bid item for Type B Progress Schedule. Weekly Look-Ahead Schedules and Schedule Updates are required on all projects.

1-08.3(2)A Type A Progress Schedule

The Contractor shall submit five copies of a Type A Progress Schedule no later than 10 days after the date the contract is executed, or some other mutually agreed upon submittal time. The schedule may be a critical path method (CPM) schedule, bar chart, or other standard schedule format. Regardless of which format is used, the schedule shall identify the critical path. The Engineer will evaluate the Type A Progress Schedule and approve or return the schedule for corrections within 15 calendar days of receiving the submittal.

1-08.3(2)B Type B Progress Schedule

The Contractor shall submit a preliminary Type B Progress Schedule no later than 5 calendar days after the date the Contract is executed. The preliminary Type B Progress Schedule shall comply with all of these requirements and the requirements of Section 1-08.3(1), except that it may be limited to only those activities occurring within the first 60 working days of the project.

The Contractor shall submit five copies of a Type B Progress Schedule depicting the entire project no later than 30 calendar days after the date the Contract is executed. The schedule shall be a critical path method (CPM) schedule developed by the Precedence Diagramming Method (PDM). Restraints may be utilized, but may not serve to change the logic of the network or the critical path. The schedule shall display at least the following information:

- Contract Number and Title
- Construction Start Date
- Critical Path
- Activity Description
- Milestone Description
- Activity Duration
- Predecessor Activities

- Successor Activities
- Early Start (ES) and Early Finish (EF) for each activity
- Late Start (LS) and Late Finish (LF) for each activity
- Total Float (TF) and Free Float (FF) for each activity
- Physical Completion Date
- Data Date

The Engineer will evaluate the Type B Progress Schedule and approve or return the schedule for corrections within 15 calendar days of receiving the submittal.

1-08.3(2)C Vacant

1-08.3(2)D Weekly Look-Ahead Schedule

Each week that Work will be performed, the Contractor shall submit a Weekly Look-Ahead Schedule showing the Contractor's and all Subcontractors' proposed Work activities for the next two weeks. The Weekly Look-Ahead Schedule shall include the description, duration and sequence of Work, along with the planned hours of Work. This schedule may be a network schedule, bar chart, or other standard schedule format. The Weekly Look-Ahead Schedule shall be submitted to the Engineer by the midpoint of the week preceding the scheduled Work or some other mutually agreed upon submittal time.

1-08.3(3) Schedule Updates

The Engineer may request a Schedule Update when any of the following events occur:

1. The project has experienced a change that affects the critical path.
2. The sequence of Work is changed from that in the approved schedule.
3. The project is significantly delayed.
4. Upon receiving an extension of Contract time.

The Contractor shall submit five copies of a Type A or Type B Schedule Update within 15 calendar days of receiving a written request, or when an update is required by any other provision of the Contract. A "significant" delay in time is defined as 10 working days or 10 percent of the original Contract time, whichever is greater.

In addition to the other requirements of this section, Schedule Updates shall reflect the following information:

1. The actual duration and sequence of as-constructed Work activities, including changed Work.
2. Approved time extensions.
3. Any construction delays or other conditions that affect the progress of the Work.
4. Any modifications to the as-planned sequence or duration of remaining activities.
5. The Physical Completion of all remaining Work in the remaining Contract time.

Unresolved requests for time extensions shall be reflected in the Schedule Update by assuming no time extension will be granted, and by showing the effects to follow-on activities necessary to physically complete the project within the currently authorized time for completion.

1-08.3(4) Measurement

No specific unit of measurement shall apply to the lump sum item for Type B Progress Schedule.

1-08.3(5) Payment

Payment will be made for the following Bid item when it is included in the Proposal:

"Type B Progress Schedule", lump sum.

The lump sum price shall be full pay for all costs for furnishing the Type B Progress Schedule and preliminary Type B Progress Schedule.

Payment of 80 percent of the lump sum price will be made upon approval of the Progress Schedule.

Payment will be increased to 100 percent of the lump sum price upon completion of 80 percent of the original total Contract Award amount.

All costs for providing Type A Progress Schedules and Weekly Look-Ahead Schedules are considered incidental to other items of Work in the Contract.

No payment will be made for Schedule Updates that are required due to the Contractors operations. Schedule Updates required by events that are attributed to the actions of the Contracting Agency will be paid for in accordance with Section 1-09.4.

1-08.4 Prosecution of Work

The Contractor shall begin Work within 21 calendar days from the date of execution of the Contract by the Contracting Agency, unless otherwise approved in writing. The Contractor shall diligently pursue the Work to the Physical Completion Date within the time specified in the Contract. Voluntary shutdown or slowing of operations by the Contractor shall not relieve the Contractor of the responsibility to complete the Work within the time(s) specified in the Contract.

When shown in the Plans, the first order of work shall be the installation of high visibility fencing to delineate all areas for protection or restoration, as described in the Contract. Installation of high visibility fencing adjacent to the roadway shall occur after the placement of all necessary signs and traffic control devices in accordance with Section 1-10.1(2). Upon construction of the fencing, the Contractor shall request the Engineer to inspect the fence. No other work shall be performed on the site until the Contracting Agency has accepted the installation of high visibility fencing, as described in the Contract.

1-08.5 Time for Completion

The Contractor shall complete all physical Contract Work within the number of "working days" stated in the Contract Provisions or as extended by the Engineer in accordance with Section 1-08.8. Every day will be counted as a "working day" unless it is a nonworking day or an Engineer determined unworkable day. A nonworking day is defined as a Saturday, a Sunday, a whole or half day on which the Contract specifically prohibits Work on the critical path of the Contractor's approved progress schedule, or one of these holidays: January 1, the third Monday of January, the third Monday of February, Memorial Day, July 4, Labor Day, November 11, Thanksgiving Day, the day after Thanksgiving, and Christmas Day. When any of these holidays fall on a Sunday, the following Monday shall be counted a nonworking day. When the holiday falls on a Saturday, the preceding Friday shall be counted a nonworking day. The days between December 25 and January 1 will be classified as nonworking days.

An unworkable day is defined as a half or whole day the Engineer declares to be unworkable because of weather or conditions caused by the weather that prevents satisfactory and timely performance of the Work shown on the critical path of the Contractor's approved progress schedule. Other conditions beyond the control of the Contractor may qualify for an extension of time in accordance with Section 1-08.8.

Contract time shall begin on the first working day following the 21st calendar day after the date the Contracting Agency executes the Contract. If the Contractor starts Work on the project at an earlier date, then Contract time shall begin on the first working day when on-site Work begins. The Contract Provisions may specify another starting date for Contract time, in which case, time will begin on the starting date specified.

Each working day shall be charged to the Contract as it occurs, until the Contract Work is physically complete. If Substantial Completion has been granted and all the authorized working days have been used, charging of working days will cease. Each week the Engineer will provide the Contractor a statement that shows the number of working days: (1) charged to the Contract the week before; (2) specified for the Physical Completion of the Contract; and (3) remaining for the Physical Completion of the Contract. The statement will also show the nonworking days and any half or whole day the Engineer declares as unworkable. Within 10 calendar days after the date of each statement, the Contractor shall file a written protest of any alleged discrepancies in it. To be considered by the Engineer, the protest shall be in sufficient detail to enable the Engineer to ascertain the basis and amount of time disputed. By not filing such detailed protest in that period, the Contractor shall be deemed as having accepted the statement as correct.

The Engineer will give the Contractor written notice of the Physical Completion Date for all Work the Contract requires. That date shall constitute the Physical Completion Date of the Contract, but shall not imply the Secretary's acceptance of the Work or the Contract.

The Engineer will give the Contractor written notice of the Completion Date of the Contract after all the Contractor's obligations under the Contract have been performed by the Contractor. The following events must occur before the Completion Date can be established:

1. The physical Work on the project must be complete; and
2. The Contractor must furnish all documentation required by the Contract and required by law, to allow the Contracting Agency to process final acceptance of the Contract. The following documents must be received by the Engineer prior to establishing a Completion Date:
    a. Certified Payrolls (Federal-aid Projects)
    b. Material Acceptance Certification Documents
    c. Monthly Reports of Amounts Paid as MBE/WBE Participants, or Monthly Reports of Amounts Credited as DBE Participation, as required by the Contract Provisions
    d. Final Contract Voucher Certification
    e. Copies of the approved "Affidavit of Prevailing Wages Paid" for the Contractor and all Subcontractors
    f. A copy of the Notice of Termination sent to the Washington State Department of Ecology (Ecology); the elapse of 30 calendar days from the date of receipt of the Notice of Termination by Ecology; and no rejection of the Notice of Termination by Ecology. This requirement will not apply if the Construction Stormwater General Permit is transferred back to the Contracting Agency in accordance with Section 8-01.3(16).

1-08.6 Suspension of Work

The Engineer may order suspension of all or any part of the Work if:

1. Unsuitable weather prevents satisfactory and timely performance of the Work; or
2. The Contractor does not comply with the Contract; or
3. It is in the public interest.

When ordered by the Engineer to suspend or resume Work, the Contractor shall do so immediately.

If the Work is suspended for reason (1) above, the period of Work stoppage will be counted as unworkable days. But if the Engineer believes the Contractor should have completed the suspended Work before the suspension, all or part of the suspension period may be counted as working days. The Engineer will set the number of unworkable days (or parts of days) by deciding how long the suspension delayed the entire project.

If the Work is suspended for reason (2) above, the period of Work stoppage will be counted as working days. The lost Work time, however, shall not relieve the Contractor from any Contract responsibility.

If the performance of all or any part of the Work is suspended, delayed, or interrupted for an unreasonable period of time by an act of the Contracting Agency in the administration of the Contract, or by failure to act within the time specified in the Contract (or if no time is specified, within a reasonable time), the Engineer will make an adjustment for any increase in the cost or time for the performance of the Contract (excluding profit) necessarily caused by the suspension, delay, or interruption. However, no adjustment will be made for any suspension, delay, or interruption if (1) the performance would have been suspended, delayed, or interrupted by any other cause, including the fault or negligence of the Contractor, or (2) an equitable adjustment is provided for or excluded under any other provision of the Contract.

If the Contractor believes that the performance of the Work is suspended, delayed, or interrupted for an unreasonable period of time and such suspension, delay, or interruption is the responsibility of the Contracting Agency, the Contractor shall immediately submit a written notice of protest to the Engineer as provided in Section 1-04.5. No adjustment shall be allowed for any costs incurred more than 10 calendar days before the date the Engineer receives the Contractor's written notice of protest. If the Contractor contends damages have been suffered as a result of such suspension, delay, or interruption, the protest shall not be allowed unless the protest (stating the amount of damages) is asserted in writing as soon as practicable, but no later than the date of the Contractor's signature on the Final Contract Voucher Certification. The Contractor shall keep full and complete records of the costs and additional time of such suspension, delay, or interruption and shall permit the Engineer to have access to those records and any other records as may be deemed necessary by the Engineer to assist in evaluating the protest.

The Engineer will determine if an equitable adjustment in cost or time is due as provided in this section. The equitable adjustment for increase in costs, if due, shall be subject to the limitations provided in Section 1-09.4, provided that no profit of any kind will be allowed on any increase in cost necessarily caused by the suspension, delay, or interruption.

Request for extensions of time will be evaluated in accordance with Section 1-08.8.

The Engineer's determination as to whether an adjustment should be made will be final as provided in Section 1-05.1.

No claim by the Contractor under this clause shall be allowed unless the Contractor has followed the procedures provided in this section and in Sections 1-04.5 and 1-09.11.

1-08.7 Maintenance During Suspension

Before and during any suspension (as described in Section 1-08.6) the Contractor shall protect the Work from damage or deterioration. Suspension shall not relieve the Contractor from anything the Contract requires unless this section states otherwise.

At no expense to the Contracting Agency, the Contractor shall provide through the construction area safe, smooth, and unobstructed roadways and pedestrian access routes for public use during the suspension (as required in Section 1-07.23 or the Special

Provisions). This may include a temporary road, alternative pedestrian access route or detour.

If the Engineer determines that the Contractor failed to pursue the Work diligently before the suspension, or failed to comply with the Contract or orders, then the Contractor shall maintain the temporary Roadway in use during suspension. In this case, the Contractor shall bear the maintenance costs. If the Contractor fails to maintain the temporary Roadway, the Contracting Agency will do the Work and deduct all resulting costs from payments due to the Contractor.

If the Engineer determines that the Contractor has pursued the Work diligently before the suspension, then the Contracting Agency will maintain the temporary Roadway (and bear its cost). This Contracting Agency-provided maintenance work will include only routine maintenance of:

1. The Traveled Way, Auxiliary Lanes, Shoulders, and detour surface;
2. Roadway drainage along and under the traveled Roadway or detour; and
3. All barricades, signs, and lights needed for directing traffic through the temporary Roadway or detour in the construction area.

The Contractor shall protect and maintain all other Work in areas not used by traffic. All costs associated with protecting and maintaining such Work shall be the responsibility of the Contractor.

After any suspension during which the Contracting Agency has done the routine maintenance, the Contractor shall accept the traveled Roadway or detour as is when Work resumes. The Contractor shall make no claim against the Contracting Agency for the condition of the Roadway or detour.

After any suspension, the Contractor shall resume all responsibilities the Contract assigns for the Work.

1-08.8 Extensions of Time

The Contractor shall submit any requests for time extensions to the Engineer in writing no later than 10 working days after the delay occurs. The requests for time extension shall be limited to the effect on the critical path of the Contractor's approved schedule attributable to the change or event giving rise to the request.

To be considered by the Engineer, the request shall be in sufficient detail (as determined by the Engineer) to enable the Engineer to ascertain the basis and amount of the time requested. The request shall include an updated schedule that supports the request and demonstrates that the change or event: (1) had a specific impact on the critical path, and except in cases of concurrent delay, was the sole cause of such impact, and (2) could not have been avoided by resequencing of the Work or by using other reasonable alternatives. If a request combined with previous extension requests, equals 20 percent or more of the original Contract time then the Contractor's letter of request must bear consent of Surety. In evaluating any request, the Engineer will consider how well the Contractor used the time from Contract execution up to the point of the delay and the effect the delay has on

any completion times included in the Special Provisions. The Engineer will evaluate and respond within 15 calendar days of receiving the request.

The authorized time for Physical Completion will be extended for a period equal to the time the Engineer determines the Work was delayed because of:

1. Adverse weather causing the time requested to be unworkable, provided that the Engineer had not already declared the time to be unworkable and the Contractor has filed a written protest according to Section 1-08.5.
2. Any action, neglect, or default of the Contracting Agency, its officers, or employees, or of any other contractor employed by the Contracting Agency.
3. Fire or other casualty for which the Contractor is not responsible.
4. Strikes.
5. Any other conditions for which these Specifications permit time extensions such as:
    a. In Section 1-04.4 if a change increases the time to do any of the Work including unchanged Work.
    b. In Section 1-04.5 if increased time is part of a protest that is found to be a valid protest.
    c. In Section 1-04.7 if a changed condition is determined to exist that caused a delay in completing the Contract.
    d. In Section 1-05.3 if the Contracting Agency does not approve properly prepared and acceptable drawings within 30 calendar days.
    e. In Section 1-07.13 if the performance of the Work is delayed as a result of damage by others.
    f. In Section 1-07.17 if the removal or the relocation of any utility by forces other than the Contractor caused a delay.
    g. In Section 1-07.24 if a delay results from all the Right of Way necessary for the construction not being purchased and the Special Provisions does not make specific provisions regarding unpurchased Right of Way.
    h. In Section 1-08.6 if the performance of the Work is suspended, delayed, or interrupted for an unreasonable period of time that proves to be the responsibility of the Contracting Agency.
    i. In Section 1-09.11 if a dispute or claim also involves a delay in completing the Contract and the dispute or claim proves to be valid.
    j. In Section 1-09.6 for Work performed on a force account basis.
6. If the actual quantity of Work performed for a Bid item was more than the original Plan quantity and increased the duration of a critical activity. Extensions of time will be limited to only that quantity exceeding the original Plan quantity.
7. Exceptional causes not specifically identified in items 1 through 6, provided the request letter proves the Contractor had no control over the cause of the delay and could have done nothing to avoid or shorten it.

Working days added to the Contract by time extensions, when time has overran, shall only apply to days on which liquidated damages or direct engineering have been charged, such as the following:

> If Substantial Completion has been granted prior to all of the authorized working days being used, then the number of days in the time extension will eliminate an equal number of days on which direct engineering charges have accrued. If the Substantial Completion Date is established after all of the authorized working days have been used, then the number of days in the time extension will eliminate an equal number of days on which liquidated damages or direct engineering charges have accrued.

The Engineer will not allow a time extension for any cause listed above if it resulted from the Contractor's default, collusion, action or inaction, or failure to comply with the Contract.

The Contracting Agency considers the time specified in the Special Provisions as sufficient to do all the Work. For this reason, the Contracting Agency will not grant a time extension for:

1. Failure to obtain all materials and workers unless the failure was the result of exceptional causes as provided above in Subsection 7;
2. Changes, protests, increased quantities, or changed conditions (Section 1-04) that do not delay the completion of the Contract or prove to be an invalid or inappropriate time extension request;
3. Delays caused by nonapproval of drawings or plans as provided in Section 1-05.3;
4. Rejection of faulty or inappropriate equipment as provided in Section 1-05.9;
5. Correction of thickness deficiency as provided in Section 5-05.5(1)B.

The Engineer will determine whether the time extension should be granted, the reasons for the extension, and the duration of the extension, if any. Such determination will be final as provided in Section 1-05.1.

1-08.9 Liquidated Damages

Time is of the essence of the Contract. Delays inconvenience the traveling public, obstruct traffic, interfere with and delay commerce, and increase risk to Highway users. Delays also cost tax payers undue sums of money, adding time needed for administration, engineering, inspection, and supervision.

Accordingly, the Contractor agrees:

1. To pay the liquidated damages identified in the Special Provisions for each working day beyond the number of working days established for Physical Completion, and
2. To authorize the Engineer to deduct these liquidated damages from any money due or coming due to the Contractor.

When the Contract Work has progressed to the extent that the Contracting Agency has full use and benefit of the facilities, both from the operational and safety standpoint,

all the initial plantings are completed and only minor incidental Work, replacement of temporary substitute facilities, plant establishment periods, or correction or repair remains to physically complete the total Contract, the Engineer may determine the Contract Work is substantially complete. The Engineer will notify the Contractor in writing of the Substantial Completion Date. For overruns in Contract time occurring after the date so established, liquidated damages identified in the Special Provisions will not apply. For overruns in Contract time occurring after the Substantial Completion Date, liquidated damages shall be assessed on the basis of direct engineering and related costs assignable to the project until the actual Physical Completion Date of all the Contract Work. The Contractor shall complete the remaining Work as promptly as possible. Upon request by the Engineer, the Contractor shall furnish a written schedule for completing the physical Work on the Contract.

Liquidated damages will not be assessed for any days for which an extension of time is granted. No deduction or payment of liquidated damages will, in any degree, release the Contractor from further obligations and liabilities to complete the entire Contract.

1-08.10 Termination of Contract

1-08.10(1) Termination for Default

The Contracting Agency may terminate the Contract upon the occurrence of any one or more or the following events:

1. If the Contractor fails to supply sufficient skilled workers or suitable materials or equipment;
2. If the Contractor refuses or fails to prosecute the Work with such diligence as will ensure its Physical Completion within the original Physical Completion time and any extensions of time which may have been granted to the Contractor by change order or otherwise;
3. If the Contractor is adjudged bankrupt or insolvent, or makes a general assignment for the benefit of creditors, or if the Contractor or a third party files a petition to take advantage of any debtor's act or to reorganize under the bankruptcy or similar laws concerning the Contractor, or if a trustee or receiver is appointed for the Contractor or for any of the Contractor's property on account of the Contractor's insolvency, and the Contractor or its successor in interest does not provide adequate assurance of future performance in accordance with the Contract within 15 calendar days of receipt of a request for assurance from the Contracting Agency;
4. If the Contractor disregards laws, ordinances, rules, codes, regulations, orders or similar requirements of any public entity having jurisdiction;
5. If the Contractor disregards the authority of the Contracting Agency;
6. If the Contractor performs Work which deviates from the Contract, and neglects or refuses to correct rejected Work; or
7. If the Contractor otherwise violates in any material way any provisions or requirements of the Contract.

Once the Contracting Agency determines that sufficient cause exists to terminate the Contract, written notice shall be given to the Contractor and its Surety indicating that the Contractor is in breach of the Contract and that the Contractor is to remedy the breach within 15 calendar days after the notice is sent. In case of an emergency such as potential damage to life or property, the response time to remedy the breach after the notice may be shortened. If the remedy does not take place to the satisfaction of the Contracting Agency, the Engineer may, by serving written notice to the Contractor and Surety either:

1. Transfer the performance of the Work from the Contractor to the Surety; or
2. Terminate the Contract and at the Contracting Agency's option prosecute it to completion by contract or otherwise. Any extra costs or damages to the Contracting Agency shall be deducted from any money due or coming due to the Contractor under the Contract.

If the Engineer elects to pursue one remedy, it will not bar the Engineer from pursuing other remedies on the same or subsequent breaches.

Upon receipt of a notice that the Work is being transferred to the Surety, the Surety shall enter upon the premises and take possession of all materials, tools, and appliances for the purpose of completing the Work included under the Contract and employ by contract or otherwise any person or persons satisfactory to the Engineer to finish the Work and provide the materials without termination of the Contract. Such employment shall not relieve the Surety of its obligations under the Contract and the bond. If there is a transfer to the Surety, payments on estimates covering Work subsequent to the transfer shall be made to the extent permitted under law to the Surety or its agent without any right of the Contractor to make any claim.

If the Engineer terminates the Contract or provides such sufficiency of labor or materials as required to complete the Work, the Contractor shall not be entitled to receive any further payments on the Contract until all the Work contemplated by the Contract has been fully performed. The Contractor shall bear any extra expenses incurred by the Contracting Agency in completing the Work, including all increased costs for completing the Work, and all damages sustained, or which may be sustained, by the Contracting Agency by reason of such refusal, neglect, failure, or discontinuance of Work by the Contractor. If liquidated damages are provided in the Contract, the Contractor shall be liable for such liquidated damages until such reasonable time as may be required for Physical Completion of the Work. After all the Work contemplated by the Contract has been completed, the Engineer will calculate the total expenses and damages for the completed Work. If the total expenses and damages are less than any unpaid balance due the Contractor, the excess will be paid by the Contracting Agency to the Contractor. If the total expenses and damages exceed the unpaid balance, the Contractor and the Surety shall be jointly and severally liable to the Contracting Agency and shall pay the difference to the State of Washington, Department of Transportation on demand.

In exercising the Contracting Agency's right to prosecute the Physical Completion of the Work, the Contracting Agency shall have the right to exercise its sole discretion as to the manner, method, and reasonableness of the costs of completing the Work. In the event

that the Contracting Agency takes Bids for remedial Work or Physical Completion of the project, the Contractor shall not be eligible for the Award of such Contracts.

In the event the Contract is terminated, the termination shall not affect any rights of the Contracting Agency against the Contractor. The rights and remedies of the Contracting Agency under the Termination Clause are in addition to any other rights and remedies provided by law or under this Contract. Any retention or payment of monies to the Contractor by the Contracting Agency will not release the Contractor from liability.

If a notice of termination for default has been issued and it is later determined for any reason that the Contractor was not in default, the rights and obligations of the parties shall be the same as if the notice of termination had been issued pursuant to Termination for Public Convenience in Section 1-08.10(2). This shall include termination for default because of failure to prosecute the Work, and the delay was found to be excusable under the provisions of Section 1-08.8.

1-08.10(2) Termination for Public Convenience

The Engineer may terminate the Contract in whole, or from time to time in part, whenever:

1. The Contractor is prevented from proceeding with the Work as a direct result of an Executive Order of the President with respect to the prosecution of war or in the interest of national defense; or an Executive Order of the President or Governor of the State with respect to the preservation of energy resources;
2. The Contractor is prevented from proceeding with the Work by reason of a preliminary, special, or permanent restraining order of a court of competent jurisdiction where the issuance of such restraining order is primarily caused by acts or omissions of persons or agencies other than the Contractor; or
3. The Engineer determines that such termination is in the best interests of the Contracting Agency.

1-08.10(3) Termination for Public Convenience Payment Request

After receipt of Termination for Public Convenience as provided in Section 1-08.10(2), the Contractor shall submit to the Contracting Agency a request for costs associated with the termination. The request shall be prepared in accordance with the claim procedures outlined in Sections 1-09.11 and 1-09.12. The request shall be submitted promptly but in no event later than 90 calendar days from the effective date of termination.

The Contractor agrees to make all records available to the extent deemed necessary by the Engineer to verify the costs in the Contractor's payment request.

1-08.10(4) Payment for Termination for Public Convenience

Whenever the Contract is terminated in accordance with Section 1-08.10(2), payment will be made in accordance with Section 1-09.5 for the actual Work performed.

If the Contracting Agency and the Contractor cannot agree as to the proper amount of payment, then the matter will be resolved as outlined in Section 1-09.13 except that, if the termination occurs because of the issuance of a restraining order as provided in Section 1-08.10(2), the matter will be resolved through mandatory and binding arbitration as described in Sections 1-09.13(3)A and B, regardless of the amount of the claim.

1-08.10(5) Responsibility of the Contractor and Surety

Termination of a Contract shall not relieve the Contractor of any responsibilities under the Contract for Work performed. Nor shall termination of the Contract relieve the Surety or Sureties of obligations under the Contract Bond or retainage bond for Work performed.

1-09 Measurement and Payment

1-09.1 Measurement of Quantities

In measuring all acceptably completed Bid items of Work, the Engineer will:

1. Use United States standard measure;
2. Make all measurements as described in this section, unless individual Specifications require otherwise;
3. Follow methods generally recognized as conforming to good engineering practice;
4. Conform to the usual practice of the Contracting Agency by carrying measurements and computations to the proper significant figure or fraction of units for each item; and
5. Measure horizontally or vertically (unless otherwise specified).

The terms listed below shall be defined as follows in all measurements under this section:

"Lump Sum" (when used as an item of payment): complete payment for the Work described for that item in the Contract.

"Gage" (in measurement of plates): the U.S. Standard Gage.

"Gage" (in measurement of galvanized sheets used to manufacture corrugated metal pipe, metal plate pipe culverts and arches, and metal cribbing): that specified in AASHTO M 36, M 167, M 196, M 197, or M 219.

"Gage" (in measurement of wire): that specified in AASHTO M 32.

"Ton": 2,000 pounds of avoirdupois weight.

Items of payment that have "Lump Sum" or "Force Account" in the Bid item of Work shall have no specific unit of measurement requirement.

For each basis of measurement listed below, the Engineer will use the method of measurement described. For Bid items or materials measured on the basis of:

Hour – Measured for each hour that Work is actually performed. Portions of an hour will be rounded up to a half hour.

Square Yard or Square Foot – The measurement shall be a calculation from the neat dimensions shown in the Plans or as altered by the Engineer. If there is an exception within the measured area where the item of Work is not performed (such as a drainage vault within a measured sidewalk) and if the exception area is greater than 9 square feet, then the area of the exception will be subtracted from the payment area calculated from the neat dimensions.

Linear Foot (pipe culverts, guard rail, underdrains, etc.) – Measured parallel to the Structure's base or foundation, unless the Plans require otherwise.

Weight – Weighed as required in Section 1-09.2.

Volume (of excavation and embankment) – Measured by the average-end-area method or by the finite element analysis method utilizing digital terrain modeling techniques. All or some computations may be based on ground elevations and other data derived photogrammetrically. The Engineer may correct for curvature.

Volume (in the hauling vehicle) – Measured at the point of delivery. Hauling vehicles may be of any size or type the Engineer approves provided that the body is of such shape that the actual contents may be readily and accurately determined. If the Engineer requires, the Contractor shall level loads at the delivery point to facilitate measurement.

For each item listed below, the Engineer will use the method of measurement described.

Structures – Measured on the neat lines shown in the Plans or as altered by the Engineer. When a complete Structure or structural unit is specified as the unit of measurement, the unit shall include all fittings and accessories.

Timber – Measured by the thousand board feet (MBM) actually used in the Structure. Measurements will be based on nominal widths and thicknesses and the extreme length of each piece.

Standard Manufactured Items (fence, wire, plates, rolled shapes, pipe conduit, etc., when specified) – Measured by the manufacturer's identification of gage, unit weight, section dimension, etc. The Engineer will accept manufacturing tolerances set by each industry unless cited Specifications require more stringent tolerances.

Cement – Measured by the pound, ton, or sack. A sack shall be 94 pounds.

Asphalt – Measured by the gallon or ton. If measured by gallon, measurement will be made at 60 F (or will be corrected to the volume at 60 F in keeping with ASTM D1250). If shipped by rail, truck, or transport, measurement will be by net certified scale masses or certified volumes (corrected for material lost en route or not actually incorporated into the Work).

No measurement will be made for:

1. Work performed or materials placed outside lines shown in the Plans or set by the Engineer;
2. Materials wasted, used, or disposed of in a manner contrary to the Contract;
3. Rejected materials (including those rejected after placement if the rejection resulted from the Contractor's failure to comply with the Contract);
4. Hauling and disposing of rejected materials;
5. Material remaining on hand after the Work is completed, except as provided in Sections 1-09.5 and 1-09.10; or
6. Any other Work or material contrary to any Contract Provision.

1-09.2 Weighing Equipment

1-09.2(1) General Requirements for Weighing Equipment

Unless specified otherwise, any Highway or bridge construction materials to be proportioned or measured and paid for by weight shall be weighed on a scale.

Scales – Scales shall:

1. Be accurate to within 0.5 percent of the correct weight throughout the range of use;
2. Not include spring balances;
3. Include beams, dials, or other reliable readout equipment;
4. Be built to prevent scale parts from binding, vibrating, or being displaced and to protect all working parts from falling material, wind, and weather; and
5. Be carefully maintained, with bunkers and platforms kept clear of accumulated materials that could cause errors and with knife edges given extra care and protection.

Scale Operations – "Contractor-provided scale operations" are defined as operations where a scale is set up by the Contractor specifically for the project and most, if not all, material weighed on the scale is utilized for Contract Work. In this situation, the Contractor shall provide a person to operate the project scale, write tickets, perform scale checks and prepare reports.

"Commercial scale operations" include the use of established scales used to sell materials to the public on a regular basis. In addition, for the purposes of this Specification, all batch, hopper, and belt scales are considered to be commercial scales. When a commercial scale is used as the project scale, the Contractor may utilize a commercial scale operator provided it is at no additional cost to the Contracting Agency.

In addition, the Contractor shall ensure that:

1. The Engineer is allowed to observe the weighing operation and check the daily scale weight record;
2. Scale verification checks are performed at the direction of the Contracting Agency (see Section 1-09.2(5));
3. Several times each day, the scale operator records and makes certain the platform scale balances and returns to zero when the load is removed; and
4. Test results and scale weight records for each day's hauling operations are provided to the Engineer daily. Unless otherwise approved, reporting shall utilize WSDOT Form 422-027 Scaleman's Daily Report.

Trucks and Tickets – Each truck to be weighed shall bear a unique identification number. This number shall be legible and in plain view of the scale operator. Each vehicle operator shall obtain a weigh or load ticket from the scale operator. The Contracting Agency will provide item quantity tickets for scales that are not self-printing. The Contractor shall provide tickets for self-printing scales. All tickets shall, at a minimum, contain the following information:

1. Date of haul;
2. Contract number;
3. Contract unit Bid item;
4. Unit of measure;
5. Identification number of hauling vehicle; and
6. Weight delivered:
    a. Net weight in the case of batch and hopper scales.
    b. Gross weight, tare and net weight in the case of platform scales (tare may be omitted if a tare beam is used).
    c. Approximate load out weight in the case of belt conveyor scales.

The vehicle operator shall deliver the ticket in legible condition to the material receiver at the material delivery point. The material delivery point is defined as the location where the material is incorporated into the permanent Work. When requested by the Engineer, the Contractor's representative shall collect the tickets throughout the day and provide them to the Engineer's designated receiver, not later than the end of shift, for reconciliation. Tickets for loads not verified as delivered will receive no pay.

1-09.2(2) Specific Requirements for Batching Scales

Each batching scale shall be designed to support a weighing container. The arrangement shall make it convenient for the operator to remove material from the weighing container while watching readout devices. Any weighing container mounted on a platform scale shall have its center of gravity directly over the platform centerline. Batching scales used for concrete or hot mix asphalt shall not be used for batching other materials.

Readout devices used for batching or hopper scales shall be marked at intervals evenly spaced throughout and shall be based on the scale's nominal rated capacity. These intervals shall not exceed one-tenth of 1 percent of the nominal rated capacity. Before use at a new site and then at 6-month intervals, all batching and hopper scales shall be: approved under rules of the Weights and Measures Section of the Washington State Department of Agriculture, or serviced and tested with at least 10,000 pounds by an agent of its manufacturer. In either case, the Contractor shall provide the Engineer with a copy of the final test results.

1-09.2(3) Specific Requirements for Platform Scales

Each platform scale shall be able to weigh the entire hauling vehicle or combination of connected vehicles at one time. No part of the vehicle or vehicle combination will be permitted off the platform as it is weighed. A tare weight shall be taken of each hauling vehicle at least once daily.

Any platform scale shall be installed and maintained with the platform level and with rigid bulkheads at either end to prevent binding or shifting. The readout device shall be marked at intervals of no more than 40 pounds. Test records shall show results to the nearest 20 pounds. During weighing operations, weights shall be read and recorded to the nearest 100 pounds. Before use at a new site and then at 6-month intervals, any platform scale shall be: approved under rules of the Washington State Department of Agriculture's Weights and Measures Section, or serviced and tested with at least 10,000 pounds by an agent of its manufacturer. In either case, the Contractor shall provide the Engineer with a copy of the final test results.

1-09.2(4) Specific Requirements for Belt Conveyor Scales

The Engineer may approve conveyor-belt weighing of untreated materials if the method and device meet all general requirements for weighing equipment. The recording tape, odometer, totalizer, calibration adjustment, and clock-time imprinter shall be kept locked and the Engineer shall retain all keys. All belt-conveyor scales shall comply with the requirements for Belt-Conveyor Scales in the National Institute of Standards and Technology (NIST) Handbook No. 44, except where these Specifications modify those requirements.

A static load test shall be made: each day after the belt-conveyor has run continuously for about 30 minutes, and again, immediately after the air temperature changes significantly. If the static load test reveals a need for adjustment, the Contractor shall perform a chain test. The Contractor shall make the computation of the test chain calibration, the calibration procedures and results, and related records available for the Engineer's review. The test chain shall be clearly marked with its calibration, carried in a suitable container, and kept immediately available for testing.

1-09.2(5) Measurement

Scale Verification Checks – The Engineer will verify the accuracy of each batch, hopper, or platform scale. The frequency of verification checks will be such that at least one test weekly is performed for each scale used in weighing contract items of Work.

Verification checks may not be routinely conducted for weighed material, whose proposal quantity multiplied by the unit Bid price, has a value less than $20,000.

The verification will consist of one of the following methods and be at the Contractor's option:

1. Weigh a loaded truck on a separate certified platform scale designated by the Contractor, for the purpose of scale verification.

2. Weigh a vehicle that weighs at least 10,000 pounds on a separate certified scale and then check the project scale with it.
3. Establish a certified fixed load weighing at least 10,000 pounds as a check-weight. The certification shall consist of an affidavit affirming the correct weight of the fixed load.

Should the scale verification check reveal a weight difference of more than 0.5 percent, a second scale verification check shall be performed immediately. If the weight differences of both comparison checks exceed the 0.5-percent limit and the scale has been overweighing, the Contractor shall immediately stop weighing and the scale shall be recertified at the Contractor's expense. If the weight difference of both comparison checks exceed the 0.5 percent limit and the scale is underweighing, it shall be adjusted immediately. Contractor will not be compensated for any loss from underweighing.

Belt Scales – To test the accuracy of a belt-conveyor scale, the Contractor shall weigh five or more payloads from sequential hauling units and compare these weights with weights of the same payloads taken on a separate certified platform scale. If the test results fluctuate, the Engineer may require more than five check loads. Conveyor weights will be based on tonnage values taken from the sealed odometer at the beginning and end of each check period.

If scale verification checks shows the scale has been under weighing, it shall be adjusted immediately. The Contractor shall not be compensated for any loss from under weighing.

If scale verification checks show the scale has been overweighing, its operation will cease immediately until adjusted.

Minor Construction Items – If the Specifications and Plans require weight measurement for minor construction items, the Contractor may request permission to convert volume to weight. If the Engineer approves, an agreed factor may be used to make this conversion and volume may be used to calculate the corresponding weight for payment.

1-09.2(6) Payment

Unless specified otherwise, the Contracting Agency will pay for no materials received by weight unless they have been weighed as required in this section or as required by another method the Engineer has approved in writing.

The Contractor shall not be compensated for any loss from underweighing that is revealed by scale verification checks.

If scale verification checks reveal that the scale is overweighing, then payment for all material weighed since the last valid scale verification check will be adjusted. The Contracting Agency will calculate the combined weight of all materials weighed after the last verification check showing accurate results. This combined weight will then be reduced for payment by the percentage of scale error that exceeds 0.5 percent unless the Contractor demonstrates to the satisfaction of the Engineer that the defect in the scale was present for a lesser period of time.

Unit Contract prices for the various pay items of the project cover all costs related to weighing and proportioning materials for payment. These costs include but are not limited to:

1. Furnishing, installing, certifying, and maintaining scales;
2. Providing a weigher to operate a Contractor-provided scale;
3. Providing a weigher to operate a commercial scale, if necessary;
4. Providing self-printing tickets, if necessary;
5. Rerouting a truck for verification weighing;
6. Assisting the Engineer with scale verification checks;
7. Any other related costs associated with meeting the requirements of this section.

1-09.3 Scope of Payment

The payment provided for in the Contract shall be full payment to the Contractor for:

1. Furnishing all materials and performing all Work under the Contract (including changes in the work, materials, or Plans) in a complete and acceptable manner;
2. All risk, loss, damage, or expense of whatever character arising out of the nature or prosecution of the work; and
3. All expense incurred resulting from a suspension or discontinuance of the Work as specified under the Contract.

The payment of any estimate or retained percentage shall not relieve the Contractor of the obligation to make good any defective Work or materials.

Unless the Plans and Special Provisions provide otherwise, the unit Contract prices for the various Bids items shall be full payment for all labor, materials, supplies, equipment, tools, and all other things required to completely incorporate the item into the Work as though the item were to read “In Place”.

If the “Payment” clause in the Specifications, for an item included in the Proposal, covers and considers all Work and material essential to that item, then the Work or materials will not be measured or paid for under any other item that may appear elsewhere in the Proposal or Specifications.

Certain payment items appearing in these Specifications may be modified in the Plans and Proposal to include:

1. The words “For Structure”, “For Concrete Barrier”, “For Bridge”, etc., with the intent of clarifying specific use of the item; or
2. The words “Site (Site Designation)”, with the intent of clarifying where a specific item of Work is to be performed.

Modification of payment items in this manner shall in no way change the intent of the Specifications relating to these items.

1-09.4 Equitable Adjustment

The equitable adjustment provided for elsewhere in the Contract shall be determined in one or more of the following ways:

1. If the parties are able to agree, the price will be determined by using:
   a. Unit prices; or
   b. Other agreed upon prices;
2. If the parties cannot agree, the price will be determined by the Engineer using:
   a. Unit prices; or
   b. Other means to establish costs.

The following limitations shall apply in determining the amount of the equitable adjustment:

1. The equipment rates shall be actual cost but shall not exceed the rates set forth in the AGC/WSDOT Equipment Rental Agreement in effect at the time the Work is performed as referred to in Section 1-09.6, and
2. To the extent any delay or failure of performance was concurrently caused by the Contracting Agency and the Contractor, the Contractor shall be entitled to a time extension for the portion of the delay or failure of performance concurrently caused, provided it make such a request pursuant to Section 1-08.8; however, the Contractor shall not be entitled to any adjustment in Contract price.
3. No claim for anticipated profits on deleted, terminated, or uncompleted Work will be allowed.
4. No claim for consequential damages of any kind will be allowed.

1-09.5 Deleted or Terminated Work

The Engineer may delete Work by change order as provided in Section 1-04.4 or may terminate the Contract in whole or part as provided in Section 1-08.10(2). When the Contract is terminated in part, the partial termination shall be treated as a deletion change order for payment purposes under this section.

Payment for completed items will be at unit Contract prices.

When any item is deleted in whole or in part by change order or when the Contract is terminated in whole or in part, payment for deleted or terminated Work will be made as follows:

1. Payment will be made for the actual number of units of Work completed at the unit Contract prices unless the Engineer determines the unit prices are inappropriate for the Work actually performed. When that determination is made by the Engineer, payment for Work performed will be as mutually agreed. If the parties cannot agree the Engineer will determine the amount of the equitable adjustment in accordance with Section 1-09.4;

2. Payment for partially completed lump sum items will be as mutually agreed. If the parties cannot agree, the Engineer will determine the amount of the equitable adjustment in accordance with Section 1-09.4;
3. To the extent not paid for by the Contract prices for the completed units of Work, the Contracting Agency will pay as part of the equitable adjustment those direct costs necessarily and actually incurred by the Contractor in anticipation of performing the Work that has been deleted or terminated;
4. The total payment for any one item in the case of a deletion or partial termination shall not exceed the Bid price as modified by approved change orders less the estimated cost (including overhead and profit) to complete the Work and less any amount paid to the Contractor for the item;
5. The total payment where the Contract is terminated in its entirety shall not exceed the total Contract price as modified by approved change orders less those amounts paid to the Contractor before the effective date of the termination; and
6. No claim for damages of any kind or for loss of anticipated profits on deleted or terminated Work will be allowed because of the termination or change order.

Contract time shall be adjusted as the parties agree. If the parties cannot agree, the Engineer will determine the equitable adjustment for Contract time.

Acceptable materials ordered by the Contractor prior to the date the Work was terminated as provided in Section 1-08.10(2) or deleted as provided in Section 1-04.4 by the Engineer, will either be purchased from the Contractor by the Contracting Agency at the actual cost and shall become the property of the Contracting Agency, or the Contracting Agency will reimburse the Contractor for the actual costs connected with returning these materials to the suppliers.

1-09.6 Force Account

The terms of the Contract or of a change order may call for Work or material to be paid for by force account. If so, then the objective of this Specification is to reimburse the Contractor for all costs associated with the Work, including costs of labor, small tools, supplies, equipment, specialized services, materials, applicable taxes and overhead and to include a profit commensurate with those costs. The amount to be paid shall be determined as described in this section.

1. **For Labor –** Labor reimbursement calculations shall be based on a “Project Labor List” (List) prepared and submitted by the Contractor and by any Subcontractor before that firm commences force account Work. Once a List is approved by the Engineer, it shall be used to calculate force account labor payment until a new List is submitted and approved. The Engineer may compare the List to payrolls and other documents and may, at any time, require the Contractor to submit a new List. The Contractor may submit a new List at any time without such a requirement. Prior payment calculations shall not be adjusted as a result of a new List.

To be approved, the List must be accurate and meet the requirements of this section. It shall include regular time and overtime rates for all employees (or work classifications) expected to participate in force account Work. The rates shall include the basic wage and fringe benefits, the current rates for Federal Insurance Compensation Act (FICA), Federal Unemployment Tax Act (FUTA) and State Unemployment Tax Act (SUTA), the company's present rates for Medical Aid and Industrial Insurance premiums and the planned payments for travel and per diem compensation.

In the event that an acceptable initial List or requested revised List is not received by the time that force account calculations are begun, the Engineer will develop a List unilaterally, utilizing the best data available, that will be used until a Contractor's List is received and approved. Again, prior calculations, prepared using the Engineer's List, will not be revised as a result of differences with the Contractor's List.

In addition to compensation for direct labor costs defined above, the Contracting Agency will pay Contractor 29 percent of the sum of the costs calculated for labor reimbursement to cover project overhead, general company overhead, profit, bonding, insurance required by Sections 1-07.10 and 1-07.18, Business & Occupation tax, and any other costs incurred, except paid sick leave. The Contracting Agency will pay the Contractor an additional 2 percent of the sum of the costs calculated for labor reimbursement to cover the cost of paid sick leave. This amount will include any costs of safety training and health tests, but will not include such costs for unique force account Work that is different from typical Work and which could not have been anticipated at time of Bid.

2. **For Materials –** The Contracting Agency will reimburse invoice cost for Contractor-supplied materials. For the purpose of this provision, "Materials" shall include those items incorporated into the Work, supplies used during the Work and items consumed. This cost shall include freight and handling charges and applicable taxes. Before Work is started, the Engineer may require the Contractor to obtain multiple quotations for the materials to be utilized and select the vendor with prices and terms most advantageous to the Contracting Agency.

   The Contracting Agency will provide a list of the types and quantities of Contractor-supplied materials witnessed by the Contracting Agency as being utilized in force account Work. The list will be furnished promptly after the material is incorporated, on a daily basis unless agreed otherwise. The Contractor may propose corrections to the list and will supply prices for the materials and other costs and return the list to the Contracting Agency. To support the prices, the Contractor shall attach valid copies of vendor invoices. If invoices are not available for materials from the Contractor's stocks, the Contractor shall certify actual costs (at a reasonable level) by affidavit. The Engineer will review the prices and any Contractor-proposed corrections and, if reasonable, approve the completed list. Once approved, the prices will be utilized in the calculation of force account reimbursement for materials.

   If, in the case of non-invoiced materials supported by Contractor affidavit, the price appears to be unreasonable, the Engineer will determine the cost for all or part of those materials, utilizing the best data available.

The Contracting Agency reserves the right to provide materials. In this case, the Contractor will receive no payment for any costs, overhead, or profit arising from the value of the materials themselves. Additional costs to handle and place the Agency-furnished material shall be compensated as described in this Specification.

In addition to compensation for direct materials cost, the Contracting Agency will pay the Contractor 21 percent of the sum of the costs calculated for materials reimbursement to cover project overhead, general company overhead, profit, bonding, insurance, required by Sections 1-07.10 and 1-07.18, Business & Occupation tax, and any other costs incurred.

3. **For Equipment –** The Contracting Agency will reimburse the Contractor for the cost of equipment utilized in the Work. The equipment provided by the Contractor shall be of modern design and in good working condition. For the purpose of this provision, "provided" shall mean that the equipment is owned (either through outright ownership or through a long-term lease) and operated by the Contractor or Subcontractor or that the equipment is rented and operated by the Contractor or Subcontractor. Equipment that is rented with operator shall not be included here, but shall be considered a service and addressed according to Subsection 4 of this provision.

   The amount of payment for any Contractor-owned equipment that is utilized shall be determined according to the version of the AGC/WSDOT Equipment Rental Agreement which is in effect at the time the force account is authorized. The rates listed in the Rental Rate Blue Book (as modified by the current AGC/WSDOT Equipment Rental Agreement) shall be full compensation for all fuel, oil, lubrication, ordinary repairs, maintenance, and all other costs incidental to furnishing and operating the equipment except labor for operation.

   Payment for rented equipment will be made on the basis of a valid invoice, covering the time period of the Work. Before Work is started, the Engineer may require the Contractor to obtain multiple quotations for the rental of equipment to be utilized and select the vendor with prices and terms most advantageous to the Contracting Agency. In the event that prior quotations are not obtained and the vendor is not a firm independent from the Contractor or Subcontractor, then after-the-fact quotations may be obtained by the Engineer from the open market in the vicinity and the lowest such quotation may be used in place of submitted invoice.

   In addition to the payments for Contractor-owned and rented equipment, one or more lump-sum payments may be made for small tools. The amount to be paid shall be determined as outlined in the AGC/WSDOT Equipment Rental Agreement.

   The Contracting Agency will add 21 percent to equipment costs to cover project overhead, general company overhead, profit, bonding, insurance, required by Sections 1-07.10 and 1-07.18, Business & Occupation tax, and any other costs incurred. This markup will be over and above those equipment costs and will not be adjusted for any equipment overhead amounts included in the Blue Book rates.

   Copies of the AGC/WSDOT Equipment Rental Agreement will be maintained on the Contracting Agency's website at www.wsdot.wa.gov.

4. **For Services –** Compensation under force account for specialized services shall be made on the basis of an invoice from the providing entity. A "specialized service" is a work operation that is not typically done by worker classifications as defined by the Washington State Department of Labor and Industries and by the Davis Bacon Act, and therefore bills by invoice for work in road, bridge and municipal construction. Before Work is started, the Engineer may require the Contractor to obtain multiple quotations for the service to be utilized and select the provider with prices and terms most advantageous to the Contracting Agency. In the event that prior quotations are not obtained and the service invoice is submitted by a Subcontractor, then after-the-fact quotations may be obtained by the Engineer from the open market in the vicinity and the lowest such quotation may be used in place of the submitted invoice.

   Except as noted below, the Contracting Agency will pay the Contractor an additional 21 percent of the sum of the costs included on invoices for specialized services to cover project overhead, general company overhead, profit, bonding, insurance, required by Sections 1-07.10 and 1-07.18, Business & Occupation tax, and any other costs incurred.

   When a supplier of services is compensated through invoice, but acts in the manner of a Subcontractor, as described in Subsection 6 of this provision, then markup for that invoice shall be according to Subsection 6, "Contractor Markup on Subcontractors' Work".

5. **For Mobilization –** Force account mobilization is defined as the preparatory Work performed by the Contractor including procurement, loading and transportation of tools and equipment, and personal travel time (when such travel time is a contractual obligation of the Contractor or a customary payment for the Contractor to all employees). Mobilization also includes the costs incurred during demobilization. Pro-rata adjustments may be made when the mobilization applies to both force account and other Contract Work. The Contracting Agency will pay for mobilization for off-site preparatory Work for force account items provided that notice has been provided sufficiently in advance to allow the Engineer to witness the activity, if desired.

   Any costs experienced during mobilization activities for labor, equipment, materials or services shall be listed in those sections of the force account summary and paid accordingly.

6. **For Contractor Markup on Subcontractor's Work –** When Work is performed on a force account basis by one or more approved Subcontractors, by lower-tier subcontractors or suppliers, or through invoice by firm(s) acting in the manner of a Subcontractor, the Contractor will be allowed an additional markup, from the table below, applied to the costs computed for Work done by each Subcontractor through Subsections 1, 2, 3, and 4, to compensate for all administrative costs, including project overhead, general company overhead, profit, bonding, insurance required by Sections 1-07.10 and 1-07.18, Business & Occupation tax, and any other costs incurred.

A firm may be considered to be acting as a Subcontractor when the Engineer observes one or more of the following characteristics:

a. The person in charge of the firm's activities takes an active role in managing the overall project, including extensive coordination, interpretation of Plans, interaction with the Contracting Agency or management of a complex and interrelated operation.

b. Rented equipment is provided fueled, operated and maintained by the firm. Operators of rented equipment are supervised directly by the firm's representative. There is little interaction between the Contractor and the employees of the firm.

c. The firm appears to be holding the risk of performance and quality of the Work.

d. The firm appears to be responsible for liability arising from the Work.

Markups on Work Performed by Subcontractor(s):

(1)	On amounts paid for Work performed by each Subcontractor on each force account and calculated through Subsections 1-4,	up to $25,000	12 percent
(2)	On amounts greater than	$25,000 up to $100,000	10 percent
(3)	On amounts greater than	$100,000	7 percent

The amounts and markup rates shall be calculated separately for each Subcontractor on each force account item established.

The payments provided above shall be full payment for all Work done on a force account basis. The calculated payment shall cover all expenses of every nature, kind, and description, including those listed above and any others incurred on the Work being paid through force account. Nothing in this provision shall preclude the Contractor from seeking an extension of time or time-related damages to unchanged Work arising as a result of the force account Work. The amount and costs of any Work to be paid by force account shall be computed by the Engineer, and the result shall be final as provided in Section 1-05.1.

An item that has been Bid at a unit price or lump sum in the Proposal will not be paid as force account unless:

1. A change as defined in Section 1-04.4 has occurred and the provisions require a payment adjustment.

2. A Contract item paid by force account requires Work that is normally included in a lump sum Contract item. In such a case, the Work normally included in a lump sum Contract item will be paid by force account under the force account Contract item.

Items which are included in the Proposal as Force Account or which are added by change order as Force Account may, by agreement of the parties at any time, be converted to agreed unit prices or lump sums applicable to the remaining Work.

1-09.7 Mobilization

Mobilization consists of preconstruction expenses and the costs of preparatory Work and operations performed by the Contractor which occur before 10 percent of the total original Contract amount is earned from other Contract items. Items which are not to be included in the item of Mobilization include but are not limited to:

1. Any portion of the Work covered by the specific Contract item or incidental Work which is to be included in a Contract item or items.
2. Profit, interest on borrowed money, overhead, or management costs.
3. Any costs of mobilizing equipment for force account Work.

Based on the lump sum Contract price for "Mobilization", partial payments will be made as follows:

1. When 5 percent of the total original Contract amount is earned from other Contract items, excluding amounts paid for materials on hand, 50 percent of the amount Bid for mobilization, or 5 percent of the total original Contract amount, whichever is the least, will be paid.
2. When 10 percent of the total original Contract amount is earned from other Contract items, excluding amounts paid for materials on hand, 100 percent of the amount Bid for mobilization, or 10 percent of the total original Contract amount, whichever is the least, will be paid.
3. When the Substantial Completion Date has been established for the project, payment of any amount Bid for mobilization in excess of 10 percent of the total original Contract amount will be paid.

Nothing herein shall be construed to limit or preclude partial payments otherwise provided by the Contract.

1-09.8 Payment for Material on Hand

The Contracting Agency may reimburse the Contractor for materials purchased before their use in the Work if they:

1. Meet the requirements of the Plans and Specifications;
2. Are delivered to or stockpiled near the project or other Engineer-approved storage sites; and
3. Consist of: sand, gravel, surfacing materials, aggregates, reinforcing steel, bronze plates, structural steel, machinery, piling, timber and lumber (not including forms or falsework), large signs unique to the project, prestressed concrete beams or girders, or other materials the Engineer may approve.

The Contracting Agency may reimburse the Contractor for traffic signal controllers as follows:

1. Fifty percent when the traffic signal controller and all components are received and assembled into a complete unit at the State Materials Laboratory.
2. One hundred percent when the traffic signal controller is approved for shipment to the project by the State Materials Laboratory.

The Contractor shall provide sufficient written evidence of production costs to enable the Engineer to compute the cost of Contractor-produced materials (such as sand, gravel, surfacing material, or aggregates). For other materials, the Contractor shall provide invoices from material suppliers. Each invoice shall be detailed sufficiently to enable the Engineer to determine the actual costs. Payment for materials on hand shall not exceed the total Contract cost for the Contract item.

If payment is based upon an unpaid invoice, the Contractor shall provide the Engineer with a paid invoice within 60 calendar days after the Contracting Agency's initial payment for materials on hand. If the paid invoice is not furnished in this time, any payment the Contracting Agency had made will be deducted from the next progress estimate and withheld until the paid invoice is supplied.

The Contracting Agency will not pay for material on hand when the invoice cost is less than $2,000. As materials are used in the Work, credits equaling the partial payments for them will be taken on future estimates. Partial payment for materials on hand shall not constitute acceptance. Any material will be rejected if found to be faulty even if partial payment for it has been made.

1-09.9 Payments

The basis of payment will be the actual quantities of Work performed according to the Contract and as specified for payment.

The Contractor shall submit a breakdown of the cost of lump sum Items to enable the Engineer to determine the Work performed on a monthly basis. Lump sum item breakdowns shall be submitted prior to the first progress payment that includes payment for the Bid Item in question. A breakdown is not required for lump sum Items that include a basis for incremental payments as part of the respective Specification. Absent a lump sum breakdown, the Engineer will make a determination based on information available. The Engineer's determination of the cost of Work shall be final.

Payments will be made for Work and labor performed and materials furnished under the Contract according to the price in the Proposal unless otherwise provided.

Partial payments will be made once each month, based upon partial estimates prepared by the Engineer. The determination of payments under the Contract will be final in accordance with Section 1-05.1. Unless otherwise provided, payments will be made from the Motor Vehicle Fund.

Failure to perform any of the obligations under the Contract by the Contractor may be decreed by the Contracting Agency to be adequate reason for withholding any payments until compliance is achieved.

Upon completion of all Work and after final inspection (Section 1-05.11), the amount due the Contractor under the Contract will be paid based upon the final estimate made by the Engineer and presentation of a Final Contract Voucher Certification signed by the Contractor. Such voucher shall be deemed a release of all claims of the Contractor unless a claim is filed in accordance with the requirements of Section 1-09.11 and is expressly excepted from the Contractor's certification on the Final Contract Voucher Certification. The date the Secretary signs the Final Contract Voucher Certification constitutes the final acceptance date (Section 1-05.12).

If the Contractor fails, refuses, or is unable to sign and return the Final Contract Voucher Certification or any other documentation required for completion and final acceptance of the Contract, the Contracting Agency reserves the right to establish a Completion Date (for the purpose of meeting the requirements of RCW 60.28) and unilaterally accept the Contract. Unilateral final acceptance will occur only after the Contractor has been provided the opportunity, by written request from the Engineer, to voluntarily submit such documents. If voluntary compliance is not achieved, formal notification of the impending establishment of a Completion Date and unilateral final acceptance will be provided by certified letter from the Secretary to the Contractor, which will provide 30 calendar days for the Contractor to submit the necessary documents. The 30 calendar day period will begin on the date the certified letter is received by the Contractor. The date the Secretary unilaterally signs the Final Contract Voucher Certification shall constitute the Completion Date and the final acceptance date (Section 1-05.12). The reservation by the Contracting Agency to unilaterally accept the Contract will apply to Contracts that are Physically Completed in accordance with Section 1-08.5, or for Contracts that are terminated in accordance with Section 1-08.10. Unilateral final acceptance of the Contract by the Contracting Agency does not in any way relieve the Contractor of their responsibility to comply with all Federal, State, tribal, or local laws, ordinances, and regulations that affect the Work under the Contract.

Payment to the Contractor of partial estimates, final estimates, and retained percentages shall be subject to controlling laws.

1-09.9(1) Retainage

Pursuant to RCW 60.28, a sum of 5 percent of the monies earned by the Contractor will be retained from progress estimates. Such retainage shall be used as a trust fund for the protection and payment (1) to the State with respect to taxes imposed pursuant to Title 82 RCW, and (2) the claims of any person arising under the Contract.

Monies retained under the provisions of RCW 60.28 shall, at the option of the Contractor, be:

1. Retained in a fund by the Contracting Agency; or

2. Deposited by the Contracting Agency in an escrow (interest-bearing) account in a bank, mutual saving bank, or savings and loan association (interest on monies so retained shall be paid to the Contractor). Deposits are to be in the name of the Contracting Agency and are not to be allowed to be withdrawn without the Contracting Agency's written authorization. The Contracting Agency will issue a check representing the sum of the monies reserved, payable to the bank or trust company. Such check shall be converted into bonds and securities chosen by the Contractor as the interest accrues.

At the time the Contract is executed the Contractor shall designate the option desired. The Contractor in choosing option (2) agrees to assume full responsibility to pay all costs that may accrue from escrow services, brokerage charges or both, and further agrees to assume all risks in connection with the investment of the retained percentages in securities. The Contracting Agency may also, at its option, accept a bond in lieu of retainage.

Release of the retainage will be made 60 days following the Completion Date (pursuant to RCW 39.12, and RCW 60.28) provided the following conditions are met:

1. On Contracts totaling more than $35,000, a release has been obtained from the Washington State Department of Revenue.
2. Affidavits of Wages Paid for the Contractor and all Subcontractors are on file with the Contracting Agency (RCW 39.12.040).
3. A certificate of Payment of Contributions Penalties and Interest on Public Works Contract is received from the Washington State Employment Security Department.
4. Washington State Department of Labor and Industries (in accordance with Section 1-07.10) shows the Contractor is current with payments of industrial insurance and medical aid premiums.
5. All claims, as provided by law, filed against the retainage have been resolved. In the event claims are filed and provided the conditions of 1, 2, 3, and 4 are met, the Contractor will be paid such retained percentage less an amount sufficient to pay any such claims together with a sum determined by the Contracting Agency sufficient to pay the cost of foreclosing on claims and to cover attorney's fees.

1-09.10 Payment for Surplus Processed Materials

After the Contract is completed, the Contractor will be reimbursed actual production costs for surplus processed material produced by the Contractor from Contracting Agency-provided sources if its value is $3,000 or more (determined by actual production costs).

The quantity of surplus material eligible for reimbursement of production costs shall be the quantity produced (but an amount not greater than 110 percent of Plan quantity or as specified by the Engineer), less the actual quantity used. For Hot Mix Asphalt, the Plan quantity and quantity used will be adjusted for the quantity of Asphalt and quantity of RAP or other materials incorporated into the mix. The Contracting Agency will determine the actual amount of surplus material for reimbursement.

The Contractor shall not dispose of any surplus material without permission of the Engineer. Surplus material shall remain the property of the Contracting Agency without reimbursement to the Contractor if it is not eligible for reimbursement.

1-09.11 Disputes and Claims

When protests occur during a Contract, the Contractor shall pursue resolution through the Engineer in accordance with Section 1-04.5. Unless noted otherwise in the specifications, compliance with all the requirements of Section 1-04.5 is a condition precedent to initiating any action pursuant to Section 1-09.11.

If the negotiations using the procedures outlined in Section 1-04.5 fail to provide satisfactory resolution of the protest, then the Contractor shall provide the Engineer with written notification of dispute stating that the Contractor will continue to pursue the dispute in accordance with the provisions of Section 1-09.11. The written notification of dispute shall be provided within 14 calendar days after receipt of the Engineer's written determination that the Contractor's protest is invalid pursuant to Section 1-04.5. Should the Contractor not provide written notification of dispute within the designated time period, the Contractor shall be deemed to have waived any right to pursue the protest further and the matter shall be considered resolved.

When the Proposal Form includes the Bid item "Disputes Review Board", unresolved protests shall be subject to the provisions of Section 1-09.11(1). Either party, Engineer or Contractor, may refer a matter in dispute to the Disputes Review Board. Compliance with the requirements of Section 1-09.11(1) is a condition precedent to any further right of the Contractor to pursue the dispute either by certified claim or litigation/arbitration.

When the Proposal Form does not include the Bid item "Disputes Review Board", the Contractor's written notification of dispute shall indicate whether the Contractor is requesting to resolve the dispute through the use of a Disputes Review Board as outlined in Section 1-09.11(1), or will submit a formal certified claim directly to the Engineer pursuant to Section 1-09.11(2). If the Contractor requests a Disputes Review Board, the Engineer will notify the Contractor in writing within 7 calendar days of receipt of the request whether the request is acceptable. If both parties to the dispute agree to use a Disputes Review Board, then a pay item "Disputes Review Board" will be added to the Contract by change order and the dispute will be subject to the provisions of Section 1-09.11(1). If the parties do not agree to establish a Disputes Review Board or the Contractor does not request a Disputes Review Board in its written notification of dispute, the Contractor shall comply with the provisions of Section 1-09.11(2).

Regardless of any protest or dispute, the Contractor shall proceed promptly with the Work as the Engineer orders.

1-09.11(1) Disputes Review Board

The procedures set forth in Section 1-09.11(1) shall only apply when the Contract includes the pay item "Disputes Review Board".

1-09.11(1)A Disputes Review Board - General

In order to assist in the resolution of dispute(s) between the Contracting Agency and the Contractor arising out of the work of this Contract, a Disputes Review Board, hereinafter called the "Board", will consider disputes referred to it and furnish written recommendations to the Contracting Agency and Contractor to assist in resolution of the dispute(s). The purpose of the Board response to such issues is to provide nonbinding findings and recommendations designed to expose the disputing parties to an independent view of the dispute.

1-09.11(1)B Disputes Eligible for Consideration by the Disputes Review Board

The Board shall consider and provide written recommendations concerning the following disputes:

1. Interpretation of the Contract.
2. Entitlement to additional compensation and/or time for completion.
3. Other subjects mutually agreed by the Contracting Agency and Contractor to be a Board issue.

1-09.11(1)C Board Member Qualifications

The following definitions apply for the purpose of setting forth experience and disclosure requirements for Board members.

Financial ties - any ownership interest, loans, receivables or payables.

Party directly involved - The Contracting Agency or Contractor of this Contract.

Party indirectly involved - The firms associated with the Contractor on this Contract, including joint venture partners, subcontractors of any tier, and suppliers; and firms associated with the Contractor or the Contracting Agency on this Contract, such as designers, architects, engineers, or other professional service firms or consultants.

The Board members shall:

1. Be experienced in the interpretation of construction contract documents.
2. Have attended training by the Dispute Resolution Board Foundation in dispute resolution within the last five years.
3. Be experienced in construction Contract dispute resolution for an owner or Contractor at the level of having responsibility and authority to settle disputes.
4. Be able to discharge their responsibilities impartially and independently, considering the facts and conditions related to the matters under consideration in strict compliance with the provisions of the Contract.

5. Not be a current employee of any party directly or indirectly involved.
6. Not have been an employee of any party directly or indirectly involved with the Project within a period of one year of the Contract Execution date.
7. Not have a financial interest in the Contract except for payments for services on the Board.

1-09.11(1)D Board Member Ongoing Responsibilities

While serving on the Disputes Review Board on this project:

1. Board members shall not participate in any discussion contemplating the creation of an agreement or making an agreement with any party directly or indirectly involved in the Contract regarding employment or fee-based consulting services, or any other business arrangement after the Contract is completed.
2. Board members shall not officially give any advice to either party. The individual members will act in a completely independent manner and will have no consulting or business connections with either party, except for payments for services on the Board.
3. During routine meetings of the Board as well as during formal hearings, Board members shall refrain from expressing opinions on the merits of statements on matters under dispute or potential dispute. Opinions of Board members expressed in private sessions with other Board members should be kept strictly confidential.
4. The Board shall comply with the terms of the Contract and enforce such terms consistent with the laws of the State of Washington. Board members shall not supplant or otherwise interfere with the respective rights, authorities, duties and obligations of the parties as defined in the Contract. In making its recommendations, the Board shall not make a recommendation that ignores, disregards, or undermines the intention, requirements, or allocation of risk, established by the Contract.
5. Throughout the life of the Contract, if Board members become aware of potential conflicts of interest, they shall be disclosed to the parties immediately.

1-09.11(1)E Establishment of the Board

The Contracting Agency and Contractor shall meet prior to the start of Contract time to jointly select three Board nominees. If the pay item, “Disputes Review Board” is added by change order, the Contracting Agency and Contractor shall meet to select Board nominees after the change order is processed.

The Contracting Agency and the Contractor shall provide to the Board nominees a list of the firms directly and indirectly involved with the Project, including, but not limited to designers, architects, engineers, professional service firms, consultants, JV partners, subcontractors and suppliers, along with a listing of key personnel of each.

Board nominees shall provide to the Contractor and Contracting Agency the following information within 21 calendar days of nomination. Board nominees that are included on the Washington State Department of Transportation "Statewide Prequalified DRB Candidate Roster" will not be required to submit resumes.

1. Resume showing:
   a. Full name and contact information
   b. Experience qualifying the person as a Board member as outlined in Section 1-09.11(1)C.
   c. Previous Board participation, if any. List each Board assignment separately, indicating the name and location of the project, approximate dates of Board service, name of Contracting Agency, name of Contractor, names of the other Board members and the approximate number of disputes heard. When previous Board experience is extensive, the list may be truncated at the prospective Board member's discretion.
2. Disclosure statement addressing the following:
   a. Previous or current direct employment by one of the parties directly or indirectly involved.
   b. Previous or current engagement as a consultant to any party directly or indirectly involved - by the prospective Board member or by the firm to which the prospective Board member is directly employed.
   c. Previous, current, or future financial ties to any of the parties directly or indirectly involved.
   d. Previous or current personal or professional relationships with a key member of any party directly or indirectly involved.
   e. Previous and current service as a Board member on projects where any of the parties directly or indirectly involved in this Contract were also involved.
   f. Any prior involvement in this project.

Within 14 calendar days of receiving the resumes and disclosure statements from the Board nominees, the Contracting Agency and the Contractor shall review and jointly agree on the final selection of the three members to serve on the Board. In the event that any of the three nominees are not acceptable to either party, the process shall be repeated until all positions are filled.

The Contracting Agency, the Contractor, and the Board shall execute the Three-Party Agreement using WSDOT Form 134-091 not later than the first Board meeting.

The Board shall determine and notify the parties which Board member will act as the Board chair.

1-09.11(1)E1 Disputes Review Board Candidates

The qualifications of some potential Board members have been reviewed and deemed potentially acceptable by the Washington State Department of Transportation. This list of potential Board members, Statewide Prequalified DRB Candidate Roster, is available from the WSDOT Headquarters Construction Office website at https://www.wsdot.wa.gov/business/construction/dispute-review-boards. Either party may propose a Board nominee that is not on the WSDOT list. In either case, Board nominees must comply with the requirements of Sections 1-09.11(1)C, 1-09.11(1)D, and 1-09.11(1)E, and every Board member must be deemed acceptable by both the Contracting Agency and the Contractor.

1-09.11(1)E2 Replacement or Termination of a Board Member

Procedures for terminating Board members are defined in The Three-Party Agreement.

1-09.11(1)F Disputes Review Board Procedures - General

The Board, Contracting Agency, and Contractor may mutually develop rules of operation of the Board that supplement the Three-Party Agreement. Such supplemental rules must be in writing and accepted by the Board, Contracting Agency, and Contractor.

The Board members shall act impartially and independently in the consideration of facts and conditions surrounding any dispute presented by the Contracting Agency or the Contractor and that the recommendations concerning any such dispute are advisory.

The Contracting Agency and the Contractor shall furnish to the Board documents in accordance with the Three-Party Agreement.

1-09.11(1)G Regular Disputes Review Board Meetings

All regular Board meetings will be held at or near the job site. The frequency of regular meetings will be set by mutual agreement of the Board, the Contracting Agency and the Contractor. Each regular meeting is expected to consist of a round table discussion and a field inspection of the project site. A member of the Contracting Agency and Contractor are expected to jointly facilitate the round table discussion. Round table discussion attendees are expected to include selected personnel from the Contracting Agency and the Contractor. The agenda for each meeting will be managed by the Board.

1-09.11(1)H Standard Procedure for Consideration of Disputes

1-09.11(1)H1 Dispute Referral

Disputes shall be referred in writing to the Board chair with a copy concurrently provided to the other Board members and the other party.

1. The dispute referral shall concisely define the nature and specifics of the dispute that is proposed to be considered by the Board and the scope of the recommendation requested. This referral is not expected to contain a mutually agreed upon statement of the dispute.

2. The Board chair shall confer with the parties to establish a briefing schedule for delivering prehearing submittals/rebuttals, and a date, time, and location for convening the Board for a hearing.

1-09.11(1)H2 Pre-Hearing Submittal

1. The Contracting Agency and the Contractor shall each prepare a pre-hearing submittal and transmit both a hard copy and an electronic copy of it to all three members of the Board and the other party. The pre-hearing submittal, comprising a position paper with such backup data as is referenced in the position paper, shall be tabbed, indexed, and the pages consecutively numbered.
2. Both position papers shall, at a minimum, contain the following:
   a. A mutually agreed upon joint statement of the dispute and the scope of the desired report being requested of the Board, placed at the beginning of the papers. The language of this joint statement shall summarize in a few sentences the nature of the dispute. If the parties are unable to agree on the wording of the joint statement of dispute, each party's position paper shall contain both statements, and identify the party authoring each statement.
   b. The basis and justification for the party's position, with reference to Contract language and other supporting documents for each element of the dispute. In order to minimize duplication and repetitiveness, the parties may identify a common set of documents that will be referred to by both parties, and submit them in a separate package.
3. If requested by the Board or either party, the Contracting Agency and the Contractor shall each prepare and submit a rebuttal paper in response the position paper of the other party.
4. The number of copies, distribution requirements, and time for submittal will be established by the Board and communicated to the parties by the Board chair.

1-09.11(1)H3 Disputes Review Board Hearings

1. The Contracting Agency will arrange for or provide hearing facilities at or near the project site.
2. Attendance:
   a. The Contracting Agency and the Contractor will have a representative at all hearings.
   b. The Contracting Agency and Contractor shall both limit attendance at the hearing to personnel directly involved in the dispute and participants in the good-faith negotiations that were conducted prior to submittal to the Board except as noted elsewhere in this section.
   c. At least 14 calendar days before the hearing, each party shall provide a list of proposed attendees to the Board and to the other party. In the event of any disagreement, the Board shall make the final determination as to who attends the hearing.

d. Attorneys shall not attend hearings except as follows:

i. Attorneys are identified as such on the list of proposed attendees;

ii. All parties desiring their attorney present are able to do so.

iii. Attorneys shall not participate in the hearing, unless the scope and extent of Attorney participation is mutually agreed to by the Contracting Agency, Contractor and the Board at least 7 calendar days before the hearing.

e. For hearings regarding disputes involving a Subcontractor, the Contractor shall require and ensure that each Subcontractor involved in the dispute have present an authorized representative with actual knowledge of the facts underlying the Subcontractor disputes.

3. A party furnishing written evidence or documentation of any kind to the Board must furnish copies of such information to the other party and the Board a minimum of 21 calendar days prior to the date the Board sets to convene the hearing for the dispute, unless otherwise mutually agreed to by the parties and the Board. Either party shall produce such additional evidence as the Board may deem necessary and furnish copies to the other party prior to submittal to the Board.

4. The conduct of the hearing shall be established by the Board and be generally consistent with the following guidelines:

a. The party who referred the dispute to the Board shall present first, followed by the other party.

b. To assure each party a full and adequate opportunity to present their position, both parties shall be allowed successive rebuttals and to rebut the opposing party's position until, in the Board's opinion, all aspects of the dispute have been fully and fairly covered.

c. The Board shall be fully prepared to, and may at any time, ask questions, request clarifications, or ask for additional data, documents, and/or job records.

d. Either party may request that the Board direct a question to, or request a clarification from the other party. The Board shall determine at what point in the proceedings such requests may be made and if they will be granted. In general, the Board will not allow one party to be questioned directly by the other party.

e. In difficult or complex cases, additional hearings may be necessary to facilitate full consideration and understanding of the dispute.

f. The Board, in its discretion, may allow introduction of arguments, exhibits, handouts, or documentary evidence that were not included in that party's prehearing position paper or rebuttal and have not been previously submitted to the other party. In such cases the other party will be granted time to review and prepare a rebuttal to the new material, which may require a continuation of the hearing.

5. After the hearing is concluded, the Board shall meet in private and reach a conclusion supported by two or more members. Its findings and recommendations, together with its reasons shall then be submitted as a written report to both parties. The recommendations shall be based on the pertinent Contract provisions, facts, and circumstances involved in the dispute. The Contract shall be interpreted and construed in accordance with the laws of the State of Washington.

1-09.11(1)H4 Failure to Prepare a Pre-Hearing Submittal or Attend a Hearing

In the event that either party fails to deliver a pre-hearing submittal by the date established by the Board, the Board shall, at its discretion, determine whether the hearing shall proceed as originally scheduled, or allow additional time for the submittal and/or reschedule the hearing. On the final date and time established for the hearing, the Board shall proceed with the hearing utilizing the information that has been submitted.

In the event that representatives of either the Contracting Agency or the Contractor fail to appear at the appointed time of a hearing, the Board shall postpone the hearing until such time as representatives from both parties are available to proceed with the hearing.

1-09.11(1)H5 Use of Outside Experts

1. By the Contracting Agency or the Contractor:
   a. A party intending to offer an outside expert's analysis at the hearing shall notify the other party and the Board in writing no less than 30 calendar days prior to the due date for delivering the pre-hearing submittal, and provide the following disclosure:
      i. The expert's name and a general statement of the area of the dispute that will be covered by his or her testimony.
      ii. A statement prepared by the proposed expert which addresses the requirements of Section 1-09.11(1)E, item 2.
      iii. A statement prepared by the proposed expert which identifies the experience and training which qualifies them as an expert.
   b. Upon receipt of the disclosure, the other party shall have the opportunity to secure the services of an outside expert to address or respond to those issues that may be raised by the other party's outside expert. The notification and disclosure requirement shall be the same as that specified elsewhere in this section, except the time requirement is 21 calendar days.
2. By the Board:
   a. When requested by the Board and subject to approval of the parties, outside experts may be needed to assist the Board. In such cases, the outside expert shall in no way be deemed authorized to usurp the Board's authority to issue the Board recommendations. Such authority shall remain vested solely in the Board.

b. Prior to arranging for outside experts, the Board shall obtain prior approval from the Contracting Agency and the Contractor by providing:

i. A statement explaining why the expert assistance is needed.

ii. An estimate of the cost of the expert assistance.

iii. The expert's name and a general statement of the area of expertise they will provide.

iv. A statement prepared by the proposed expert which addresses the requirements of Section 1-09.11(1)E, item 2.

v. A statement prepared by the proposed expert which identifies the experience and training which qualifies them as an expert.

vi. A confidentiality statement, consistent with the confidentiality obligations of the Board described in the Three Party Agreement, executed by the proposed expert.

1-09.11(1)H6 Disputes Review Board Report

The Board's recommendations shall be formalized in a written report signed by all Board members. The recommendations shall be based on the Contract Provisions and the facts and circumstances involved in the dispute. The report should include a description of the dispute, statements of each party's position, findings as to the facts of the dispute, discussion and rationale for the recommendation(s), and the recommendation(s). The report shall be submitted concurrently to the parties, as soon as possible after completion of the hearing as agreed by all parties.

Either party may request clarification of a report within 14 calendar days following receipt of the report. Within a reasonable period of time, the Board shall provide written clarification to both parties. Requests for clarification shall be submitted in writing simultaneously to the Board and the other party.

Either party may request reconsideration of a report, provided:

1. The request is made within 14 calendar days following receipt of the report, and
2. New information is obtained or developed that was not known at the time of the hearing or, in the party's opinion, the Board misunderstood or failed to consider pertinent facts of the dispute.

Requests for reconsideration shall be submitted in writing simultaneously to the Board and the other party. The Board shall give the party not requesting reconsideration the option of submitting a rebuttal to any information that is the basis of the request for reconsideration. The Board shall provide a written response to the request for reconsideration.

1-09.11(1)H7 Acceptance of Disputes Review Board Recommendations

Within 30 calendar days of receiving the Board's report, or within 14 calendar days of receiving the Board's written clarification and/or reconsideration, both the Contracting Agency and the Contractor shall respond to the other in writing signifying that the dispute is either resolved or remains unresolved. Although both parties should place weight upon the Board recommendations, the recommendations are not binding.

If the Board's assistance does not lead to resolution of the dispute, the Contractor must file a claim according to Section 1-09.11(2) before seeking any form of judicial relief.

In the event the Board's recommendations do not lead to resolution of the dispute, the Board's recommendation consisting solely of the Board's written report and any written minority reports, along with the Board's written clarifications and written responses to requests for reconsideration, if any, will be admissible in any subsequent dispute resolution proceedings including, but not limited to litigation/arbitration. The aforementioned list of documentation shall be considered all inclusive.

1-09.11(1)I Vacant

1-09.11(1)J Payment for the Disputes Review Board

The Contracting Agency and Contractor shall share equally in the cost of the Board's services and all operating expenses of the Board. The Board members' compensation shall be in accordance with the Three Party Agreement. After the Contractor and Contracting Agency review invoices from the Board and other operating expenses of the Board, the Contractor shall make full payment for all Board members and Board operating payments, under the pay item "Disputes Review Board".

The Contractor and the Contracting Agency shall equally bear the cost of the services of the outside expert hired to advise the Board. Outside experts hired to advise the Board shall Contract directly with the Contractor after concurrence from the Board and approval from the Contracting Agency. Invoices for these services shall be submitted by the expert to both the Contractor and Contracting Agency for approval by both parties. The Contractor shall pay approved invoices in full, and the Contracting Agency will reimburse the Contractor for fifty percent of such payments, under the Bid item "Disputes Review Board".

The cost for securing outside expert services for the Contracting Agency or the Contractor shall be borne by the party securing such services.

The Contracting Agency will provide administrative services, such as conference facilities and copying services, to the Board and the Contracting Agency will bear the costs for these services.

1-09.11(1)K Indemnification of Disputes Review Board Members

The Contracting Agency and Contractor shall indemnify and hold harmless the Board members from and against all claims, damages, losses and expenses, including but not limited to attorney's fees arising out of and resulting from the actions and recommendations of the Board.

1-09.11(2) Claims

If the Contractor claims that additional payment is due and the Contractor has pursued and exhausted all the means provided in Sections 1-04.5 and 1-09.11(1) to resolve a dispute, including the use of a Disputes Review Board if one was established, the Contractor may file a claim as provided in this section. The Contractor agrees to waive any claim for additional payment if the written notifications provided in Section 1-04.5 are not given, or if the Engineer is not afforded reasonable access by the Contractor to complete records of actual cost and additional time incurred as required by Section 1-04.5, or if a claim is not filed as provided in this section. The fact that the Contractor has provided a proper notification, provided a properly filed claim, or provided the Engineer access to records of actual cost, shall not in any way be construed as proving or substantiating the validity of the claim. If the claim, after consideration by the Engineer, is found to have merit, the Engineer will make an equitable adjustment either in the amount of costs to be paid or in the time required for the Work, or both. If the Engineer finds the claim to be without merit, no adjustment will be made.

All claims filed by the Contractor shall be in writing and in sufficient detail to enable the Engineer to ascertain the basis and amount of the claim. All claims shall be submitted to the Engineer as provided in Section 1-05.15. As a minimum, the following information must accompany each claim submitted:

1. A detailed factual statement of the claim for additional compensation and time, if any, providing all necessary dates, locations, and items of Work affected by the claim.
2. The date on which facts arose which gave rise to the claim.
3. The name of each Contracting Agency individual, official, or employee involved in or knowledgeable about the claim.
4. The specific provisions of the Contract which support the claim and a statement of the reasons why such provisions support the claim.
5. If the claim relates to a decision of the Engineer which the Contract leaves to the Engineer's discretion or as to which the Contract provides that the Engineer's decision is final, the Contractor shall set out in detail all facts supporting its position relating to the decision of the Engineer.
6. The identification of any documents and the substance of any oral communications that support the claim.

7. Copies of any identified documents, other than Contracting Agency documents and documents previously furnished to the Contracting Agency by the Contractor, that support the claim (manuals which are standard to the industry, used by the Contractor, may be included by reference).
8. If an extension of time is sought:
    a. The specific days and dates for which it is sought,
    b. The specific reasons the Contractor believes a time extension should be granted,
    c. The specific provisions of Section 1-08.8 under which it is sought, and
    d. The Contractor's analysis of its progress schedule to demonstrate the reason for a time extension.
9. If additional compensation is sought, the exact amount sought and a breakdown of that amount into the following categories:
    a. Labor;
    b. Materials;
    c. Direct equipment. The actual cost for each piece of equipment for which a claim is made or in the absence of actual cost, the rates established by the AGC/WSDOT Equipment Rental Agreement which was in effect when the Work was performed. In no case shall the amounts claimed for each piece of equipment exceed the rates established by that Equipment Rental Agreement even if the actual cost for such equipment is higher. The Contracting Agency may audit the Contractor's cost records as provided in Section 1-09.12 to determine actual equipment cost. The following information shall be provided for each piece of equipment:
        (1) Detailed description (e.g., Motor Grader Diesel Powered Caterpillar 12 "G", Tractor Crawler ROPS & Dozer Included Diesel);
        (2) The hours of use or standby; and
        (3) The specific day and dates of use or standby;
    d. Job overhead;
    e. Overhead (general and administrative);
    f. Subcontractor's claims (in the same level of detail as specified herein is required for any Subcontractor's claims); and
    g. Other categories as specified by the Contractor or the Contracting Agency.

10. A notarized statement shall be submitted to the Engineer containing the following language:

    Under the penalty of law for perjury or falsification, the undersigned,

    _____, _____
    (name) (title)

    of _____
    (company)

    hereby certifies that the claim for extra compensation and time, if any, made herein for Work on this Contract is a true statement of the actual costs incurred and time sought, and is fully documented and supported under the Contract between the parties.

    Dated _____/s/_____

    Subscribed and sworn before me this _____ day of _____

    _____
    Notary Public

    My Commission Expires:_____

It will be the responsibility of the Contractor to keep full and complete records of the costs and additional time incurred for any alleged claim. The Contractor shall permit the Engineer to have access to those records and any other records as may be required by the Engineer to determine the facts or contentions involved in the claim. The Contractor shall retain those records for a period of not less than three years after final acceptance.

The Contractor shall pursue administrative resolution of any claim with the Engineer or the designee of the Engineer.

Failure to submit with the Final Contract Voucher Certification such information and details as described in this section for any claim shall operate as a waiver of the claims by the Contractor as provided in Section 1-09.9.

Provided that the Contractor is in full compliance with all the provisions of this section and after the formal claim document has been submitted, the Contracting Agency will respond, in writing, to the Contractor as follows:

1. Within 45 calendar days from the date the claim is received by the Contracting Agency if the claim amount is less than $100,000;
2. Within 90 calendar days from the date the claim is received by the Contracting Agency if the claim amount is equal to or greater than $100,000; or

3. If the above restraints are unreasonable due to the complexity of the claim under consideration, the Contractor will be notified within 15 calendar days from the date the claim is received by the Contracting Agency as to the amount of time which will be necessary for the Contracting Agency to prepare its response.

Full compliance by the Contractor with the provisions of this section is a contractual condition precedent to the Contractor's right to seek judicial relief.

1-09.11(3) Time Limitation and Jurisdiction

For the convenience of the parties to the Contract it is mutually agreed by the parties that any claims or causes of action which the Contractor has against the State of Washington arising from the Contract shall be brought within 180 calendar days from the date of final acceptance (Section 1-05.12) of the Contract by the State of Washington; and it is further agreed that any such claims or causes of action shall be brought only in the Superior Court of Thurston County. The parties understand and agree that the Contractor's failure to bring suit within the time period provided, shall be a complete bar to any such claims or causes of action. It is further mutually agreed by the parties that when any claims or causes of action which the Contractor asserts against the State of Washington arising from the Contract are filed with the State or initiated in court, the Contractor shall permit the State to have timely access to any records deemed necessary by the State to assist in evaluating the claims or action.

1-09.12 Audits

1-09.12(1) General

The Contractor's wage, payroll, and cost records on this Contract shall be open to inspection or audit by representatives of the Contracting Agency during the life of the Contract and for a period of not less than 3 years after the date of final acceptance of the Contract. The Contractor shall retain these records for that period. The Contractor shall also guarantee that the wage, payroll, and cost records of all Subcontractors and all lower tier Subcontractors shall be retained and open to similar inspection or audit for the same period of time. The audit may be performed by employees of the Contracting Agency or by an auditor under contract with the Contracting Agency. The Contractor, Subcontractors, or lower tier subcontractors shall provide adequate facilities, acceptable to the Engineer, for the audit during normal business hours. The Contractor, Subcontractors, or lower tier subcontractors shall make a good faith effort to cooperate with the auditors. If an audit is to be commenced more than 60 calendar days after the final acceptance date of the Contract, the Contractor will be given 20 calendar days notice of the time when the audit is to begin. If any litigation, claim, or audit arising out of, in connection with, or related to this Contract is initiated, the wage, payroll, and cost records shall be retained until such litigation, claim, or audit involving the records is completed.

1-09.12(2) Claims

All claims filed against the Contracting Agency shall be subject to audit at any time following the filing of the claim. Failure of the Contractor, Subcontractors, or lower tier subcontractors to maintain and retain sufficient records to allow the auditors to verify all or a portion of the claim or to permit the auditor access to the books and records of the Contractor, Subcontractors, or lower tier subcontractors shall constitute a waiver of a claim and shall bar any recovery thereunder.

1-09.12(3) Required Documents for Audits

As a minimum, the auditors shall have available to them the following documents:

1. Daily time sheets and supervisor's daily reports.
2. Collective Bargaining Agreements.
3. Insurance, welfare, and benefits records.
4. Payroll registers.
5. Earnings records.
6. Payroll tax forms.
7. Material invoices and requisitions.
8. Material cost distribution worksheet.
9. Equipment records (list of company equipment, rates, etc.).
10. Vendors', rental agencies', Subcontractors', and lower tier subcontractors' invoices.
11. Contracts between the Contractor and each of its Subcontractors, and all lower-tier subcontractor contracts and supplier contracts.
12. Subcontractors' and lower tier subcontractors' payment certificates.
13. Canceled checks (payroll and vendors).
14. Job cost reports, including monthly totals.
15. Job payroll ledger.
16. General ledger.
17. Cash disbursements journal.
18. Financial statements for all years reflecting the operations on this Contract. In addition, the Contracting Agency may require, if it deems appropriate, additional financial statements for 3 years preceding execution of the Contract and 3 years following final acceptance of the Contract.
19. Depreciation records on all company equipment whether these records are maintained by the company involved, its accountant, or others.
20. If a source other than depreciation records is used to develop costs for the Contractor's internal purposes in establishing the actual cost of owning and operating equipment, all such other source documents.

21. All documents which relate to each and every claim together with all documents which support the amount of damages as to each claim.
22. Worksheets or software used to prepare the claim establishing the cost components for items of the claim including but not limited to labor, benefits and insurance, materials, equipment, Subcontractors, all documents which establish the time periods, individuals involved, the hours for the individuals, and the rates for the individuals.
23. Worksheets, software, and all other documents used by the Contractor to prepare its Bid.

An audit may be performed by employees of the Contracting Agency or a representative of the Contracting Agency. The Contractor and its Subcontractors shall provide adequate facilities acceptable to the Contracting Agency for the audit during normal business hours. The Contractor and all Subcontractors shall cooperate with the Contracting Agency's auditors.

1-09.13 Claims Resolution

1-09.13(1) General

Prior to seeking claim resolution through nonbinding alternative dispute resolution processes, binding arbitration, or litigation, the Contractor shall proceed under the administrative procedures in Sections 1-04.5 and 1-09.11, and any Special Provision provided in the Contract for resolution of disputes. The provisions of these sections must be complied with in full, as a condition precedent to the Contractor's right to seek claim resolution through any nonbinding alternative dispute resolution process, binding arbitration or litigation.

1-09.13(2) Nonbinding Alternative Disputes Resolution (ADR)

Nonbinding ADR processes are encouraged and available upon mutual agreement of the Contractor and the Contracting Agency for all claims submitted in accordance with Section 1-09.11, provided that:

1. All the administrative remedies provided for in the Contract have been exhausted;
2. The Contracting Agency has been given the time and opportunity to respond to the Contractor as provided in Section 1-09.11(2); and
3. The Contracting Agency has determined that it has sufficient information concerning the Contractor's claims to participate in a nonbinding ADR process.

The Contracting Agency and the Contractor mutually agree that the cost of the nonbinding ADR process shall be shared equally by both parties with each party bearing its own preparation costs.

The type of nonbinding ADR process shall be agreed upon by the parties and shall be conducted within the State of Washington at a location mutually acceptable to the parties.

The Contractor agrees that the participation in a nonbinding ADR process does not in any way waive the requirement that binding arbitration or litigation proceedings must commence within 180 calendar days of final acceptance of the Contract, the same as any other claim or causes of action as provided in Section 1-09.11(3).

1-09.13(3) Claims $250,000 or Less

The Contractor and the Contracting Agency mutually agree that those claims which total $250,000 or less, submitted in accordance with Section 1-09.11 and not resolved by nonbinding ADR processes, shall be resolved through mandatory and binding arbitration as described herein.

1-09.13(3)A Administration of Arbitration

Arbitration shall be as agreed by the parties or, if the parties cannot agree, arbitration shall be administered through the American Arbitration Association (AAA) using the following arbitration methods:

1. The current version of the Construction Industry Arbitration Rules and Mediation *Fast Track Procedures* shall be used for claims with an amount less than $75,000.
2. The current version of the Construction Industry Arbitration Rules and Mediation *Regular Track Procedures* shall be used for claims with an amount equal to or greater than $75,000 and less than $250,000.

The Contracting Agency and the Contractor mutually agree the venue of any arbitration hearing shall be within the State of Washington and any such hearing shall be conducted within the State of Washington.

The Contracting Agency and the Contractor mutually agree to be bound by the decision of the arbitrator, and judgment upon the award rendered by the arbitrator may be entered in the Superior Court of Thurston County. The decision of the arbitrator and the specific basis for the decision shall be in writing. The arbitrator shall use the Contract as a basis for decisions.

1-09.13(3)B Procedures to Pursue Arbitration

If the dispute cannot be resolved through administrative procedures provided in Sections 1-04.5 and 1-09.11, and any Special Provision provided in the Contract for resolution of disputes or through a mutually agreed upon nonbinding ADR process, the Contractor shall advise the Engineer, in writing, that mandatory and binding arbitration is desired. The parties may agree on an arbitration process, or, if the parties cannot agree a demand for arbitration shall be filed by the Contractor, in accordance with the AAA rules, with the Contracting Agency, and with the AAA. Selection of the arbitrator and the administration of the arbitration shall proceed in accordance with AAA rules using arbitrators from the list developed by the AAA, except that: for claims under $25,000 using the Northwest Region Expedited Commercial Arbitration Rules, arbitration selection shall proceed pursuant to Section 55 of the Expedited Procedure of the Construction Industry Arbitration Rules. Arbitration shall proceed utilizing the appropriate rule of the AAA as determined by the dollar amount of the claim as provided in Section 1-09.13(3)A.

Unresolved disputes which do not involve delays or impacts to unchanged Work may be brought to binding arbitration prior to Physical Completion of the project, provided that:

1. All the administrative remedies provided for in the Contract have been exhausted;
2. The dispute has been pursued to the claim status as provided in Section 1-09.11(2); and
3. The Contractor certifies in writing that claims for delays or impacts to the Work will not result from the dispute.

Unless the Contracting Agency and the Contractor agree otherwise, all other unresolved claims (disputes which have been pursued to the claim status) which arise from a Contract must be brought in a single arbitration hearing and only after Physical Completion of the Contract. The total of those unresolved claims cannot be greater than $250,000 to be eligible for arbitration.

In addition, the Contractor agrees arbitration proceedings must commence, by filing of the aforementioned demand for arbitration, within 180 calendar days of final acceptance of the contract, the same as any other claim or causes of action as provided in Section 1-09.11(3).

The scope and extent of discovery shall be determined by the arbitrator in accordance with AAA rules. In addition, each party for claims greater than $25,000 shall serve upon the other party a "statement of proof". The statement of proof shall be served, with a copy to the AAA, no less than 20 calendar days prior to the arbitration hearing and shall include:

1. The identity, current business address, and residential address of each witness who will testify at the hearing;
2. The identity of a witness as an expert if an expert witness is to be called, a statement as to the subject matter and the substance of the facts and opinions on which the expert is expected to testify, a summary of the grounds for each opinion, and a resume of the expert's qualifications; and
3. A list of each document that the party intends to offer in evidence at the arbitration hearing. Either party may request from the other party a copy of any document listed. If such a request is made, a copy of the document shall be provided within 5 calendar days from the date the request is received.

The arbitrator may permit a party to call a witness or offer a document not shown or included in the statement of proof only upon a showing of good cause.

1-09.13(4) Claims in Excess of $250,000

The Contractor and the Contracting Agency mutually agree that those claims in excess of $250,000, submitted in accordance with Section 1-09.11 and not resolved by nonbinding ADR processes, shall be resolved through litigation unless the parties mutually agree to resolve the claim through binding arbitration.

1-10 Temporary Traffic Control

1-10.1 General

Temporary traffic control refers to the control of all types of traffic, including vehicles, bicyclists, and pedestrians (including pedestrians with disabilities). The Contractor, utilizing contractor labor and contractor-provided equipment and materials (except when such labor, equipment, or materials are to be provided by the Contracting Agency as specifically identified herein), shall plan, manage, supervise, and perform all temporary traffic control activities needed to support the Work of the Contract.

1-10.1(1) Materials

Materials shall meet the requirements of the following Sections:

Stop/Slow Paddles	9-35.1
Construction Signs	9-35.2
Wood Sign Posts	9-35.3
Sequential Arrow Signs	9-35.4
Portable Changeable Message Signs	9-35.5
Barricades	9-35.6
Traffic Safety Drums	9-35.7
Traffic Cones	9-35.9
Tubular Markers	9-35.10
Warning Lights and Flashers	9-35.11
Transportable Attenuator	9-35.12
Tall Channelizing Devices	9-35.13
Portable Temporary Traffic Control Signal	9-35.14

1-10.1(2) Description

The Contractor shall provide flaggers and all other personnel required for labor for traffic control activities that are not otherwise specified as being furnished by the Contracting Agency.

The Contractor shall perform all procedures necessary to support the Contract Work.

Unless otherwise permitted by the Contract or approved by the Engineer, the Contractor shall keep all existing pedestrian routes and access points (including sidewalks, paths, and crosswalks) open and clear at all times.

The Contractor shall keep lanes, on-ramps, and off-ramps, open to traffic at all times except when Work requires closures. Ramps shall not be closed on consecutive interchanges at the same time, unless approved by the Engineer. Lanes and ramps shall be closed for the minimum time required to complete the Work. When paving hot mix asphalt the Contractor may apply water to the pavement to shorten the time required before reopening to traffic.

The Contractor shall provide signs and other traffic control devices not otherwise specified as being furnished by the Contracting Agency. The Contractor shall erect and maintain all construction signs, warning signs, detour signs, and other traffic control devices necessary to warn and protect the public at all times from injury or damage as a result of the Contractor's operations, which may occur on or adjacent to Highways, roads, streets, sidewalks, or paths. No Work shall be done on or adjacent to any Traveled Way until all necessary signs and traffic control devices are in place.

The traffic control resources and activities described shall be used for the safety of the public, of the Contractor's employees, and of the Contracting Agency's personnel and to facilitate the movement of the traveling public. Traffic control resources and activities may be used for the separation or merging of public and construction traffic when such use is in accordance with a specific approved traffic control plan.

Upon failure of the Contractor to immediately provide flaggers; erect, maintain, and remove signs; or provide, erect, maintain, and remove other traffic control devices when ordered to do so by the Engineer, the Contracting Agency may, without further notice to the Contractor or the Surety, perform any of the above and deduct all of the costs from the Contractor's payments.

The Contractor shall be responsible for providing adequate labor, sufficient signs, and other traffic control devices, and for performing traffic control procedures needed for the protection of the Work and the public at all times regardless of whether or not the labor, devices or procedures have been ordered by the Engineer, furnished by the Contracting Agency, or paid for by the Contracting Agency.

Wherever possible when performing Contract Work, the Contractor's equipment shall follow normal and legal traffic movements. The Contractor's ingress and egress of the Work area shall be accomplished with as little disruption to traffic as possible. Traffic control devices shall be removed by picking up the devices in a reverse sequence to that used for installation. This may require moving backwards through the work zone. When located behind barrier or at other locations shown on approved traffic control plans, equipment may operate in a direction opposite to adjacent traffic.

The Contractor is advised that the Contracting Agency may have entered into operating agreements with one or more law enforcement organizations for cooperative activities. Under such agreements, at the sole discretion of the Contracting Agency, law enforcement personnel may enter the work zone for enforcement purposes and may participate in the Contractor's traffic control activities. The responsibility under the Contract for all traffic control resides with the Contractor and any such participation by law enforcement personnel in Contractor traffic control activities will be referenced in the Special Provisions or will be preceded by an agreement and, if appropriate, a cost adjustment. Nothing in this Contract is intended to create an entitlement, on the part of the Contractor, to the services or participation of the law enforcement organization.

1-10.2 Traffic Control Management

1-10.2(1) General

It is the Contractor's responsibility to plan, conduct, and safely perform the Work. The Contractor shall manage temporary traffic control with his or her own staff. Traffic control management responsibilities shall be formally assigned to one or more company supervisors who are actively involved in the planning and management of field Contract activities. The Contractor shall provide the Engineer with a copy of the formal assignment. The duties of traffic control management may not be subcontracted.

The Contractor shall designate an individual or individuals to perform the duties of the primary Traffic Control Supervisor (TCS). The designation shall also identify an alternate TCS who can assume the duties of the primary TCS in the event of that person's inability to perform. The TCS shall be responsible for safe implementation of approved Traffic Control Plans provided by the Contractor.

The primary and alternate TCS shall be certified by one of the organizations listed in the Special Provisions. Possession of a current Washington State TCS card and flagging card by the primary and alternate TCS is mandatory. A traffic control management assignment and a TCS designation are required on all projects that will utilize traffic control.

The Contractor shall maintain 24-hour telephone numbers at which the Contractor's assigned traffic control management personnel and the TCS can be contacted and be available upon the Engineer's request at other than normal working hours. These persons shall have the resources, ability and authority to expeditiously correct any deficiency in the traffic control system.

1-10.2(1)A Traffic Control Management

The responsibilities of the Contractor's traffic control management personnel shall include:

1. Overseeing and approving the actions of the Traffic Control Supervisor (TCS) to ensure that proper safety and traffic control measures are implemented and consistent with the specific requirements created by the Contractor's work zones and the Contract. Some form of oversight shall be in place and effective even when the traffic control management personnel are not present at the jobsite.
2. Providing the Contractor's designated TCS with approved Traffic Control Plans (TCPs) which are compatible with the Work operations and traffic control for which they will be implemented. Having the latest adopted edition of the *Manual on Uniform Traffic Control Devices for Streets and Highways* (MUTCD), including the *Washington State Modifications to the MUTCD* M 24-01 the most current edition of the *Public Rights-of-Way Accessibility Guidelines* (PROWAG), which can be downloaded from the United States Access Board website at www.access-board.gov/prowac under Revised Draft Guidelines (2005), and applicable standards and Specifications available at all times on the project.

3. Discussing proposed traffic control measures and coordinating implementation of the Contractor-adopted traffic control plan(s) with the Engineer.
4. Coordinating all traffic control operations, including those of Subcontractors and suppliers, with each other and with any adjacent construction or maintenance operations.
5. Coordinating the project's activities (such as ramp closures, road closures, and lane closures) with appropriate police, fire control agencies, city or county engineering, medical emergency agencies, school districts, and transit companies.
6. Overseeing all requirements of the Contract that contribute to the convenience, safety, and orderly movement of vehicular and pedestrian traffic.
7. Reviewing the TCS's diaries daily and being aware of field traffic control operations.
8. Being present on-site a sufficient amount of time to adequately satisfy the above-listed responsibilities.

Failure to carry out any of the above-listed responsibilities shall be a failure to comply with the Contract and may result in a suspension of Work as described in Section 1-08.6.

1-10.2(1)B Traffic Control Supervisor

A Traffic Control Supervisor (TCS) shall be present on the project whenever flagging or other traffic control labor is being utilized or less frequently, as authorized by the Engineer.

The TCS shall personally perform all the duties of the TCS. During nonwork periods, the TCS shall be available to the job site within a 45-minute time period after notification by the Engineer.

The TCS's duties shall include:

1. Having a current set of approved traffic control plans (TCPs), applicable Contract Provisions as provided by the Contractor, the latest adopted edition of the MUTCD, including the *Washington State Modifications to the MUTCD*, the book *Quality Guidelines for Temporary Work Zone Traffic Control Devices*, the most current edition of the PROWAG, and applicable standards and Specifications.
2. Inspecting traffic control devices and nighttime lighting for proper location, installation, message, cleanliness, and effect on the traveling public. Traffic control devices shall be inspected at least once per hour during working hours except that Class A signs need to be checked once a week and nighttime lighting need to be checked only once a shift. Traffic control devices left in place for 24 hours or more shall also be inspected once during the nonworking hours when they are initially set up (during daylight or darkness, whichever is opposite of the working hours). The TCS shall correct, or arrange to have corrected, any deficiencies noted during these inspections.

3. Preparing a daily traffic control diary on each day that traffic control is performed using WSDOT Form 421-040A and 421-040B, and submitting them to the Engineer no later than the end of the next working day. The Contractor may use alternate forms if approved by the Engineer. Diary entries shall include, but not be limited to:
   a. Time of day when signs and traffic control devices are installed and removed,
   b. Location and condition of signs and traffic control devices,
   c. Revisions to the traffic control plan,
   d. Lighting utilized at night, and
   e. Observations of traffic conditions.
4. Making minor revisions to the traffic control plan to accommodate site conditions provided that the original intent of the traffic control plan is maintained and the revision has the concurrence of both the Contractor and the Engineer.
5. Attending traffic control coordinating meetings or coordination activities as necessary for full understanding and effective performance.
6. Ensuring that all needed traffic control devices and equipment are available and in good working condition prior to the need to install or utilize them.
7. Ensuring that all pedestrian routes or access points, existing or temporary, are kept clear and free of obstructions and that all temporary pedestrian routes or access points are detectable and accessible to persons with disabilities as provided for in the approved Plans.

The TCS may perform the Work described in Section 1-10.3(1)A Flaggers or in Section 1-10.3(1)B Other Traffic Control Labor and be compensated under those Bid items, provided that the duties of the TCS are accomplished.

1-10.2(2) Traffic Control Plans

The traffic control plan or plans appearing in the Contract documents show a method of handling vehicle, bicycle, and pedestrian traffic. All construction signs, flaggers, and other traffic control devices are shown on the traffic control plan(s) except for emergency situations. If the Contractor proposes adding the use of flaggers to a plan, this will constitute a modification requiring approval by the Engineer. The modified plans shall show locations for all the required advance warning signs and a safe, protected location for the flagging station. If flagging is to be performed during hours of darkness, the plan shall include appropriate illumination for the flagging station.

When the Contractor's chosen method of performing the Work in the Contract requires some form of temporary traffic control, for vehicles, bicyclists, or pedestrians, the Contractor shall either: (1) submit a Type 1 Working Drawing designating and adopting, in writing, the traffic control plan or plans from the Contract documents that support that method; or (2) submit a Type 2 Working Drawing consisting of the Contractor's plan that modifies, supplements or replaces a plan from the Contract documents. Any Contractor-proposed modification, supplement or replacement shall show the necessary construction signs, flaggers, and other traffic control devices required to support the Work. Any

Contractor-proposed traffic control plan shall conform to the established standards for plan development as shown in the MUTCD, Part 6 and the most current edition of the PROWAG. The Contractor shall be solely responsible for submitting any proposed traffic control plan or modification, obtaining the Engineer's acceptance and providing copies of the accepted Traffic Control Plans to the Traffic Control Supervisor.

1-10.2(3) Conformance to Established Standards

Flagging, signs, and all other traffic control devices and procedures furnished or provided shall conform to the standards established in the latest WSDOT adopted edition (in accordance with WAC 468-95) of the MUTCD, published by the U.S. Department of Transportation, and the 2005 draft version of the Public Rights-of-Way Accessibility Guidelines (PROWAG) https://www.access-board.gov/guidelines-and-standards/streets-sidewalks/public-rights-of-way/background/revised-draft-guidelines. Judgment of the quality of devices furnished will be based upon Quality Guidelines for Temporary Traffic Control Devices, published by the American Traffic Safety Services Association. Copies of the MUTCD and Quality Guidelines for Temporary Control Devices may be purchased from the American Traffic Safety Services Association, 15 Riverside Parkway, Suite 100, Fredericksburg, VA 22406-1022.

In addition to the standards of the MUTCD described above, the Contracting Agency enforces crashworthiness requirements for most work zone devices. The AASHTO Manual for Assessing Safety Hardware (MASH) has superseded the National Cooperative Highway Research Project (NCHRP) Report 350 as the established requirements for crash testing. Temporary traffic control devices manufactured after December 31, 2019 shall be compliant with the 2016 edition of the Manual for Assessing Safety Hardware (MASH 16) crash test requirements, as determined by the Contracting Agency, except as follows:

1. In situations where a MASH 16 compliant traffic control device does not exist and there are no available traffic control devices that were manufactured on or before December 31, 2019, then a traffic control device manufactured after December 31, 2019 that is compliant with either NCHRP 350 or the 2009 edition of the Manual for Assessing Safety Hardware (MASH 09) is allowed for use with approval of the Engineer.
2. Temporary traffic control devices that were manufactured on or before December 31, 2019, and were successfully tested to National Cooperative Highway Research Program (NCHRP) Report 350 or MASH 09 may continue to be used on WSDOT projects throughout their normal service life.
3. Small and lightweight channelizing and delineating devices, including cones, tubular markers, flexible delineator posts, and plastic drums, shall meet the requirements of either NCHRP 350, MASH 09, or MASH 16, as determined by the manufacturer of the device.
4. A determination of crashworthiness for acceptance of trailer-mounted devices such as arrow displays, temporary traffic signals, area lighting supports, and portable changeable message signs is currently not required.

The condition of signs and traffic control devices shall be acceptable or marginal as defined in the book *Quality Guidelines for Temporary Traffic Control Devices*, and will be accepted based on a visual inspection by the Engineer. The Engineer's decision on the condition of a sign or traffic control device shall be final. A sign or traffic control device determined to be unacceptable shall be removed from the project and replaced within 12 hours of notification.

1-10.3 Traffic Control Labor, Procedures, and Devices

1-10.3(1) Traffic Control Labor

The Contractor shall furnish all personnel for flagging, for the execution of all procedures related to temporary traffic control and for the setup, maintenance and removal of all temporary traffic control devices and construction signs necessary to control vehicular, bicycle, and pedestrian traffic during construction operations.

Vests and other high-visibility apparel shall be in conformance with Section 1-07.8.

1-10.3(1)A Flaggers

Flaggers shall be posted where shown on approved Traffic Control Plans or where directed by the Engineer. All flaggers shall possess a current flagging card issued by the State of Washington, Oregon, Montana, or Idaho. The flagging card shall be immediately available and shown to the Contracting Agency upon request.

Flagging stations shall be shown on Traffic Control Plans at locations where construction operations require stopping or diverting public traffic. Flagging stations shall be staffed only when flagging is required. This staffing may be continuous or intermittent, depending on the nature of the construction activity. Whenever a flagger is not required to stop or divert traffic, the flagger shall move away from the flagging station to a safer location. During hours of darkness, flagging stations shall be illuminated in a manner that insures that flaggers can easily be seen but that does not cause glare to the traveling public.

Flagger station illumination shall meet the requirements of the MUTCD and these Specifications.

The Contractor shall provide portable lighting equipment capable of sufficiently illuminating a flagger and their station without creating glare for oncoming motorists, yet will meet the mobility requirements of the operation. The lighting stations shall be located on the same side of the roadway as the flagger and aimed either parallel or perpendicular to the traveled lanes to minimize glare. The lighting devices shall be located 5 to 10 feet from the edge of the travel lane with a mounting height of 15 to 25 feet above the ground. The flagger should be visible and discernable as a flagger from a distance of 1,000 feet.

Flaggers shall be equipped with portable two-way radios, with a range suitable for the project. The radios shall be capable of having direct contact with project management (foremen, superintendents, etc.).

The Contractor shall furnish Stop/Slow paddles conforming to the requirements of Section 9-35.1 for all flagging operations.

1-10.3(1)B Other Traffic Control Labor

In addition to flagging duties, the Contractor shall provide personnel for all other traffic control procedures required by the construction operations and for the labor to install, maintain and remove any traffic control devices shown on Traffic Control Plans.

1-10.3(2) Traffic Control Procedures

1-10.3(2)A One-Way Traffic Control

The project Work may require that traffic be maintained on a portion of the Roadway during the progress of the Work using one-way traffic control. If this is the case, the Contractor's operation shall be confined to one-half the Roadway, permitting traffic on the other half. If shown on an approved traffic control plan or directed by the Engineer, one-way traffic control, in accordance with the MUTCD, shall be provided and shall also conform to the following requirements:

In any one-way traffic control configuration, side roads and approaches will be closed or controlled by a flagger or by appropriate approved signing. A side road flagger will coordinate with end flaggers where there is line of sight and with the pilot car where the end flaggers cannot be seen.

Queues of vehicles will be allowed to take turns passing through the work zone in the single open lane. When one-way traffic control is in effect, Contractor vehicles shall not use the open traffic lane except while following the same rules and routes required of the public traffic.

As conditions permit, the Contractor shall, at the end of each day, leave the Work area in such condition that it can be traveled without damage to the Work, without danger to traffic, and without one-way traffic control. If, in the opinion of the Engineer, one-way traffic control cannot be dispensed with after working hours, then the operation will be continued throughout the non-working hours.

1-10.3(2)B Rolling Slowdown

Rolling slowdown traffic control operations are not to be used for routine Work that can be addressed by standard lane or shoulder closure traffic control. When a short-term roadway closure is needed for an infrequent, nonrepetitive Work operation such as a sign bridge removal or utility wire crossing, the Contractor may implement a rolling slowdown on a multilane roadway, as part of an accepted traffic control plan.

The Contractor shall submit Type 2 Working Drawings consisting of a traffic control plan detailing the expected delay time, interchange ramp control, and rolling slowdown distance. A portable changeable message sign shall be placed ahead of the starting point of the traffic control to warn traffic of the slowdown. The sign shall be placed far enough ahead of the Work to avoid any expected backup of vehicles.

A rolling slowdown shall use traffic control vehicles with flashing amber lights. At least one traffic control vehicle will be used for every two lanes to be slowed, plus a control vehicle will serve as a following (chase) vehicle for traffic ahead of the blockade. The traffic control vehicles shall enter the roadway and form a moving blockade to reduce traffic speeds and create a clear area ahead of the blockade in which to accomplish the Work without a total stoppage of traffic.

The location where the traffic control vehicles shall begin the slowdown and the speed at which the moving blockade will be allowed to travel will be calculated to accommodate the estimated time needed for closure. The chase control vehicle shall follow the slowest vehicle ahead of the blockade. When the chase vehicle passes, the Contractor may begin the Work operation. In the event that the Work operation is not completed when the moving blockade reaches the site, all Work except that necessary to clear the Roadway shall cease immediately and the Roadway shall be cleared and reopened as soon as possible.

All ramps and entrances to the Roadway between the moving blockade and Work operation shall be temporarily closed using flaggers. Radio communications between the Work operation and the moving blockade shall be established and utilized to adjust the speed of the blockade to accommodate the closure time needed.

1-10.3(2)C Lane Closure Setup/Takedown

Where allowed by the Contract and where shown on approved traffic control plans or directed by the Engineer, the Contractor shall set up traffic control measures to close one or more lanes of a multi-lane facility. When this is to occur, the following sequence shall be followed:

1. If the Plans show a portable changeable message sign, it shall be established in advance of the operation, far enough back to provide warning of both the operation and any queue of traffic that has formed during the operation.
2. Advance warning signs are set up on the Shoulder of the Roadway opposite the lane to be closed.
3. Advance warning signs are set up on the same Shoulder as the lane to be closed.
4. A transportable attenuator, with arrow board, is moved into place at the beginning of the closure taper.
5. Channelization devices are placed to mark the taper and the length of the closure as shown on the traffic control plan.

Once the lane is closed, the transportable attenuator/arrow board combination shall be replaced with an arrow board without attenuator.

If additional lanes are to be closed, this shall be done in sequence with previous lane closures using the same sequence of activities. A transportable attenuator with arrow board is required during the process of closing each additional lane and is to be replaced with an arrow board without attenuator after the lane is closed. Each closed lane shall be marked with a separate arrow board at all times.

Channelization devices shall not be moved by traffic control personnel across an open lane of traffic. If an existing setup or staging of traffic control devices require crossing an open lane of traffic, the traffic control devices shall be taken down completely and then set up in the new configuration.

Traffic control for lane closures shall be removed in the reverse order of its installation.

1-10.3(2)D Mobile Operations

Where construction operations are such that movement along the length of a Roadway is continuous or near-continuous to the extent that a stationary traffic control layout will not be effective, the Contractor may implement a moving, or mobile, traffic control scheme. Such moving control shall always be conducted in the same direction as the adjacent traffic.

Where shown on an approved traffic control plan or where directed by the Engineer, mobile traffic control shall consist of portable equipment, moving with the operation. A portable changeable message sign shall be established in advance of the operation, far enough back to provide warning of both the operation and of any queue of traffic that has formed during the operation. The advance sign shall be continuously moved to stay near the back of the queue at all times. A transportable attenuator, with arrow board, shall be positioned and maintained at a fixed distance upstream of the Work. A shadow vehicle, with transportable attenuator shall be positioned and maintained immediately upstream of the Work.

1-10.3(2)E Patrol and Maintain Traffic Control Measures

At all times, when temporary traffic control measures are in place, the Contractor shall provide for patrolling and maintaining these measures. The Work shall consist of resetting errant devices, assuring visibility of all devices, cleaning and repairing where necessary, providing maintenance for all equipment, including replacing batteries and light bulbs as well as keeping motorized and electronic items functioning, and adjusting the location of devices to respond to actual conditions, such as queue length, unanticipated traffic conflicts and other areas where planned traffic control has proven ineffective.

This Work shall be performed by the Contractor, either by or under the direction of the Traffic Control Supervisor. Personnel, with vehicles if necessary, shall be dispatched so that all traffic control can be reviewed at least once per hour during working hours and at least once during each non-working day.

1-10.3(3) Traffic Control Devices

Traffic control devices, including signs, furnished or provided shall conform to the standards established in the latest WSDOT-adopted edition of the *Manual on Uniform Traffic Control Devices for Streets and Highways* (MUTCD) published by the U.S. Department of Transportation and the Washington State Modifications to the MUTCD. Requirements for pedestrian traffic control devices are addressed in the MUTCD.

1-10.3(3)A Construction Signs

All construction signs required by approved traffic control plans, as well as any other appropriate signs directed by the Engineer shall be furnished by the Contractor. The Contractor shall provide the posts or supports and erect and maintain the signs in a clean, neat, and presentable condition until the need for them has ended. Post mounted signs shall be installed as shown in the *Standard Plans*. When the need for construction signs has ended, the Contractor, upon approval of the Engineer, shall remove all signs, posts, and supports from the project and they shall remain the property of the Contractor.

No passing zones on the existing Roadway that are marked with paint striping and which striping is to be obliterated by construction operations shall be replaced by "Do Not Pass" and "Pass With Care" signs. The Contractor shall provide and install the posts and signs. The signs shall be maintained by the Contractor until they are removed or until the Contract is Physically Completed. When the project includes striping by the Contractor, the signs and posts shall be removed by the Contractor when the no passing zones are reestablished by striping. The signs and posts will become the property of the Contractor. When the Contractor is not responsible for striping and when the striping by others is not completed when the project is Physically Completed, the posts and signs shall be left in place and shall become the property of the Contracting Agency.

All existing signs, new permanent signs installed under this Contract, and construction signs installed under this Contract that are inappropriate for the traffic configuration at a given time shall be removed or completely covered in accordance with Section 8-21.3(3). Construction signs will be divided into two classes. Class A construction signs are those signs that remain in service throughout the construction or during a major phase of the Work. They are mounted on posts, existing fixed Structures, or substantial supports of a semi-permanent nature. Class A signs will be designated as such on the approved Traffic Control Plan. "Do Not Pass" and "Pass With Care" signs are classified as Class A construction signs. Sign and support installation for Class A signs shall be in accordance with the Contract Plans or the *Standard Plans*. Class B construction signs are those signs that are placed and removed daily, or are used for short durations which may extend for 1 to 3 days. They are mounted on portable or temporary mountings. Tripod-mounted signs in place more than 3 days in any one location, unless approved by the Engineer, shall be required to be post-mounted and shall be classified as Class A construction signs.

Where it is necessary to add weight to signs for stability, sand bags or other similar ballast may be used, but the top of ballast shall not be more than 4 inches above the Roadway surface, and shall not interfere with the breakaway features of the device. The Contractor shall follow the manufacturer's recommendations for sign ballasting.

Signs, posts, or supports that are lost, stolen, damaged, destroyed, or which the Engineer deems to be unacceptable while their use is required on the project shall be replaced by the Contractor.

1-10.3(3)B Sequential Arrow Signs

Where shown on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide, operate and maintain sequential arrow signs. A sequential arrow sign is required for all lane closure tapers on a multilane facility. A separate sequential arrow sign shall be used for each closed lane. The arrow sign shall not be used to laterally shift traffic. When used in the caution mode, the four corner mode shall be used.

1-10.3(3)C Portable Changeable Message Sign

Where shown on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide, operate, and maintain portable changeable message signs (PCMS). A PCMS shall be placed behind a barrier or guardrail whenever possible, but shall at a minimum provide 4 feet of lateral clearance to edge of travelled lane and be delineated by channelization devices. The Contractor shall remove the PCMS from the clear zone when not in use unless protected by barrier or guardrail.

1-10.3(3)D Barricades

Where shown on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide, install and maintain barricades. Barricades shall be kept in good repair and shall be removed immediately when, in the opinion of the Engineer, they are no longer functioning as designed.

Where it is necessary to add weight to barricades for stability, sand bags or other similar ballast may be used, but the height shall not be more than 4 inches above the Roadway surface and shall not interfere with the breakaway features of the device. The Contractor shall follow the manufacturer's recommendation for sign ballasting.

1-10.3(3)E Traffic Safety Drums

Where shown on an approved Traffic Control Plan, or where ordered by the Engineer, the Contractor shall provide, install, and maintain traffic safety drums.

Used drums may be utilized, provided all drums used on the project are of essentially the same configuration and the devices conform to Section 1-10.2(3).

The drums shall be designed to resist overturning by means of a weighted lower unit that will separate from the drum when impacted by a vehicle.

Drums shall be regularly maintained to ensure that they are clean and that the drum and reflective material are in good condition. If the Engineer determines that a drum has been damaged beyond usefulness, or provides inadequate reflectivity, a replacement drum shall be furnished.

When the Engineer determines that the drums are no longer required, they shall be removed from the project and shall remain the property of the Contractor.

1-10.3(3)F Vacant

1-10.3(3)G Traffic Cones and Tall Channelizing Devices

Where shown on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide, install and maintain traffic cones or tall channelizing devices. Cones and tall channelizing devices shall be kept in good repair and shall be removed immediately when directed by the Engineer. Where wind or moving traffic frequently displaces cones or tall channelizing devices, an effective method of stabilizing them, such as stacking two together at each location, shall be employed, or heavier weighted bases may be necessary.

1-10.3(3)H Tubular Markers

Where shown on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide, install, and maintain tubular markers. Tubular markers shall be kept in good repair and shall be removed immediately when directed by the Engineer. Tubular markers are secondary devices and are not to be used as substitutes for cones or other delineation devices without an approved traffic control plan.

Where the Traffic Control Plan shows pavement-mounted tubular markers, the adhesive used to fasten the base to the pavement shall be suitable for the purpose, as approved by the Engineer. During the removal of pavement-mounted tubular markers, care shall be taken to avoid damage to the existing pavement. Any such damage shall be repaired by the Contractor at no cost to the Contracting Agency.

1-10.3(3)I Warning Lights and Flashers

Where shown attached to traffic control devices on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide and maintain flashing warning lights. Lights attached to advance warning signs shall be Type B, high-intensity. Lights attached to traffic safety drums, barricades or other signs shall be Type C, steady-burning low intensity or, where attention is to be directed to a specific device, Type A, flashing low-intensity units.

1-10.3(3)J Transportable Attenuator

Where shown on an approved traffic control plan or where ordered by the Engineer, the Contractor shall provide, operate, and maintain transportable impact attenuators consistent with the requirements of Section 9-35.12. These attenuators shall be available, on-site, for the entire duration of their projected use.

The transportable attenuator shall be positioned to separate and protect construction work zone activities from normal traffic flow.

During use, the attenuator shall be in the full down-and-locked position. For stationary operations, the host vehicle's parking brake shall be set.

A transportable attenuator may be used in lieu of a temporary impact attenuator when approved by the Engineer as part of a stage traffic control shift to protect an object such as blunt barrier end or bridge pier column that is located within the work zone clear zone.

This use of a transportable attenuator is restricted to a maximum of 3 days or approved extension by the Engineer.

1-10.3(3)K Portable Temporary Traffic Control Signal

Where shown on an approved traffic control plan, the Contractor shall provide, operate, maintain, and remove a portable temporary traffic control signal system to provide alternating one-lane traffic operations on a two-way facility. A portable temporary traffic control signal system shall be defined as two traffic control units that operate together. The system shall be trailer-mounted, fully self-contained, and designed so that it can be easily transported and deployed at different locations.

The Contractor shall submit a Type 2 Working Drawing consisting of the manufacturer's specifications for the portable temporary traffic control signal. A manufacturer's representative is required to demonstrate the capabilities of the temporary portable signal prior to approval and provide training to contractor personnel as necessary.

Remote manual control of the portable traffic control signal by the Traffic Control Supervisor (TCS) or a qualified operator may be allowed if necessitated by Work area or traffic conditions and as allowed by the Engineer.

Maximum length between signal heads shall be 1,500 feet unless otherwise shown on the Plans or ordered by the Engineer in accordance with Section 1-04.4.

The Engineer or designee will inspect the signal system at initial installation/operation and approve the signal timing. Final approval will be based on the results of the operational inspection.

The Traffic Control Supervisor shall monitor and ensure that the Portable Temporary Traffic Control Signal is fully operational and maintained as specified by the manufacturer. This Work may include cleaning and replacing lamps and other routine maintenance as needed.

If repairs or adjustments are required the Contractor shall respond immediately and provide flagger traffic control, if the Roadway cannot be safely reopened to two-way traffic, until such time that repairs can be made. The Contractor shall either repair the signal or replace with a backup unit within 24 hours.

The Engineer will monitor the traffic, signal operation and order adjustments as needed based on traffic conditions. Timing adjustments require the approval of the Engineer.

As shown on the traffic control plan, temporary stop bars and "STOP HERE ON RED" Signs (R10-6) shall be provided at the location traffic is expected to stop during the red display. The stop bar locations shall be illuminated at night. The illumination shall be the responsibility of the Contractor and shall be adjusted to ensure minimal glare to motorists.

When not in operation, remove signal heads from the view of traffic or cover signal heads with bags made of non-ripping material specifically designed for covering signal heads. Do not use trash bags of any type. Remove, cover, fold, or turn all inappropriate signs so that they are not readable by oncoming traffic.

The Contractor shall provide and install all field wiring to make a complete and operational portable traffic control signal and shall maintain the system throughout the life of the Contract.

Portable temporary traffic signals shall not be installed within 300 feet of at-grade railroad crossing, or if driveways or Roadway access points are located between the portable temporary traffic control signals.

1-10.4 Measurement

1-10.4(1) Lump Sum Bid for Project (No Unit Items)

When the Bid Proposal contains the item "Project Temporary Traffic Control", there will be no measurement of unit items for Work defined by Section 1-10 except as described in Section 1-10.4(3). Also, except as described in Section 1-10.4(3), all of Sections 1-10.4(2) and 1-10.5(2) are deleted.

1-10.4(2) Item Bids With Lump Sum for Incidentals

When the Bid Proposal does not contain the item "Project Temporary Traffic Control", Sections 1-10.4(1) and 1-10.5(1) are deleted and the Bid Proposal will contain some or all of the following items, measured as noted.

"Flaggers" will be measured by the hour. Hours will be measured for each flagging station, shown on an approved Traffic Control Plan, when that station is staffed in accordance with Section 1-10.3(1)A. When a flagging station is staffed on an intermittent basis, no deduction will be made in measured hours provided that the person staffing the station is in a standby mode and is not performing other duties.

"Other Traffic Control Labor" will be measured by the hour. Time spent on activities other than those described herein will not be measured under this item. The hours of one person will be measured for each patrol route that the Contractor performs the Work described under Section 1-10.3(2)E, Patrol and Maintain Traffic Control Measures, regardless of the actual number of persons per route. Hours will be measured for each person engaged in any one of the following activities:

- Operating a pilot vehicle during one-way piloted traffic control.
- Operating a traffic control vehicle or a chase vehicle during a rolling slowdown operation.
- Operating a vehicle or placing/removing traffic control devices during the setup or takedown of a lane closure. Performing preliminary Work to prepare for placing and removing these devices.
- Operating any of the moving traffic control equipment, or adjusting signing during a mobile operation as described in Section 1-10.3(2)D.

- Placing and removing Class B construction signs. Performing preliminary Work to prepare for placing and removing these signs.
- Relocation of Portable Changeable Message Signs within the project limits.
- Installing and removing Barricades, Traffic Safety Drums, Cones, Tubular Markers and Warning Lights and Flashers to carry out approved Traffic Control Plan(s). Performing preliminary Work to prepare for installing these devices.

"Construction Signs, Class A" will be measured by the square foot of panel area for each sign designated on an approved Traffic Control Plan as Class A or for each construction sign installed as ordered by the Engineer and designated as Class A at the time of the order. Class A signs may be used in more than one location and will be measured for each new installation. Class B construction signs will not be measured. Sign posts or supports will not be measured.

"Sequential Arrow Sign" will be measured by the hour for the time that each sign is operating as shown on an approved Traffic Control Plan.

"Portable Changeable Message Sign" will be measured by the hour for the time that each sign is operating as shown on an approved Traffic Control Plan.

"Transportable Attenuator" will be measured per each one time only for each host vehicle with mounted or attached impact attenuator used on the project. The final pay quantity shall be the maximum number of transportable attenuators in place at any one time.

"Operation of Transportable Attenuator" will be measured by the hour for each transportable attenuator manned and operated. Manned and operated shall be when the transportable attenuator has an operator and is required to move, in operating position, with the construction operation or when moving the transportable attenuator from one position to another on the project.

1-10.4(3) Reinstating Unit Items With Lump Sum Traffic Control

The Contract Provisions may establish the project as lump sum, in accordance with Section 1-10.4(1) and also include one or more of the items included above in Section 1-10.4(2). When that occurs, the corresponding measurement provision in Section 1-10.4(2) is not deleted and the Work under that item will be measured as specified.

1-10.4(4) Owner-Provided Resources

The Contract Provisions may call for specific items of labor, materials, or equipment, noted in Section 1-10 as the responsibility of the Contractor, to be supplied by the Contracting Agency. When this occurs, there will be no adjustment in measurement of unit quantities.

1-10.5 Payment

1-10.5(1) Lump Sum Bid for Project (No Unit Items)

"Project Temporary Traffic Control", lump sum.

The lump sum Contract payment shall be full compensation for all costs incurred by the Contractor in performing the Contract Work defined in Section 1-10 except for costs compensated by Bid Proposal items inserted through Contract Provisions as described in Section 1-10.4(3).

1-10.5(2) Item Bids With Lump Sum for Incidentals

"Traffic Control Supervisor", lump sum.

The lump sum Contract payment shall be full compensation for all costs incurred by the Contractor in performing the Work defined in Section 1-10.2(1)B.

"Pedestrian Traffic Control", lump sum.

The lump sum Contract payment shall be full compensation for all costs incurred by the Contractor in performing the Work for pedestrian traffic control defined in Section 1-10.

"Flaggers", per hour.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all costs incurred by the Contractor in performing the Work defined in Section 1-10.3(1)A.

"Other Traffic Control Labor", per hour.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all labor costs incurred by the Contractor in performing the Work specified for this item in Section 1-10.4(2).

"Construction Signs Class A", per square foot.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all costs incurred by the Contractor in performing the Work described in Section 1-10.3(3)A. In the event that "Do Not Pass" and "Pass With Care" signs must be left in place, a change order, as described in Section 1-04.4, will be required. When the Bid Proposal contains the item "Sign Covering", then covering those signs indicated in the Contract will be measured and paid according to Section 8-21.

"Sequential Arrow Sign", per hour.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all costs incurred by the Contractor in performing the Work described in Section 1-10.3(3)B.

"Portable Changeable Message Sign", per hour.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all costs incurred by the Contractor in performing the Work for procuring all portable changeable message signs required for the project and for transporting these signs to and from the project.

"Transportable Attenuator", per each.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all costs incurred by the Contractor in performing the Work described in Section 1-10.3(3)J except for costs compensated separately under the items "Operation of Transportable Attenuator" and "Repair Transportable Attenuator".

"Operation of Transportable Attenuator", per hour.

The unit Contract price, when applied to the number of units measured for this item in accordance with Section 1-10.4(2), shall be full compensation for all costs incurred by the Contractor in performing the Work for operating transportable attenuators on the project.

"Repair Transportable Attenuator", by force account.

All costs of repairing or replacing transportable attenuators that are damaged by the motoring public while in use as shown on an approved Traffic Control Plan will be paid for by force account as specified in Section 1-09.6. To provide a common Proposal for all Bidders, the Contracting Agency has estimated the amount of force account for "Repair Transportable Attenuator" and has entered the amount in the Proposal to become a part of the total Bid by the Contractor. Transportable attenuators damaged due to the Contractor's operation or damaged in any manner when not in use shall be repaired or replaced by the Contractor at no expense to the Contracting Agency.

"Other Temporary Traffic Control", lump sum.

The lump sum Contract payment shall be full compensation for all costs incurred by the Contractor in performing the Work defined in Section 1-10, and which costs are not compensated by one of the above-listed items.

"Portable Temporary Traffic Control Signal", lump sum.

The lump sum Contract payment shall be full compensation for all costs incurred by the Contractor in performing the Work as described in Section 1-10.3(3)K, including all costs for traffic control during manual control, adjustment, malfunction, or failure of the portable traffic control signals and during replacement of failed or malfunctioning signals.

1-10.5(3) Reinstating Unit Items With Lump Sum Traffic Control

The Contract Provisions may establish the project as lump sum, in accordance with Section 1-10.4(1) and also reinstate the measurement of one or more of the items described in Section 1-10.4(2). When that occurs, the corresponding payment provision in Section 1-10.5(2) is not deleted and the Work under that item will be paid as specified.

2-01 Clearing, Grubbing, and Roadside Cleanup

2-01.1 Description

The Contractor shall clear, grub, and clean up those areas staked or described in the Special Provisions. This Work includes protecting from harm all trees, bushes, shrubs, or other objects selected to remain.

"Clearing" means removing and disposing of all unwanted material from the surface, such as trees, brush, down timber, or other natural material.

"Grubbing" means removing and disposing of all unwanted vegetative matter from underground, such as sod, stumps, roots, buried logs, or other debris.

"Roadside cleanup", whether inside or outside the staked area, means Work done to give the roadside an attractive, finished appearance.

"Debris" means all unusable natural material produced by clearing, grubbing, or roadside cleanup.

2-01.2 Disposal of Usable Material and Debris

The Contractor shall meet all requirements of state, county, and municipal regulations regarding health, safety, and public welfare in the disposal of all usable material and debris.

The Contractor shall dispose of all debris by one or more of the disposal methods described below.

2-01.2(1) Disposal Method No. 1 – Open Burning

The open burning of residue resulting from land clearing is restricted by Chapter 173-425 of the Washington Administrative Code (WAC). No commercial open burning shall be conducted without authorization from the Washington State Department of Ecology or the appropriate local air pollution control authority. All burning operations shall be strictly in accordance with these authorizations.

2-01.2(2) Disposal Method No. 2 – Waste Site

Debris shall be hauled to a waste site obtained and provided by the Contractor in accordance with Section 2-03.3(7)C.

2-01.2(3) Disposal Method No. 3 – Chipping

Wood chips may be disposed of on-site in accordance with the following:

1. Chips shall be no larger than 6 square inches and no thicker than ½ inch.
2. Chips shall be disposed outside of sensitive areas, and in areas that aren't in conflict with permanent Work.
3. Chips shall not be incorporated into the embankment but may be spread on slopes where feasible at depths no greater than 2 inches.
4. Chips shall be tractor-walked into the ground.

2-01.3 Construction Requirements

2-01.3(1) Clearing

The Contractor shall:

1. Fell trees only within the area to be cleared.
2. Close-cut parallel to the slope of the ground all stumps to be left in the cleared area outside the slope stakes.
3. Follow these requirements for all stumps that will be buried deeper than 5 feet from the top, side, or end surface of the embankment or any structure and are in a location that will not be terraced as described in Section 2-03.3(14):
   a. Close-cut stumps under 18 inches in diameter.
   b. Trim stumps that exceed 18 inches in diameter to no more than 12 inches above original ground level.
4. Leave standing any trees or native growth indicated by the Engineer.
5. Trim all trees to be left standing to the height specified by the Engineer, neatly cutting all limbs close to the tree trunk.
6. Thin clumps of native growth as the Engineer may direct.
7. Protect, by fencing if necessary, all trees or native growth from any damage caused by construction operations.

2-01.3(2) Grubbing

The Contractor shall:

1. Grub deep enough to remove all stumps, large roots, buried logs, and other vegetative material.
2. Grub all areas:
   a. Indicated by the Engineer or by the Special Provisions.
   b. To be excavated, including area staked for slope treatment.
   c. Where subdrainage trenches will be dug, unsuitable material removed, or Structures built.
   d. In which hillsides or existing embankments will be terraced as described in Section 2-03.3(14).
   e. Upon which embankments will be placed, except stumps may be close-cut or trimmed as allowed in Section 2-01.3(1) item 3.

A Contract may include grubbing without mentioning clearing or roadside cleanup. In that case, the Contractor shall remove and dispose of all upturned stumps and roots of windfalls that lie within the cleared area of the Right of Way, even though they are outside the area staked for grubbing. Such Work shall be incidental to other Work covered by the Contract.

2-01.3(3) Vacant

2-01.3(4) Roadside Cleanup

Roadside cleanup, as ordered by the Engineer, consists of Work not otherwise provided for in the Contract. Such Work may include:

1. Removing trees, snags, down timber, upturned stumps, large rocks and boulders, and other unsightly matter outside the areas staked for clearing or grubbing.
2. Thinning trees or brush.
3. Filling holes, and smoothing and contouring the ground.
4. Shaping the ends of cuts and fills to fit adjacent terrain and to enhance the area's appearance.
5. Obliterating abandoned roads and reshaping the areas to blend naturally with surroundings.

Methods and equipment used in roadside cleanup shall be approved by the Engineer.

2-01.4 Measurement

When clearing and grubbing is paid per acre, the following areas will be excluded from measurement:

1. Any area along an existing Highway that requires no Work.
2. Any gap that requires no Work, provided the gap is at least 50 feet long when measured parallel to the center line and contains at least 2,500 square feet.

Isolated areas of less than 2,500 square feet that require Work lying between areas excluded from measurement will be counted as having 2,500 square feet. If these isolated areas occur intermittently, the final measurement shall not exceed the total area containing the several isolated areas when measured as continuous.

Clearing and grubbing may be combined in the Proposal. If the Proposal calls for such combined Work to be measured "per acre", the measurement methods described above will apply. If the Proposal designates such combined Work as "lump sum", the Contracting Agency will not base payment on any unit of measurement.

2-01.5 Payment

Payment will be made for the following Bid items when they are included in the Proposal:

"Clearing and Grubbing", per acre or lump sum.

The unit Contract price per acre or lump sum for "Clearing and Grubbing" shall be full pay for all Work described in this section except "Roadside Cleanup".

"Roadside Cleanup", by force account as provided in Section 1-09.6.

To provide a common Proposal for all Bidders, the Contracting Agency has entered an amount in the Proposal to become a part of the Contractor's total Bid.

2-02 Removal of Structures and Obstructions

2-02.1 Description

The Work described in this section includes removing and disposing of, or salvaging, materials named in the Special Provisions or identified by the Engineer. The Work also includes the backfilling of trenches, holes, or pits that result from such removal.

2-02.2 Vacant

2-02.3 Construction Requirements

With certain exceptions, the Contractor shall raze, remove, and dispose of all buildings and foundations, Structures, fences, and other obstructions that lie wholly or partially within the Right of Way. The exceptions are utility-owned equipment and any other items the Contracting Agency may direct the Contractor to leave intact.

When salvageable material is to remain Contracting Agency property, the Special Provisions will identify the material and describe how the Contractor shall remove it and where it will be stored.

Any material not named in the Special Provisions as Contracting Agency property will become the property of the Contractor and shall be removed from the project.

The Contractor may dispose of waste material in Contracting Agency-owned sites if the Special Provisions or the Engineer permits it. Otherwise, the Contractor shall arrange to dispose of waste at no expense to the Contracting Agency and the disposal shall meet the requirements of Section 2-03.3(7)C.

2-02.3(1) Removal of Foundations

When removing foundations the Contractor shall:

1. Remove foundations to a depth of at least 5 feet below finished ground elevation or Subgrade elevation, whichever is lower.
2. Break up basement floors to promote drainage.
3. Fill basements or other cavities left by the removal of Structures. The fill shall match the level of surrounding ground. Fill within the slopes of the Roadbed shall be compacted to meet the requirements of Section 2-03.3(14)C, Method B.

2-02.3(2) Removal of Bridges, Box Culverts, and Other Drainage Structures

When salvaging any steel or wooden bridge that will remain Contracting Agency property, the Contractor shall prevent unnecessary damage to the material. Steel members shall be match-marked.

Unless otherwise directed, the Contractor shall remove foundations of existing Structures to a point 2 feet below: the finished ground elevation, the adjacent ground elevation, or the natural stream bottom. If a foundation lies wholly or partially on the site of a new Structure, it shall be removed to a level that accommodates building the new Structure.

Any blasting shall be subject to the Engineer's approval. The Contractor must complete all blasting before the placement of new Work.

2-02.3(2)A Bridge and Structure Removal

2-02.3(2)A1 Bridge Demolition Plan Submittal

The Contractor shall submit a Type 2E Working Drawing consisting of a bridge demolition plan, showing the method of removing the existing bridge(s), or portions of bridges, as specified.

The bridge demolition plan shall show all equipment, sequence of operations, and details required to complete the work, including containment, collection, and disposal of all debris. The plan shall include a crane foundation stability analysis and crane load calculations, including all dead load and rigging for the Work. The plan shall detail the containment, collection, and disposal of all debris. The plan shall show all stages of demolition.

When the bridge removal work includes removal of a truss or other steel span, and when the Contractor's removal method involves use of a crane or cranes to pick, lift, and remove the truss or steel span, the Contractor shall confirm the dead load weight prior to beginning the removal operation. The operation of confirming the dead load shall be performed at both ends of the span or at all existing support locations, and shall ensure that the span is broken free of its support bearings. The Contractor's method of confirming the dead load, whether by hydraulic jacks or other means, shall be included in the Contractor's bridge demolition plan submittal. Verification of dead load may be waived with Engineer's concurrence if the calculated lifting weight is less than 20 tons and is less than half the safe working load of the selected crane.

When the bridge removal work involves removing portions of existing concrete without replacement, the methods and tools used to achieve the smooth surface and profile specified in Section 2-02.3(2)A2 shall be included in the Contractor's bridge demolition plan submittal.

2-02.3(2)A2 Removing Portions of Existing Concrete

Care shall be taken in removing concrete to prevent overbreakage or damage to portions of the existing Structure which are to remain. Before concrete removal begins, a saw cut shall be made into the surface of the concrete at the perimeter of the removal limits. The saw cut shall be ¾-inch deep when the steel reinforcement is to remain, and may be deeper when the steel reinforcement is removed with the concrete.

Where existing steel reinforcing bars are specified in the Plans to be saved, use of power driven tools to remove the strip or zone of concrete encapsulating these bars is restricted as follows:

1. Jack hammers not heavier than the nominal 30-pound class.
2. Chipping hammers not heavier than the nominal 15-pound class.

No other power driven equipment shall be used to remove the portion of existing concrete specified for removal where existing steel reinforcing bars are specified to be saved. The power driven tools shall be operated at angles less than 45-degrees as measured from the surface of the concrete to the tool.

Concrete shall be completely removed (exposing the deformed surface of the bar) from existing steel reinforcing bars which extend from the existing members and are specified to remain. Steel reinforcing bars that are not designated to remain shall be cut a minimum of 1-inch behind the final surface. The void left by removal of the steel reinforcing bar shall be filled with mortar conforming to Section 9-20.4(2). The mortar shall match the color of the existing concrete surface as nearly as practicable.

The Contractor shall roughen, clean, and saturate existing concrete surfaces, against which fresh concrete will be placed, in accordance with Section 6-02.3(12)B. When a portion of existing concrete is to be removed without replacement, concrete shall be removed to a clean line with a smooth surface of less than 1/16 inch profile.

2-02.3(2)A3 Use of Explosives for Bridge Demolition

Explosives shall not be used for bridge demolition, except as specifically allowed by the Special Provisions.

2-02.3(3) Removal of Pavement, Sidewalks, Curbs, and Gutters

In removing pavement, sidewalks, curbs, and gutters, the Contractor shall:

1. Haul broken-up pieces into the Roadway embankment or to some off-project site.
2. Material that is to be incorporated into the embankment shall be broken into pieces not exceeding 18 inches in any dimension, and no part of any piece shall be within 3 feet of the top, side, or end surface of the embankment or any Structure.

3. Make a vertical full depth saw cut between any existing pavement, sidewalk, curb, or gutter that is to remain and the portion to be removed. For concrete pavement removal, a second vertical full depth relief saw cut offset 12 to 18 inches from and parallel to the initial saw cut is also required, unless the Engineer allows otherwise. For removal of bituminous pavement, asphalt planing equipment may be used in lieu of sawcutting provided that a clean vertical edge remains.
4. Replace at no expense to the Contracting Agency any existing pavement designated to remain that is damaged during the removal of other pavement.

2-02.4 Vacant

2-02.5 Payment

Payment shall be made for the following Bid item when it is included in the Proposal:

"Removal of Structures and Obstructions", lump sum.
If pavements, sidewalks, curbs, or gutters lie within an excavation area, their removal will be paid for as part of the quantity removed in excavation.

"Removing Existing Bridge___", lump sum.

"Removing Existing Structure___", lump sum.

"Removing Portion of Existing Bridge___", lump sum.

"Removing Portion of Existing Structure___", lump sum.

2-03 Roadway Excavation and Embankment

2-03.1 Description

The Work described in this section, regardless of the nature or type of the materials encountered, includes excavating and grading the Roadway, excavating in borrow pits, excavating below grade, excavating channels and ditches, removing slide material, and disposing of all excavated material. These activities may be performed in making cuts, embankments, slopes, Roadway ditches, approaches, parking areas, Highway-driveway intersections, and in completing related Work. The Work includes the removal of pavement, sidewalks, curbs and gutters as described in Section 2-02 when these items lie within an excavation area.

The Work excludes these items if they are designated as pay items in the Contract:

1. Haul.
2. Excavation for Structures and ditches.
3. Removal of unsuitable materials.

The Plans may divide the project into separate areas (Roadway Excavation, Area A, Roadway Excavation, Area B, etc.). Such division does not imply any classification of materials in the areas. The boundaries of the areas shall not be changed regardless of how similar or dissimilar the materials are from one area to another.

All Work described here must reasonably conform to the alignment, grade, and cross-sections shown in the Plans or established by the Engineer.

2-03.2 Vacant

2-03.3 Construction Requirements

2-03.3(1) Widening of Cuts

If routine cuts do not supply enough material to form the embankment, the Contractor shall obtain more material from areas inside or outside the Right of Way and/or from widening one or both sides of existing cuts as determined by the Engineer. The Contractor shall dress the sides of the cuts to any slopes the Engineer may require. If the Contractor has dressed a cut before the Engineer determines to widen it, the Contracting Agency will pay for the resloping as provided in Section 1-04.4. In addition, material obtained from areas beyond the cuts shown in the Plans that result in additional haul will be paid by the Contracting Agency as provided in Section 1-04.4.

2-03.3(2) Rock Cuts

1. **Preserving Rock Below Subgrade** – The Contractor shall take care not to break down, loosen, or damage the rock under the Subgrade line, except as provided by Section 2-03.3(3). Normally cuts will be made from the top, lift by lift, to protect the rock bench that will remain. The Contractor shall be responsible for methods used and for any damage caused to the Roadbed, regardless of any previous approvals by the Engineer.

2. **Scaling and Dressing** – To leave rock cuts in a safe, stable condition, the Contractor shall scale and dress them, removing all loose fragments and rocks not firmly fastened to the rock slope. The Contractor shall also remove any overhanging rock the Engineer sees as a hazard to Roadway users.

   If the Engineer requires it, the Contractor shall remove loose fragments and rocks lying outside the slope stakes. Payment for such extra Work shall be by force account as provided in Section 1-09.6. The Contracting Agency will pay for loading and hauling these materials at the unit Contract prices that apply or as provided in Section 1-04.4.

3. **Drilling and Blasting** – Not less than 2 weeks prior to commencing drilling and blasting operations or at any time the Contractor proposes to change the drilling and blasting methods, the Contractor shall submit a Type 2 Working Drawing consisting of a blasting plan. The blasting plan shall contain the full details of the drilling and blasting patterns and controls the Contractor proposes to use for both the controlled and production blasting. The blasting plan submittal is required for all blasting operations and shall contain at least the following information:

   a. Station limits of proposed shot.

   b. Plan and section views of proposed drill pattern including free face, burden, blast hole spacing, blast hole diameter, blast hole angles, lift height, and subdrill depth.

   c. Loading diagram showing type and amount of explosives, primers, initiators, and location and depth of stemming.

   d. Initiation sequence of blast holes including delay times and delay system.

   e. Manufacturer's data sheets for all explosives, primers, and initiators to be employed.

   Review of the blasting plan by the Engineer shall not relieve the Contractor of the responsibility for the accuracy and adequacy of the plan when implemented in the field.

4. **Controlled Blasting** – When blasting to establish slopes 0.5:1 or steeper, and more than 10 feet high, the Contractor shall use controlled blasting. The Engineer may require the Contractor to use controlled blasting to form the faces of other slopes, even if the slopes could be formed by nonblasting methods.

   Controlled blasting refers to the controlled use of explosives and blasting accessories in carefully spaced and aligned drill holes to provide a free surface or shear plane in the rock along the specified backslope. Controlled blasting techniques covered by this Specification include presplitting and cushion blasting.

   In addition to the blasting plan submittal, when using controlled blasting the Contractor shall:

   a. Prior to commencing full-scale blasting operations, the Contractor shall demonstrate the adequacy of the proposed blast plan by drilling, blasting, and excavating short test sections, up to 100 feet in length, to determine which combination of method, hole spacing, and charge works best. When field conditions warrant, the Contractor may be ordered to use test section lengths less than 100 feet.

      Unless otherwise allowed by the Engineer, the Contractor shall begin the tests with the controlled blast holes spaced 30 inches apart, then adjust if needed, until the Engineer accepts the spacing to be used for full-scale blasting operations.

   b. The Contractor shall completely remove all overburden, soil, and loose or decomposed rock along the top of the excavation for a distance of at least 30 feet beyond the end of the production hole drilling limits, or to the end of the cut, before drilling the presplitting holes.

   c. The controlled blast holes shall be not less than 2½ inches nor more than 3 inches in diameter.

   d. The Contractor shall control drilling operations by the use of the proper equipment and technique to ensure that no hole deviates from the plane of the planned slope by more than 9 inches either parallel or normal to the slope. Drill holes exceeding these limits will not be paid for unless satisfactory slopes are being obtained.

   e. Controlled blast holes shall extend a minimum of 30 feet beyond the limits of the production holes to be detonated, or to the end of the cut as applicable.

   f. The length of controlled blast holes for any individual lift shall not exceed 20 feet unless the Contractor can demonstrate to the Engineer the ability to stay within the above tolerances and produce a uniform slope. If greater than 5 percent of the presplit holes are misaligned in any one lift, the Contractor shall reduce the height of the lifts until the 9-inch alignment tolerance is met. Upon satisfactory demonstration, the length of holes may be increased to a maximum of 60 feet with written acceptance of the Engineer.

   g. When the cut height requires more than one lift, a maximum 2-foot offset between lifts will be permitted to allow for drill equipment clearances. The

Contractor shall begin the controlled blast hole drilling at a point that will allow for necessary offsets and shall adjust, at the start of lower lifts, to compensate for any drift that may have occurred in the upper lifts.

h. Before placing charges, the Contractor shall determine that the hole is free of obstructions for its entire depth. All necessary precautions shall be exercised so that the placing of the charges will not cause caving of material from the walls of the holes.

i. The maximum diameter of explosives used in presplit holes shall not be greater than ½ the diameter of the presplit hole.

j. Only standard explosives manufactured especially for controlled blasting shall be used in controlled blast holes, unless otherwise allowed by the Engineer. Bulk ammonium nitrate and fuel oil (ANFO) shall not be loaded in the presplit holes.

k. If fractional portions of standard explosive cartridges are used, they shall be firmly affixed to the detonating cord in a manner that the cartridges will not slip down the detonating cord nor bridge across the hole. Spacing of fractional cartridges along the length of the detonating cord shall not exceed 30 inches center to center and shall be adjusted to give the desired results.

l. Continuous column cartridge type of explosives used with detonating cord shall be assembled and affixed to the detonating cord in accordance with the explosive manufacturer's instructions, a copy of which shall be submitted as a Type 1 Working Drawing.

m. The bottom charge of a presplit hole may be larger than the line charges but shall not be large enough to cause overbreak. The top charge of the presplitting hole shall be placed far enough below the collar, and reduced sufficiently, to avoid overbreaking and heaving.

n. The upper portion of all presplit holes, from the top most charge to the hole collar, shall be stemmed. Stemming materials shall be sand or other dry angular material, all of which passes a ⅜-inch sieve.

o. If presplitting is specified, the detonation of these holes shall be fired first.

p. If cushion blasting is specified, the detonation of these holes shall be fired last on an instantaneous delay after all other blasting has taken place in the excavation.

q. Production blast holes shall not be drilled closer than 6 feet to the controlled blast line, unless otherwise allowed by the Engineer. The bottom of the production holes shall not be lower than the bottom of the controlled blast holes. Production holes shall not exceed 6 inches in diameter, unless otherwise allowed by the Engineer. Detonation of production holes shall be on a delay sequence toward a free face.

r. The use of horizontal blast holes for either production or controlled blasting is prohibited.

2-03.3(3) Excavation Below Subgrade

Rock Excavation – When the Contractor finds rock or other hard material at the Subgrade elevation, it shall be excavated the full width of the Roadbed to at least 6 inches below Subgrade, then backfilled with rock fragments, gravel, or other free-draining material not more than 4 inches in diameter.

If the Contractor uses a Subgrade trimmer, the backfill shall be rock, gravel, or other free-draining material not more than 2 inches in diameter. The Contractor shall save the finer free-draining material from excavations or borrow pits to use in backfilling the top 6 inches of the Subgrade. All such material shall be approved by the Engineer.

Sub excavation – At any time, the Engineer may order excavation below Subgrade to remove soft and uncompactible material. The replacement material shall be free-draining and granular, or other materials as determined by the Engineer.

Draining Rock Pockets – If blasting below Subgrade leaves a rock pocket that will not drain, the Contractor shall dig a trench from the pocket bottom to the roadside ditch, then backfill both the pocket and the trench with rock fragments, gravel, or other material approved by the Engineer, at no expense to the Contracting Agency.

Compaction – If the density of the natural earth under any area of the Roadway is less than that required in Section 2-03.3(14)C, Method B, the Engineer may order the Contractor to perform any or all of the following:

1. Scarify the earth to a depth of 6 inches.
2. Aerate or water.
3. Compact the scarified area to the required density.
4. Excavate to a specific depth.
5. Backfill the excavated area in layers, using the previously excavated material or other material.
6. Compact each layer to meet the compaction requirements for embankments.

2-03.3(4) Sluicing

The Contractor shall not excavate by sluicing unless the Special Provisions specifically call for it.

2-03.3(5) Slope Treatment

The tops of all Roadway cut slopes, except solid rock cuts, shall be rounded in accordance with the *Standard Plans*. Unless otherwise noted in the Plans or Special Provisions, Class A slope treatment shall be utilized.

If a layer of earth covers a rock cut, the slope shall be rounded above the rock as if it were an earth slope.

When the Contractor removes stumps or any embedded material from the rounded area, the void shall be backfilled and stabilized to prevent erosion.

All Work required to complete slope treatment, including excavation, haul, and slope rounding, shall be included in the unit Bid price for Roadway excavation.

2-03.3(6) Deposit of Rock for the Contracting Agency's Use

At the Engineer's direction, the Contractor shall deposit excavated rock at the roadside or elsewhere. If this requires the Contractor to use material that would otherwise have gone into an embankment, the Contracting Agency will pay for the extra cubic yards of excavation needed to complete the embankment. Any such rock deposit shall be Contracting Agency property. The Contractor shall be responsible for safekeeping the deposit until the Contracting Agency has removed it or until the Contract is completed.

2-03.3(7) Disposal of Surplus Material

2-03.3(7)A General

The Contractor shall haul all excavation to the nearest embankment unless the Engineer declares the hauling distance to be too great. If excavation yields more material than needed for nearby embankments, the Contractor shall dispose of the excess in keeping with the Special Provisions or as the Engineer directs.

2-03.3(7)B Haul

When the Contract includes a payment item for haul, the Contracting Agency will pay as follows for hauling excess excavation to a disposal site:

1. If the Contracting Agency provides a site, but the Contractor chooses to haul elsewhere, the Contracting Agency will pay for the actual distance up to but not exceeding the distance that would have been necessary using the Contracting Agency site.
2. If the Contracting Agency does not provide a site, the Contracting Agency will pay for the actual distance up to but not exceeding the distance necessary to haul to a site 1 mile from the project limits.

2-03.3(7)C Contractor-Provided Disposal Site

If the Contracting Agency provides no waste site, but requires disposal of excess excavation or other materials, the Contractor shall arrange for disposal at no expense to the Contracting Agency, except as provided in Section 2-03.3(7)B, item 2.

The Contractor shall acquire all permits and approvals required for the use of the disposal sites before any waste is hauled off the project. The Contractor shall submit a Type 1 Working Drawing consisting of copies of the permits and approvals for any disposal sites to be used. The cost of any such permits and approvals shall be included in the Bid prices for other Work.

Disposal of excess material within a wetland area will not be allowed without a Section 404 permit issued by the U.S. Corps of Engineers and approval by the local agency with jurisdiction over the wetlands.

The Contractor shall protect, indemnify, and save harmless the Contracting Agency from any damages that may arise from the Contractor's activities in making these arrangements. Such indemnity shall be in accordance with RCW 4.24.115 as amended by CH. 305, Laws of 1986. Any action required to satisfy any permit and/or any approval requirements in a Contractor-provided disposal site shall be performed by the Contractor at no additional expense to the Contracting Agency.

Reclamation of a Contractor-supplied waste site must conform to the requirements of Section 3-03.

2-03.3(8) Wasting Material

If, against the Engineer's orders, the Contractor wastes material needed for the embankment, it shall be replaced at no expense to the Contracting Agency with material the Engineer approves.

2-03.3(9) Roadway Ditches

At each transition from cut to fill, the Contractor shall divert any Roadway ditch away from the embankment in natural ground. Ditches shall never permit water to flow into or upon embankment material.

2-03.3(10) Selected Material

When the Contract or the Engineer calls for it, selected material shall be used for finishing the top part of the Subgrade, for structural or other backfill, or for other purposes. Unless the Special Provisions specify otherwise, the Engineer may identify as "selected" any material excavated within the right-of-way, including the excavation of local borrow.

Direct Hauling – If it is practical, the Contractor shall haul selected material immediately from excavation to its final place on the Roadbed. The Contracting Agency will pay for such Work at the unit Contract prices for excavating, hauling, watering, and compacting.

Delayed Excavation – If it is impractical to haul selected material to its final place at once, the Contractor shall delay excavation until the placement will be workable. The Contracting Agency will not pay extra for delayed excavation.

Stockpiling – The Engineer may allow the Contractor to stockpile selected materials if delaying the excavation will hamper grading or force impractical movements of equipment. In this case, the Engineer will direct where and when the Contractor shall excavate, stockpile, haul, and place the selected materials.

Sections 2-03.4 and 2-03.5 describe how the Contracting Agency will measure and pay for excavating and hauling these stockpiled selected materials. The neat line volume of material removed will provide the basis for measuring material taken from the stockpile.

2-03.3(11) Slides

If a slide occurs on a finished slope before final acceptance of the Work, the Contractor shall remove or replace the slide material. The Contractor shall also refinish the slope to the condition and with the materials required by the Engineer.

The Contracting Agency will pay for the excavation at the unit Contract price and for resloping on a force account basis. The Engineer may authorize payment for the excavation by agreed price or force account if:

1. The slide material cannot be measured accurately, or
2. Excavation of slide material requires equipment not available on the project.

If the Contractor undercuts or destroys a slope, or has failed to implement erosion control devices as shown in the Contract or in the TESC plan, it shall be resloped to the original alignment or to a new one established by the Engineer at no expense to the Contracting Agency.

2-03.3(12) Overbreak

Overbreak includes that part of any material excavated, displaced, or loosened outside the staked or reestablished slope or grade. Such material is considered overbreak whether its movement resulted from blasting, from the character of the material itself, or from any other cause. Overbreak, however, does not include material from slides as described in Section 2-03.3(11).

If the Engineer does not approve use of the overbreak, the Contractor shall remove, haul, and dispose of it at no expense to the Contracting Agency. In this case, the Contractor shall follow the procedure for handling surplus described in Section 2-03.3(7).

If the Engineer approves, the Contractor may use overbreak:

1. To complete an embankment when the excavated material unexpectedly falls short of the amount required. The Contracting Agency will pay the Roadway excavation Contract price for the volume of material the overbreak replaces, and will pay the Contract price for haul. However, no payment will be made if overbreak is used when other material is available within the neat lines of the Roadway prism.
2. To replace borrow excavation originally planned for an embankment. The Contracting Agency will pay for overbreak used this way at the unit Contract price for Roadway or borrow excavation, whichever costs less. The Engineer will include haul to be paid as in the original Proposal in comparing the costs under the two payment methods.

2-03.3(13) Borrow

Borrow is the excavation of material outside the Roadway prism or outside the limits of any other excavation area required by the Contract. Before any borrow site can be used, it must be measured and approved by the Engineer. Any material excavated from a borrow site before the site is measured will not be paid for. The widening of Roadway cuts and ditches will be considered Roadway excavation, not borrow.

If the Contract documents designate borrow sources, the Contractor may utilize those sources or may obtain borrow from other sites. If borrow is obtained from a Contractor-provided site, there will be no additional cost to the Contracting Agency beyond the Contract unit price for the excavated borrow material. There will be no payment for aeration of the borrowed material from a Contractor-provided site, even if the Contract contains an item for aeration and even if the Contract documents designate borrow sources.

If neither the Plans nor the Special Provisions name a source for borrow, the Contractor shall provide a source at no expense to the Contracting Agency.

The Contractor shall reclaim all borrow sites, Contracting Agency-owned, Contracting Agency-supplied, or obtained by the Contractor, in keeping with Section 3-03.

2-03.3(14) Embankment Construction

The Contracting Agency classifies embankment construction as:

1. **Rock Embankment** – In which the material in all or any part of an embankment contains 25 percent or more, by volume, gravel or stone 4 inches or more in diameter. Section 2-03.3(14)A.
2. **Earth Embankment** – Made of any material other than that used in rock embankment. Section 2-03.3(14)B.

Unstable Base – If the Engineer believes the natural earth base will impair an embankment or make it unstable, the Contractor shall stabilize or remove and dispose of the base material in keeping with this section or Section 2-03.3(14)E.

Hillside Terraces – The Contractor shall terrace the original ground or embankment when the slope of the surface is 2H:1V or steeper unless otherwise directed by the Engineer. The face of each terrace shall be a minimum of 1 foot and a maximum of 5 feet in height and shall be vertical or near vertical as required to remain stable during material placement and compaction. The bench of the terrace shall slope outward to drain and shall not be inclined steeper than 0.05 foot per foot. Terraces damaged during work shall be reestablished. The Engineer may order the Contractor to place gravel backfill, pipe drains or both to drain any seepage.

All costs for building terraces shall be included in the prices for other Work.

Soft Base – On wet or swampy ground, the Contractor shall haul and spread embankment material by methods that will disturb the base as little as possible. If the Engineer approves, the Contractor may place the lower part of the fill by dumping and spreading successive loads to form a uniform layer just thick enough to support equipment used to place and compact upper layers.

Normally the Contractor shall not increase the planned depth of the embankment over a soft base merely to permit the use of heavier equipment. But if the Contractor proves that the planned depth will not support light hauling vehicles, the Engineer may approve a deeper fill. The Contractor shall not claim extra pay if these restrictions require the use of lighter equipment or different construction methods than originally planned for use on the soft base.

2-03.3(14)A Rock Embankment Construction

The Contractor shall build rock embankments in horizontal layers. No layer shall be deeper than 18 inches unless the rocks in the fill material average more than 18 inches in diameter. The Contractor shall separate and distribute the larger pieces of rock and fill the spaces between them with smaller rocks and earth. With the Engineer's approval, the Contractor may dispose of rocks larger than the average size instead of placing them in the embankment.

Compacting – The Contractor shall use a 50-ton compression roller or a vibratory roller having a dynamic force of at least 40,000 pounds impact per vibration and at least 1,000 vibrations per minute. In either case, the roller shall make one full coverage for each 6 inches, or any fraction of 6 inches, of lift depth.

When lift depth is 18 inches or less, the Contractor may use a 10-ton compression roller or a vibratory roller having a dynamic force of at least 30,000-pounds impact per vibration and at least 1,000 vibrations per minute. In either case, the roller shall make four full coverages for each 6 inches, or any fraction of 6 inches, of lift depth.

Rollers must exert reasonably even pressure over the area covered. The Contractor shall limit the speed of compression rollers to no more than 4 mph, and the speed of vibratory rollers to no more than 1½ mph.

If possible, the Contractor shall compact the material even further by routing empty and loaded hauling equipment evenly over the entire width of the embankment.

When the Engineer believes rolling to be physically impractical, rolling may be omitted on part or all of a layer.

Should excessive moisture threaten the stability of the embankment the Engineer may order the Contractor to alter the operation. This may include alternating layers of wet and dry materials, drying materials before placing, or halting Work in the problem areas. In this case the Contracting Agency will not increase payment, but will pay the unit Contract prices for the pay items that apply.

Top Layer – The Contractor shall build each rock embankment up to 6 inches below Subgrade. The top 6-inch layer of embankment shall be of rock, gravel, or other free-draining material that does not exceed 4 inches in diameter. When the Plans require use of a Subgrade trimmer, these materials in the top layer may not exceed 2 inches in diameter.

When practical, and as approved by the Engineer, the Contractor shall save the finer free-draining material from excavations or borrow pits for use in topping rock fills. If selected materials suitable for topping are available, the Contracting Agency will pay for them as described in Section 2-03.3(10). If such materials are not available on site, the Contracting Agency will pay for imported materials by including them in the unit Contract price for gravel borrow or borrow excavation, each including haul. If the Proposal does not include these items, the Contracting Agency will pay as provided in Section 1-04.4.

2-03.3(14)B Earth Embankment Construction

The Contractor shall place earth embankments in horizontal layers of uniform thickness. These layers shall run full width from the top to the bottom of the embankment. Slopes shall be compacted to the required density as part of embankment compaction.

During grading operations, the Contractor shall shape the surfaces of embankments and excavations to uniform cross-sections and eliminate all ruts and low places that could hold water. The Contractor shall raise the center of an embankment above the sides. When the surface of an embankment intersects a side hill, the surface shall be sloped away at a rate not to exceed 20:1.

2-03.3(14)C Compacting Earth Embankments

This section describes three methods (A, B, and C) for building earth embankments. The Contractor shall use Method B unless the Special Provisions require another method.

Method A – Each embankment shall be made of layers no more than 2 feet thick. The Contractor shall compact each layer by routing loaded haul equipment over its entire width. If the Engineer approves, the Contractor may use end dumping to begin placing a side hill fill too narrow for hauling equipment. When the fill is wide enough, the remaining layers shall be compacted by the loaded hauling equipment.

Method B – The top 2 feet of each embankment shall be compacted to 95 percent of the maximum density as determined by the compaction control tests described in Section 2-03.3(14)D. All material below the 2-foot level shall be compacted to 90 percent of the same maximum density.

In the top 2 feet, horizontal layers shall not exceed 4 inches in depth before compaction. No layer below the top 2 feet shall exceed 8 inches in depth before compaction.

The Contractor shall use compacting equipment approved by the Engineer.

Method C – Each layer of the entire embankment shall be compacted to 95 percent of the maximum density as determined by the compaction control tests described in Section 2-03.3(14)D.

In the top 2 feet, horizontal layers shall not exceed 4 inches in depth before compaction. No layer below the top 2 feet shall exceed 8 inches in depth before compaction.

The Contractor shall use compacting equipment approved by the Engineer.

Under Methods B or C, the Engineer may permit the Contractor to increase layer thickness up to 18 inches before compaction, provided:

1. The layer is more than 2 feet below the top of the embankment,
2. An approved vibratory roller is used, and
3. The required density is obtained throughout the full depth and width of each layer.

Whatever the method used, any embankment inaccessible to large compacting equipment shall be compacted with small mechanical or vibratory compactors.

Moisture Content – The Contractor shall adjust moisture content during compaction to produce a firm, stable and unyielding embankment. The embankment shall be free from pumping and rutting due to excessive moisture and is the Contractor's responsibility to manage and adjust as necessary.

The Contracting Agency will consider all costs for drying embankment material to be incidental to other Work, including excessive moisture due to inclement weather. If, however, the Contract includes an aeration item, the Contracting Agency will pay for such Work as specified in Sections 2-03.4 and 2-03.5.

The Contractor shall repair, at no expense to the Contracting Agency, any partial or complete embankment that loses stability because of continued hauling across it. Evidence of lost stability includes pumping, rutting or lateral displacement of embankment. The Contractor shall also alter hauling equipment or procedures to prevent further damage.

2-03.3(14)D Compaction and Moisture Control Tests

Maximum density and optimum moisture content shall be determined by one of the following methods:

1. Materials with less than 30 percent by weight retained on the No. 4 sieve shall be determined using FOP for AASHTO T 99 Method A.
2. Materials with 30 percent or more by weight retained on the No. 4 sieve and less than 30 percent retained on the ¾-inch sieve shall be determined by WSDOT T 606 or FOP for AASHTO T 180 Method D. The determination of which test procedure to use will be made solely by the Contracting Agency.
3. Materials with 30 percent or more retained on the ¾-inch sieve shall be determined by WSDOT T 606.

In place density will be determined using Test Methods FOP for AASHTO T 310 and WSDOT SOP 615.

2-03.3(14)E Unsuitable Foundation Excavation

When the Contract or the Engineer requires it, the Contractor shall excavate unstable natural ground before building any embankment over it. This unstable material may include peat, muck, swampland, buried logs and stumps, or other material not fit for an embankment base. The Contractor shall excavate such material to the boundaries set by the Engineer.

The Work will not be considered unsuitable foundation excavation if the materials:

1. Came from the Roadway cut, ditch, or channel-change prisms.
2. Resulted from Structure excavation Class A or B.
3. Are covered in Section 2-03.3(3).

If the Contract provides no Bid item for unsuitable foundation excavation, the Contracting Agency will pay as provided in Section 1-04.4.

2-03.3(14)F Vacant

2-03.3(14)G Backfilling

When water fills an area after the removal of soft or unstable materials, the Contractor shall, if possible, drain the site so that any backfill may be compacted. If drainage is not possible, the Contractor shall use granular material for backfilling in water, including areas where blasting has displaced the soft material. The Special Provisions may require other backfilling methods.

The costs of pumping or digging temporary drainage ditches shall be incidental to and included in other items of Work that apply.

2-03.3(14)H Prefabricated Vertical Drains

The Contractor shall furnish all necessary labor, equipment and materials, and perform all operations necessary for the installation of prefabricated vertical drains in accordance with the details shown in the Plans and with the requirements of these Specifications.

The prefabricated drain shall consist of a continuous plastic drainage core wrapped in a nonwoven geotextile material as specified in the Contract.

The drains shall be free of defects, rips, holes, or flaws. During shipment and storage, the drain shall be wrapped in a heavy-duty protective covering. The storage area shall protect the drain material from sunlight, mud, dirt, dust, debris, and detrimental substances. Manufacturer certification shall be provided for all drain materials delivered to the project.

Vertical drains shall be staked by the Contractor and constructed prior to embankment construction.

Prior to installation of vertical drains, a sand drainage blanket shall be placed on the ground surface for use as a working platform. This platform shall have a minimum depth of 2 feet and shall consist of uncompacted material meeting the requirements of Section 9-03.13(1).

Vertical drains shall be installed with equipment that will cause a minimum of subsoil disturbance. A mandrel or sleeve shall be advanced through the subsoil using vibratory, constant load, or constant rate of advance methods. The mandrel shall have a maximum cross-sectional area of 14 square inches, shall protect the prefabricated drain material from tears, cuts, and abrasions during installation, and shall be provided with an “anchor” plate or rod. The “anchor” plate or rod shall provide sufficient strength to prevent the soil from entering the bottom during installation and shall anchor the bottom of the drain at the required depth when the mandrel is removed. Use of falling weight impact hammers or jetting will not be allowed within the compressible subsoil to be drained.

The prefabricated drains shall be installed vertically from the working surface to the required elevations and in a sequence that will not require equipment to travel over previously installed drains. The Contractor shall provide the Engineer with a suitable means of verifying the plumbness of the equipment and determining the depth of the drain at any time. The equipment shall not deviate more than 0.25 inches per foot from vertical.

Splices or connections in the prefabricated drain material shall be done in a professional manner to ensure continuity of the wick material. The prefabricated drain shall be cut to leave at least 6 inches protruding above the working platform at each drain location.

Where obstructions are encountered which cannot be penetrated the Contractor shall abandon the hole. A maximum of two attempts shall be made to install a new drain within 18 inches of the obstructed hole. Drains that otherwise deviate from the Plan location by more than 6 inches, or that are damaged or improperly installed, will be rejected.

Installation of the drains should consider and be coordinated with the geotechnical instrumentation shown in the Plans. Special care shall be taken when installing drains near instrumentation already in place. Replacement of instrumentation damaged by the Contractor will be the responsibility of the Contractor.

The Contractor shall demonstrate that the equipment, method, and materials produce a satisfactory installation in accordance with these Specifications. For this purpose, the Contractor shall be required to install trial drains at different locations within the Work area.

The Contractor shall submit a Type 2 Working Drawing consisting of details of the sequence and method of installation. The submittal shall, at a minimum, contain the dimensions and length of mandrel, a detailed description of the proposed method(s) for overcoming obstructions, and the proposed method(s) for splicing drains.

Approval by the Engineer will not relieve the Contractor of the responsibility to install prefabricated vertical drains in accordance with the Plans, Special Provisions, and these Specifications. If, at any time, the Engineer considers the method of installation does not produce a satisfactory drain, the Contractor shall alter the method and equipment as necessary.

2-03.3(14)I Embankments at Bridge and Trestle Ends

This Work consists of filling around the ends of trestles and bridges, the area defined in Section 1-01.3. The Contractor shall begin and complete this Work as soon as possible after each bridge is completed or when the Engineer requires.

The Contractor shall select fill material from the excavation sources elsewhere on the project. Bridge Approach Embankments shall be compacted to at least 95 percent of the maximum density as determined by the tests described in Section 2-03.3(14)D. In any embankment area where piles will be installed, the Contractor shall remove all solid material, rocks, broken concrete, etc., larger than 3 inches across that would interfere with pile driving.

To prevent the bridge from being distorted or displaced, the Contractor shall place backfill evenly around all sides and parts of the Structure. The Contractor shall not backfill any abutment prior to placing the Superstructure. After the Superstructure is in place, use of small compactors may be required to compact the backfill around the Structure. Embankments and backfill behind the abutments shall be brought up in layers and compacted concurrently. The difference in backfill height against each abutment shall not exceed 2 feet unless otherwise allowed by the Engineer.

The Contractor may request to place the abutment backfill (either full or partial height) prior to placement of the Superstructure by submitting Type 2E Working Drawings consisting of calculations confirming that the abutment is stable, both for overturning and sliding, without the Superstructure in place. The stability calculations shall assume a loading of 30 lbs/ft^3 equivalent fluid pressure and include at least a 2-foot surcharge for the backfill placement equipment. If the abutment backfill is allowed to be placed prior to completion of the Superstructure, the Contractor shall bear any added cost that results from the change.

The Contractor shall build the embankment under the bridge to the dimensions shown in the *Standard Plans* or detailed in the Plans.

Cost related to all Work described in this section shall be incidental to other Work and included in the unit Contract prices that apply.

2-03.3(14)J Gravel Borrow Including Haul

When required by the Plans or the Engineer, the Contractor shall use gravel borrow meeting the requirements of Section 9-03.14(1) to:

1. Build structural embankments.
2. Backfill excavation of unsuitable foundation material above the ground water table.
3. Backfill below-grade excavation above the ground water table.
4. Construct mechanically stabilized earth walls.
5. Construct reinforced soil slopes.

Gravel borrow shall be compacted according to Sections 2-03.3(14)C and 2-03.3(14)D.

2-03.3(14)K Select or Common Borrow Including Haul

When required by the Plans or the Engineer, the Contractor shall use select borrow meeting the requirements of Section 9-03.14(2), or common borrow meeting the requirements of Section 9-03.14(3) to:

1. Build embankments.
2. Backfill excavation of unsuitable foundation material above the ground water table.
3. Backfill below-grade excavation above the ground water table.

Where specified, select borrow may be used for constructing reinforced slopes.

Select borrow and common borrow shall be compacted according to Sections 2-03.3(14)C and 2-03.3(14)D.

2-03.3(14)L Embankment Widening for Guardrail

Embankments widened for the installation of beam guardrail shall be terraced in accordance with the requirements for hillside terraces in Section 2-03.3(14). Compaction shall be in accordance with Method A, as specified in Section 2-03.3(14)C. Guardrail posts shall not be installed until the embankment widening is completed and compacted.

2-03.3(14)M Excavation of Channels and Ditches

Channel Excavation includes open excavations 8 feet wide or more at the bottom, but excludes channels that are part of the Roadway.

Ditch Excavation includes open excavations less than 8 feet wide at the bottom, but excludes ditches that are part of the Roadway.

Before excavating channels or ditches, the Contractor shall clear and grub the area in accordance with Section 2-01.

2-03.3(15) Aeration

The Contracting Agency may include aeration as a Contract item if material from test holes in excavation or borrow sites is too wet to compact properly. Even if the Contract includes such an item, the Contractor shall make every effort to reduce the need for aeration. The Contractor shall do so by using methods known to be effective in building embankments with wet materials. Such methods include open ditching to drain excavation areas or alternating layers of wet and dry materials. These and similar methods will be incidental to excavation and their costs shall be included in the unit Contract price for Roadway excavation, for borrow excavation (including haul), and for haul.

If aeration is not a Contract item, its cost shall be incidental to and included in the excavation and embankment items.

Aeration Equipment – The Engineer may direct the Contractor to use aeration equipment in these areas: Roadway excavation, borrow sites, or embankments. The Contracting Agency does not guarantee the moisture-reducing effectiveness of any single type of equipment. The Engineer may, however, require the use of any type that will best aerate a given area.

If the Contractor uses any of the following types of equipment, it shall meet these minimum requirements:

1. **Heavy-Duty Power Grader –** This machine shall have a moldboard measuring 12 feet long, 24 inches high, and ¾ inch thick. Each grader shall carry its maximum number of standard scarifier-rippers or discs.
2. **Heavy-Duty Gang Plow –** It shall have at least five 16-inch bottoms. Its tractor shall be able to move no less than 1½ mph while plowing at least 9 inches deep through fairly wet material.
3. **Heavy-Duty Tandem Discs –** This machine shall cut a swath at least 8 feet wide with discs no less than 28 inches in diameter. Its tractor shall be able to turn fairly wet material at least 6 inches deep while moving at 2 mph or more.
4. **Heavy-Duty Self-Propelled, Rotary Pulverizer –** This machine shall have paddles attached to a transverse shaft. It shall travel 1½ mph or more while aerating a swath at least 6 feet wide to a depth of 6 inches.

The Contractor shall not use any aerating equipment listed above in tandem nor use any of this equipment to carry out other Bid items of Work while aerating.

The Engineer may halt aerating Work when weather conditions prevent satisfactory results.

2-03.3(16) End Slopes

The Engineer will determine when and where to build end slopes, whether these occur at the beginning or end of a project, at the borders of excavation or embankments, at bridge ends, or elsewhere. The Contractor shall build end slopes not detailed in the Plans to the line and grade designated by the Engineer regardless of centerline limits shown in the Plans. All Work to complete and maintain these end slopes shall be considered as Work to be performed under the Contract.

2-03.3(17) Snow Removal

If snow deep enough to interfere with the Work covers a cut or an embankment, the Contractor shall remove and deposit it outside the slope stakes. Snow removal must be done at least 100 feet ahead of excavation and embankment Work. The Contractor shall remove snow at no expense to the Contracting Agency.

2-03.3(18) Stepped Slope Construction

When the Plans or the Engineer requires it, the Contractor shall shape slopes cut in soft rock to a stepped pattern conforming closely to the typical cross-section in the Plans. Stepped slopes shall meet these requirements:

1. Each step shall be 1 to 2 feet high.
2. The horizontal depth of each step will depend on its relationship to the staked slope ratio. The approximate midpoint of each horizontal tread shall occur on the staked slope line.
3. The treads shall be approximately level in all directions.
4. The ends of the steps shall be blended into the natural ground, with loose material removed from transitional areas.
5. If the Contractor cannot rip a rock outcropping within a cut, the steps shall be blended into the rock.
6. Large rocks and material that may fall into the ditch line or onto the Roadway shall be removed, but scaling is not required.

The compaction and seeding requirements of Section 8-01.3(2) shall not apply to stepped slope construction.

The Contracting Agency will measure stepped slope excavation by the area defined by the staked slope line. The unit Contract price per cubic yard for Roadway or borrow excavation shall be full pay for all labor and equipment required to build stepped slopes.

2-03.3(19) Removal of Pavement, Sidewalks, Curbs, and Gutters

The requirements of Section 2-02.3(3) shall also apply when pavements, sidewalks, curbs, and gutters lie within an excavation.

2-03.4 Measurement

Roadway excavation, channel excavation, ditch excavation, unsuitable foundation excavation, and common borrow items will be measured by the cubic yard. All excavated material will be measured in the position it occupied before the excavation was performed. An original ground measurement will be taken using cross-section or digital terrain modeling survey techniques. For Roadway excavation, channel excavation, and ditch excavation items, the original ground will be compared with the planned finished section shown in the Plans. Slope/ground intercept points defining the limits of the measurement will be as staked. For unsuitable foundation excavation and common borrow items, the original ground will be compared with a survey of the excavation area taken after the Work is completed. When the Contracting Agency requires excavated material to be stockpiled, re-excavated and moved again, a second measurement will be made, adding quantity for the same item used in the original excavation. The second measurement will be a comparison of the original cross-section of the stockpile with a cross-section of the stockpile area after the second excavation is completed.

If the excavation item does not include Haul, then the measurement provisions of Section 2-04 shall apply.

Gravel borrow and select borrow will be measured by the cubic yard or ton. Measurement by cubic yard will be made in the hauling vehicle.

Sand drainage blanket will be measured by the ton with deductions made for the weight of moisture above 8 percent.

Embankment compaction (Methods B and C in Section 2-03.3(14)C) will be measured by the cubic yard. An original ground measurement will be taken using cross-section or digital terrain modeling survey techniques. Quantities will be determined based on a comparison of the original ground measurement with the finished embankment section as staked. No allowance will be made for material that settles. No deduction will be taken for other items constructed within the embankment (bridge abutments, piers, columns, backfill, wall backfill, pipes, etc.). The Contracting Agency will exclude from compaction measurement material that is wasted or placed under water and not compacted in layers as provided by Sections 2-03.3(14)A and 2-03.3(14)C. In cuts, where excavation has been made below the planned Subgrade elevation, and in fills where excavation has been made below original ground, compaction will be measured by the cubic yard in the cross-section of compacted backfill material. When material below grade in cuts or in original ground beneath fills is scarified and recompacted, embankment compaction will be measured by its compacted depth, up to a maximum of 6 inches. There is no specific unit of measure and no measurement will be made for method A compaction as described in Section 2-03.3(14)C.

Controlled blasting of rock face will be measured by the linear foot of hole drilled. Holes will be measured from the top of the rock surface to the elevation of the Roadway ditch or to a bench elevation set by the Engineer. Quantities shown in the Plans are based on 30-inch hole spacing. Actual quantities will depend on field conditions and results from test sections.

Prefabricated vertical drains will be measured by the linear foot. Trial drains will be measured and included in the payment quantity for the prefabricated vertical drains. The drains will be measured from the top of the working platform to the bottom of each hole.

2-03.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Roadway Excavation", per cubic yard.

"Roadway Excavation Incl. Haul", per cubic yard.

"Roadway Excavation – Area ____", per cubic yard.

"Roadway Excavation Incl. Haul – Area ____", per cubic yard.

"Channel Excavation", per cubic yard.

"Channel Excavation Incl. Haul", per cubic yard.

"Ditch Excavation", per cubic yard.

"Ditch Excavation Incl. Haul", per cubic yard.

The unit Contract price per cubic yard for "Roadway Excavation", "Roadway Excavation Incl. Haul", "Roadway Excavation – Area __", "Roadway Excavation Incl. Haul – Area ___", "Channel Excavation", "Channel Excavation Incl. Haul", "Ditch Excavation", and "Ditch Excavation Incl. Haul" shall be full compensation for all costs incurred for excavating, loading, placing, or otherwise disposing of the material.

For "Haul", the unit Contract price as provided in Section 2-04 shall apply, except when the pay item is shown as including Haul. In that case the unit Contract price per cubic yard shall include "Haul". When a bid item is not included in the proposal for channel excavation or ditch excavation, all costs shall be included in roadway excavation.

When the Engineer orders Work according to Section 2-03.3(3), unit Contract prices shall apply unless the Work differs materially from the excavation above Subgrade, then payment will be in accordance with Section 1-04.4.

"Unsuitable Foundation Excavation", per cubic yard.

"Unsuitable Foundation Excavation Incl. Haul", per cubic yard.

The unit Contract price per cubic yard for "Unsuitable Foundation Excavation" and "Unsuitable Foundation Excavation Incl. Haul" shall be full payment for all costs incurred for excavating, loading, and disposing of the material. For "Haul", the unit Contract price as provided in Section 2-04 shall apply, except when the Bid item is shown as including Haul. In that case, the unit Contract price per cubic yard shall include "Haul".

"Common Borrow Incl. Haul", per cubic yard.

The unit Contract price per cubic yard for "Common Borrow Incl. Haul" shall be full compensation for all costs incurred for excavating, loading, hauling, placing, or otherwise disposing of the material. The unit Contract price includes removing, disposing of, wasting, or stockpiling any material in the borrow site that does not meet the Specifications for "Common Borrow".

"Select Borrow Incl. Haul", per ton.

"Select Borrow Incl. Haul", per cubic yard.

"Gravel Borrow Incl. Haul", per ton.

"Gravel Borrow Incl. Haul", per cubic yard.

"Sand Drainage Blanket", per ton.

The unit Contract price per ton or cubic yard for "Select Borrow Incl. Haul", "Gravel Borrow Incl. Haul" and "Sand Drainage Blanket" shall be full compensation for all costs incurred for excavating, loading, hauling, and placing the material unless otherwise specified in the Proposal.

"Embankment Compaction", per cubic yard.

The unit Contract price per cubic yard for "Embankment Compaction" shall be full compensation for all costs incurred for all material, labor, tools, equipment, and incidentals required.

When embankments are constructed using Method A compaction, payment for embankment compaction will not be made as a separate item. All costs for embankment compaction shall be included in other Bid items involved.

If the Bid item "Embankment Compaction" is not provided in the Proposal, compensation for costs incurred to perform the Work described in Section 2-03.3(14), Embankment Construction, shall be included in payment for other items of Work in the Contract.

"Aeration", by force account.

"Aeration" will be paid for by force account as specified in Section 1-09.6. The payment for aeration and other related unit Contract prices shall be full compensation for all costs incurred to perform the Work described in Section 2-03.3(15). Should the Contractor fail to seal an aerated area prior to inclement weather, additional aeration to restore the area to its previous condition shall be at the Contractor's expense.

For the purpose of providing a common Proposal for all Bidders, the Contracting Agency has entered an amount in the Proposal to become a part of the total Bid by the Contractor.

"Controlled Blasting of Rock Face", per linear foot.

The unit Contract price per linear foot for "Controlled Blasting of Rock Face" shall be full compensation for all costs incurred to perform the Work described in Section 2-03.3(2). Measurement and payment for Roadway excavation and haul related to blasting shall be as provided under those items in this section and shall include the volume of material excavated from the benches or setbacks approved for drilling separate lifts.

"Prefabricated Vertical Drain", per linear foot.

The unit Contract price per linear foot shall be full compensation for all costs incurred to perform the Work, including trial drains, as described in Section 2-03.3(14)H.

2-04 Haul

2-04.1 Description

This Work consists of transporting excavated material from its original site to its final place in the Work.

The balance points shown in the Plans are only approximate. The Engineer may change the balance points to help equalize quantities of materials or to dispose of surpluses.

When the Plans require hauling, the Contractor shall not substitute wasting or borrowing. The Contracting Agency will not pay extra for cross-hauling unless the Engineer so orders.

2-04.2 Vacant

2-04.3 Vacant

2-04.4 Measurement

The Contracting Agency will measure haul in units of haul where one unit equals 100-cubic yards of excavated material hauled 100 feet.

Excavated material will be measured in its original position. The Engineer will provide a copy of the location mass diagram upon request.

Haul On Right of Way – To compute units of haul, the Contracting Agency will measure haul distance parallel to the centerline (or base line) of the Highway. Lateral distance (cross-hauling) will not be measured.

Quantities to be measured in this way include: (1) material from the Roadway prism or prisms; (2) borrow from widened cuts; (3) waste deposited in the Right of Way or alongside it; and (4) material from Auxiliary Lanes – Frontage Roads, speed change lanes, paralleling and loop ramps, cross roads, and other lanes that supplement through-traffic movements.

If the Plans show more than one centerline or base line (as in a multi-lane Highway), the Plans or Special Provisions will describe the line by which haul will be computed.

Waste Haul Off Right of Way – The Contracting Agency will measure the cross-section and length of any waste embankment to calculate waste quantities. If the Plans or Special Provisions do not specify a haul route, the Contracting Agency will compute haul along the long axis of the waste embankment, thence along a line running perpendicular to the Highway center line, starting at the center line and ending at the nearest end of the waste embankment.

However, when a route is specified, haul distance will be measured along that route. If the Contractor chooses to use a route shorter than that computed or specified, the Contracting Agency will base payment on the length of the route actually used.

2-04.5 Payment

Payment will be made for the following Bid item when it is included in the Proposal:

"Haul", per unit.

2-05 Vacant

2-06 Subgrade Preparation

2-06.1 Description

This Work consists of preparing graded Roadbed for surfacing or surfaced Roadbed for paving.

2-06.2 Vacant

2-06.3 Construction Requirements

2-06.3(1) Subgrade for Surfacing

In preparing the Roadbed for surfacing, the Contractor shall:

1. Remove from the Roadbed, immediately before placing surfacing materials, all brush, weeds, vegetation, grass, and other debris.
2. Dispose of all debris as the Engineer directs.
3. Drain water from all low spots or ruts.
4. Shape the entire Subgrade to a uniform surface running reasonably true to the line, grade, and cross-section as staked.
5. If necessary, the Contractor shall process the Subgrade in cut areas to remove materials too coarse for mechanical trimming and recompaction.
6. Compact the Subgrade to a depth of 6 inches. Compaction shall achieve 95 percent of the maximum density determined under the tests described in Section 2-03.3(14)D. If the underlying material is too soft to permit proper compaction of the Subgrade, the Contractor shall loosen, aerate (or excavate and remove), and compact the Subgrade until the top layer can be compacted as required.
7. Remove excess material that does not drift to low spots during grading and shaping. The Contractor shall dispose of this excess by placing it where the Subgrade lacks material or by wasting it, as the Engineer directs.
8. Add materials as the Engineer directs where the Subgrade needs more to bring it up to grade. The Contractor shall water and compact these added materials as needed to produce a true finished Subgrade.

If the Contract requires a trimming machine, it shall:

1. Maintain the grade and transverse slopes automatically through sensors that respond to reference lines on both edges of each Roadway.
2. Create a smooth, uniform surface free from chatter and ripples.

2-06.3(2) Subgrade for Pavement

Before any paving is placed, the Contractor shall bring the Subgrade to the required line, grade, and cross-section. The Contractor shall compact the Subgrade to a depth of 6 inches to 95 percent of maximum density as determined by the compaction control tests for granular materials. The compacted area shall be wide enough to let paving machines operate without visible distortion of surfacing material.

The Contractor shall maintain the Subgrade in the required condition until the pavement is placed. The Contractor may remove material just before paving if the Plans require thicker areas of pavement.

2-06.4 Vacant

2-06.5 Measurement and Payment

2-06.5(1) Subgrade Constructed Under Same Contract

Surfacing or Treated Base – If the Contractor builds a Subgrade for surfacing or treated base, the Contracting Agency will consider Subgrade preparation as part of the construction Work. In this case, measurement and payment will conform to Section 2-03. Such payment shall be the full price for all Subgrade preparation Work.

Pavement – If the Contractor builds a Subgrade for pavement, the Contracting Agency will follow the criteria in Section 5-04 (for HMA pavement) or Section 5-05 (for cement concrete pavement) to measure and pay for materials used to prepare the Subgrade. The Contracting Agency will measure and pay for water as specified in Section 2-07.

2-06.5(2) Subgrade Not Constructed Under Same Contract

When the Contractor prepares an existing Subgrade for surfacing (one not built under the present Contract), the Contracting Agency will measure and pay for the Work by these criteria:

1. **Final Conditioning –** All the following Work on the Subgrade shall be included in other Contract Bid items: clearing vegetation and other debris, draining water, smoothing to prepare for staking, grading, shaping, and compacting to a 6-inch depth to final line, grade, and cross-section.
2. **Excess Materials –** If the Contractor must dispose of excess materials during grading and shaping, the Contracting Agency will measure and pay for the Work as Roadway excavation. If the Contract includes no pay item for Roadway excavation, the Contracting Agency will measure and pay as provided in Section 1-04.4.
3. **Added Materials –** If the Subgrade requires more materials, the Contracting Agency will pay the unit Contract price for each kind of material the Contractor provides. The unit Contract price shall be full pay for furnishing, placing, and compacting the materials. When unit Contract prices do not apply, the Contracting Agency will measure and pay for the Work as provided in Section 1-04.4.

4. **Excavation and Backfill –** If the Engineer orders the Contractor to excavate unstable spots in the Subgrade, the Contracting Agency will measure and pay for the Work as Roadway excavation. If the Contract does not include Roadway excavation as a pay item, payment will be by agreed price or force account. The Contracting Agency will pay unit Contract prices for suitable backfill material when included in the Contract and will pay as provided in Section 1-04.4 when not included.
5. **Subgrade Protection –** No payment shall be made for protecting the Subgrade.

2-07 Watering

2-07.1 Description

This Work consists of furnishing, hauling, and applying water for compacting embankments, constructing Subgrade, placing of crushed surfacing, dust control, and as the Engineer requires.

2-07.2 Vacant

2-07.3 Construction Requirements

The Contractor shall apply water by means of tank trucks equipped with spray bars. Spray controls shall ensure that the water flows evenly and in the amounts required by the Engineer. The Engineer may direct that the Contractor apply water at night or early in the morning to reduce evaporation losses.

2-07.4 Measurement

Water will be measured by the gallon using tanks or tank trucks of known capacity or by meters approved by the Engineer. The Contractor shall supply and install any meters at no expense to the Contracting Agency.

2-07.5 Payment

Payment will be made for the following Bid item when it is included in the Proposal:

> "Water", per M gal.
>
> The unit Contract price per M gallon for "Water" shall be full pay for all labor, materials, tools, and equipment necessary to furnish, haul, and apply the water.

When the Contract does not include water as a pay item, providing and applying the water shall be incidental to construction. All costs shall be included in the other Contract pay items.

2-08 Vacant

2-09 Structure Excavation

2-09.1 Description

Structure excavation consists of excavating and disposing of all natural material or man-made objects that must be removed to make way for bridge foundations, retaining walls, culverts, trenches for pipelines, conduits, and other Structures as shown in the Plans.

This Work also includes, unless the Contract provides otherwise, removing whole or partial Structures, grubbing Structure sites that would not otherwise be grubbed, building and later removing shoring, cofferdams, or caissons, pumping or draining excavated areas, protecting excavated materials from the weather, and placing and compacting backfill.

2-09.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Fine Aggregate for Concrete	9-03.1(2)
Admixture for Concrete	9-23.6
Fly Ash	9-23.9
Ground Granulated Blast Furnace Slag	9-23.10
Water	9-25

2-09.3 Construction Requirements

2-09.3(1) General Requirements

All Structure excavation, trenching, and shoring shall be performed in strict compliance with WAC 296-155 as well as all other applicable local, Contracting Agency, and Federal laws and regulations.

2-09.3(1)A Staking, Cross-Sectioning, and Inspecting

The Contractor shall not begin excavating until after the stakes have been set to locate and/or outline the Structure and taken cross-sections to determine how much material to remove. The Engineer will occasionally inspect material taken from and material remaining in the excavation.

2-09.3(1)B Depth of Excavation

The Contractor shall excavate foundation pits to the depth the Plans require, or to any revised depth ordered by the Engineer.

2-09.3(1)C Removal of Unstable Base Material

When the material at the bottom of an excavation is not stable enough to support the Structure, the Contractor shall excavate below grade and replace the unstable material with gravel backfill.

Gravel backfill shall meet the requirements of Section 9-03.12. It shall be placed in layers not more than 6 inches thick with each layer compacted to 95 percent of the maximum density determined by the Compaction Control Test, Section 2-03.3(14)D.

2-09.3(1)D Disposal of Excavated Material

The Engineer may direct the Contractor to dispose of excavated material in embankments, backfills, or remove it from the site.

All costs for disposing of excavated material within the project limits shall be included in the unit Contract price for Structure excavation, Class A or B. If, however, the Contractor must load and haul the material to a disposal site, the Contracting Agency will pay as provided in Section 1-04.4 for loading and hauling. The Contracting Agency will not pay for handling at the disposal site. Any such disposal shall meet the requirements of Section 2-03.3(7)C.

If the Contract includes Structure excavation, Class A or B, including haul, the unit Contract price shall include all costs for loading and hauling the material the full required distance.

2-09.3(1)E Backfilling

The backfilling of openings dug for Structures shall be a necessary part of and incidental to the excavation. Unless the Engineer directs otherwise, backfill material shall be nonclay material containing no pieces more than 3 inches across, no frozen lumps, and no wood or other foreign material.

When specified in the Contract or when approved by the Engineer, the Contractor shall supply controlled density fill as backfill material.

Alternative Sources. When material from Structure excavation is unsuitable for use as backfill, the Engineer may require the Contractor to:

1. Use other material covered by the Contract if such substitution involves Work that does not differ materially from what would otherwise have been required,
2. Substitute selected material in accordance with Section 2-03.3(10),
3. Use Controlled Density Fill (CDF) also known as Controlled Low Strength Material (CLSM)), or
4. Obtain material elsewhere. Material obtained elsewhere will be paid for in accordance with Section 1-04.4.

Controlled Density Fill (CDF) or Controlled Low-Strength Material (CLSM) – CDF is a self compacting, cementitious, flowable material requiring no subsequent vibration or tamping to achieve consolidation. The Contractor shall provide a mix design in writing to the Engineer on WSDOT Form 350-040 and utilize ACI 229 as a guide to develop the CDF mix design. No CDF shall be placed until the Engineer has reviewed the mix design. CDF shall be designed to have a minimum 28-day strength of 50 psi and a maximum 28-day strength not to exceed 300 psi. The CDF consistency shall be flowable (approximate slump 3 to 10 inches).

The following testing methods shall be used by the Contractor to develop the CDF mix design:

28-day compressive strength – ASTM D4832;

Unit weight, yield, and air content – ASTM D6023;

Slump – FOP for AASHTO T 119.

The water/cement ratio shall be calculated on the total weight of cementitious material. Cementitious materials are those listed in Section 5-05.2.

Admixtures used in CDF shall meet the requirements of Section 9-23.6, Admixtures for Concrete, and foaming agents, if used, shall meet the requirements of ASTM C869. Admixtures shall be used in accordance with the manufacturer's recommendations and non-chloride accelerating admixtures may be used to accelerate the hardening of CDF.

CDF shall meet the requirement of Section 6-02.3(5)C and shall be accepted based on a Certificate of Compliance. The producer shall provide a Certificate of Compliance for each truckload of CDF in accordance with Section 6-02.3(5)B.

Stockpiling – The Engineer may require the Contractor to selectively remove and stockpile any usable material excavated for a Structure. If this material meets the requirements for gravel backfill for walls it may replace gravel as wall or abutment backfill.

If the Contractor stockpiles excavated material for use as backfill, it shall be protected with plastic sheeting or by some other method from contamination and weather damage. If the material becomes too wet or contaminated in the stockpile, the Contractor shall dispose of and replace it with an equal amount of suitable material, all at no expense to the Contracting Agency. All costs for storing, protecting, rehandling, and placing stockpiled material shall be included in the unit Contract price for Structure excavation, Class A or B.

Compaction – Backfill from Structure excavation shall be placed and compacted in keeping with the following requirements:

1. Backfill supporting Roadbed, Roadway embankments, or Structures, including backfill providing lateral support for noise barrier wall foundations, luminaire poles, traffic signal standards, and roadside and overhead sign Structure foundations shall be placed in horizontal layers no more than 6 inches thick with each layer compacted to 95 percent of the maximum density determined by the Compaction Control Test according to Section 2-03.3(14)D.

2. Gravel backfill for drains shall be placed in horizontal layers no more than 12 inches thick, with each layer compacted by at least three passes of a vibratory compactor approved by the Engineer.
3. All other structure excavation backfill shall be placed in layers no more than 2 feet thick (loose), with each layer tamped and graded so that final settling will leave the backfill flush with surrounding ground.
4. Compaction of controlled density fill will not be required.

Timing – Backfill shall not be placed against any concrete Structure until the concrete has attained 90 percent of its design strength and a minimum age of 14 days, except that reinforced concrete retaining walls 15 feet in height or less may be backfilled after the wall has attained 90 percent of its design compressive strength and curing requirements of Section 6-02.3(11) are met. Footings and columns may be backfilled as soon as forms have been removed, so long as the backfill is brought up evenly on all sides.

The Engineer may order the Contractor to use lean concrete in backfilling around piers and in front of abutments and walls. The Contracting Agency will pay for such backfilling as provided in Section 1-04.4.

If water prevents the Contractor from properly placing and compacting backfill, it shall be removed by pumping or other means.

All costs not defined in this section that relate to providing, placing, and compacting backfill shall be at the Contractor's expense.

2-09.3(1)F Items to Remain

If the Contractor damages or removes pavement or anything else meant to remain outside the excavation area, it shall be repaired or replaced at no expense to the Contracting Agency.

2-09.3(2) Classification of Structure Excavation

1. **Class A –** Structure excavation required for bridge and retaining wall footings, precast reinforced concrete three sided structure footings, geosynthetic retaining walls, structural earth walls, sign structure footings, pile or drilled shaft caps, seals, wingwall footings, precast reinforced concrete box culverts, precast reinforced concrete split box culverts, detention vaults, and noise barrier wall footings shall be classified as Structure excavation Class A. If the excavation requires a cofferdam, structural shoring, or extra excavation, the work outside the neat lines of the Structure excavation Class A shall be classified as shoring or extra excavation Class A.
2. **Class B –** All other Structure excavation shall be Class B. If this excavation requires cofferdams, shoring, or extra excavation, the work outside the neat lines of the Structure excavation Class B shall be classified as shoring or extra excavation Class B.

2-09.3(3) Construction Requirements, Structure Excavation, Class A

2-09.3(3)A Preservation of Channel

When foundations or Substructures are to be built in or next to running streams, the Contractor shall:

1. Excavate inside cofferdams, caissons, or sheet piling unless dredging or open pit excavation is permitted.
2. Backfill foundations placed inside cofferdams and behind sheet piling prior to removing cofferdams or sheet piling. This backfill shall be level with the original streambed and shall prevent scouring.
3. Remove any excavation material that may have been deposited in or near the stream so that the watercourse is free from obstruction.
4. Maintain water depth and horizontal clearances required for traffic to pass on navigable streams, furnishing any channel signals or lights required during construction.
5. Place riprap around the outside of cofferdams, as specified, to repair local scour.

2-09.3(3)B Excavation Using Open Pits – Extra Excavation

The Contractor may dig open pits or perform extra excavation without shoring or cofferdams, if:

1. Footings can be placed in dry material away from running water.
2. The integrity of the completed Structure and its surroundings is not reduced.
3. Worker safety is ensured as required by law.
4. The excavation does not disturb the existing pavement or any other adjacent structural elements.

If a slide occurs in an open pit, the Contractor shall remove the slide material. If the slide disturbs an area over which a Highway will be built, the Contractor shall backfill and compact the site to the original ground line as approved by the Engineer. If the slide damages an existing facility such as a Roadway or Structure, the Contractor shall repair the damage caused by the slide. The Contractor shall pay all costs related to removing slide material and restoring the slide area, including the repair of any pavement or structural elements damaged by the slide.

The Contractor shall drain or pump any water from the pit, taking care not to stir up or soften the bottom. If equipment in the pit or inadequate water removal makes the foundation material unstable, the Contractor shall, at no expense to the Contracting Agency, remove and replace it with material acceptable to the Engineer.

When the Engineer believes ground water flow may impair a concrete footing, the Contractor shall place under it a layer of gravel at least 6 inches thick. Before placing the gravel, the Contractor shall excavate to whatever grade the Engineer requires. This provision shall not apply to the building of concrete seals.

The Contractor may omit forms when the earthen sides of a footing excavation will stand vertically. In this case, the Contractor may excavate to the neat line dimensions of the footing and pour concrete against the undisturbed earth. If the hole is larger than neat line dimensions, the Contractor shall bear the cost of the extra concrete.

For open temporary cuts, the following requirements shall be met:

1. No vehicular or construction traffic, or construction surcharge loads will be allowed within a distance of 5 feet from the top of the cut.
2. Exposed soil along the slope shall be protected from surface erosion.
3. Construction activities shall be scheduled so that the length of time the temporary cut is left open is reduced to the extent practical.
4. Surface water shall be diverted away from the excavation.

The excavation height (Ht) shall be calculated within a vertical plane as the difference between the lowest elevation in the excavation and the highest elevation of the ground surface immediately adjacent to the excavation. Pavement thickness and other surface treatments existing at the time of the excavation shall be included in the height calculation.

Submittals and Design Requirements

Excavations 4-feet and less in height do not require design and submittals. The Contractor shall provide a safe work environment and shall execute the work in a manner that does not damage adjacent pavements, utilities, or structures. If the Engineer determines the Contractor's work may potentially affect adjacent traffic, pavements, utilities, or structures, the Engineer may request a Type 1 Working Drawing from the Contractor. The Contractor shall explain in the Type 1 Working Drawing how the Engineer's concerns will be addressed, why infrastructure will not be damaged by the work, and how worker safety will be preserved.

For excavations that have soil types and slope geometries defined in WAC 296-155 part N and are between 4-feet and 20-feet in height, the Contractor shall submit Type 2 Working Drawings. Required submittal elements include, at a minimum, the following:

1. A plan view showing the limits of the excavation and its relationship to traffic, structures, utilities and other pertinent project elements. If the stability of the excavation requires no-load zones or equipment setback distances, those shall be shown on the plan view.
2. A typical or controlling cross section showing the proposed excavation, original ground line, and locations of traffic, existing structures, utilities, site constraints, surcharge loads, or other conditions that could affect the stability of the slope. If the stability of the excavation requires no-load zones or equipment setback distances, those shall be shown in cross section.
3. A summary clearly describing subsurface conditions, soil type for WAC 296-155 part N, and groundwater conditions, sequencing considerations, and governing assumptions.

Where WAC 296-155 part N requires an engineer's design, the Contractor shall submit Type 2E Working Drawings. Required submittal elements include, at a minimum, the three items above and the following additional items:

4. Supporting calculations for the design of the excavation, the soil and material properties selected for design, and the justification for the selection for those properties, in accordance with the WSDOT *Geotechnical Design Manual* M 46-03.
5. Safety factors, or load and resistance factors used, and justification for their selection, in accordance with the WSDOT Geotechnical Design Manual M 46-03, and referenced AASHTO design manuals.
6. A monitoring plan to evaluate the excavation performance throughout its design life
7. Any supplemental subsurface explorations made by the Contractor to meet the requirements for geotechnical design of excavation slopes, in accordance with the WSDOT *Geotechnical Design Manual* M 46-03.

2-09.3(3)C Preparation for Placing Foundations

When a foundation will rest on rock, excavation shall penetrate it at least 1 foot, or more if the Plans require, to form a key for the footing. The Contractor shall cut the bottom of the excavation to a firm surface, level, stepped, or serrated as the Engineer directs, and remove all loose material.

For an arch abutment, the back face shall be trimmed to true lines so that concrete can be poured against undisturbed material.

If concrete will rest on any excavated surface other than solid rock, the Contractor shall not disturb the bottom of the excavation. The Contractor shall also remove all loose or soft material just before pouring the concrete.

Upon completing any foundation excavation, the Contractor shall notify the Engineer. No concrete or other permanent part of the Structure may be placed until the Engineer has given permission to proceed.

2-09.3(3)D Shoring and Cofferdams

Definitions – Structural shoring is defined as a shoring system that is installed prior to excavation. Structural shoring shall provide lateral support of soils and limit lateral movement of soils supporting Structures, Roadways, utilities, railroads, etc., such that these items are not damaged as a result of the lateral movement of the supporting soils.

Structural shoring systems includes driven cantilever sheet piles, sheet piles with tiebacks, sheet pile cofferdams with wale rings or struts, prestressed spud piles, cantilever soldier piles with lagging, soldier piles with lagging and tiebacks, and multiple tier tieback systems.

Trench boxes, sliding trench shields, jacked shores, shoring systems that are installed after excavation, and soldier pile, sheet pile, or similar shoring walls installed in front of a pre-excavated slope, are not allowed as structural shoring.

A cofferdam is any watertight enclosure, sealed at the bottom and designed for the dewatering operation, that surrounds the excavated area of a Structure. The Contractor shall use steel sheet pile or interlocking steel pile cofferdams in all excavation that is under water or affected by ground water.

Submittals and Design Requirements – The Contractor shall submit Type 2E Working Drawings with supporting calculations showing the proposed methods and construction details of structural shoring or cofferdams in accordance with Sections 1-05.3 and 6-02.3(16).

Structural shoring and cofferdams shall be designed in accordance with the WSDOT Geotechnical Design Manual M 46-03. Allowable stresses for materials shall not exceed stresses and conditions allowed by Section 6-02.3(17)B.

For open temporary cuts associated with a shoring system, the requirements for open temporary cuts specified in Section 2-09.3(3)B shall be met.

The structural shoring system shall be designed for site specific conditions which shall be shown and described in the Working Drawings. The structural shoring system design shall include the design of the slopes for stability above and below the shoring system. Except as otherwise noted, the design height of all structural shoring in design calculations and Working Drawings shall be for the depth of excavation as required by the Plans, plus an additional 2 feet to account for the possibility of overexcavation. If the Contractor provides written documentation to the satisfaction of the Engineer that the soil conditions at the site are not likely to require overexcavation, the Engineer may waive the requirement for 2 feet of overexcavation design height.

Examples of such items that shall be shown on the structural shoring submittal and supported by calculations include, but are not limited to, the following:

1. Heights; soil slopes; soil benches; and controlling cross sections showing adjacent existing foundations, utilities, site constraints, and any surcharge loading conditions that could affect the stability of the shoring system, including any slopes above or below the shoring.
2. A summary clearly describing performance objectives, subsurface soil and groundwater conditions, sequencing considerations, and governing assumptions.
3. Any supplemental subsurface explorations made to meet the requirements for geotechnical design of excavation slopes, shoring walls, and other means of ground support, in accordance with the WSDOT *Geotechnical Design Manual* M 46-03.
4. Supporting geotechnical calculations used to design the shoring system, including the stability evaluation of the shoring system in its completed form as well as intermediate shoring system construction stages, the soil and material properties selected for design, and the justification for the selection for those properties, in accordance with the WSDOT *Geotechnical Design Manual* M 46-03.
5. Safety factors, or load and resistance factors used, and justification for their selection.

6. Location and weight of construction equipment adjacent to the excavation; location of adjacent traffic; and structural shoring system material properties, spacing, size, connection details, weld sizes, and embedment depths.
7. Structural shoring installation and construction sequence, procedure, length of time for procedure and time between operations; proof load testing procedure if any; deadman anchor design and geometry; no load zones; grouting material and strengths; and a list of all assumptions.
8. Methods and materials to be used to fill voids behind lagging, when soldier piles with lagging are used as structural shoring.
9. A monitoring/testing plan to evaluate the performance of the excavation/shoring system throughout its design life, and
10. An estimate of expected displacements or vibrations, threshold limits that would trigger remedial actions, and a list of potential remedial actions should thresholds be exceeded. Thresholds shall be established to prevent damage to adjacent facilities, as well as degradation of the soil properties due to deformation.

Construction Requirements – Structural shoring or cofferdams shall be provided for all excavations near completed Structures (foundations of bridges, walls, or buildings), near utilities, and near railroads.

All other excavations 4 feet or more in depth shall either be shored with structural shoring or cofferdams, or shall meet the open-pit requirements of Section 2-09.3(3)B.

Existing foundations shall be supported with structural shoring if the excavation is within the limits defined by a plane which extends out from the nearest edge of the existing footing a level distance of ½ the width of the existing footing and then down a slope of 1.5:1.

When structural shoring or cofferdams are utilized, all excavation and structural shoring shall be constructed in accordance with the processed structural shoring submittal, including any required construction sequence noted in the Working Drawings. The Contractor shall remain responsible for satisfactory results.

If soldier piles are placed in drilled holes, and lagging is installed concurrently with the excavation, all backfill above the bottom of the lagging shall consist of controlled-density fill or lean concrete. Backfill below the bottom of the lagging may consist of pea gravel. If full-height steel sheet lagging is installed prior to excavation, soldier pile holes may be backfilled with pea gravel.

If lagging is used, void space behind the lagging shall be minimized. If the Engineer determines that the voids present could result in damage or serviceability problems for the structural shoring system or any Structures or facilities adjacent to the structural shoring system, the Contractor shall cease excavation and lagging installation, and shall fill the voids specified by the Engineer in accordance with the approved structural shoring submittal. Further excavation and lagging placement shall not continue until the specified voids are filled to the satisfaction of the Engineer.

Excavation shall not proceed ahead of lagging installation by more than 4 feet or by the height that the soil will safely stand, whichever is least. For tieback shoring systems, excavation shall not proceed ahead by more than 4 feet of the tie installation and proof testing.

In using cofferdams or structural shoring, the Contractor shall:

1. Extend cofferdams well below the bottom of the excavation, and embed structural shoring as shown in the structural shoring submittal as approved by the Engineer.
2. Provide enough clearance for constructing forms, inspecting concrete exteriors, and pumping water that collects outside the forms. If cofferdams tilt or move laterally during placement, the Contractor, at no expense to the Contracting Agency, shall straighten or enlarge them to provide the required clearance.
3. Secure the cofferdam in place to prevent tipping or movement.
4. Place structural shoring or cofferdams so that they will not interfere with any pile driving required.
5. Not place any shoring, braces, or kickers inside the cofferdams and structural shoring that will induce stress, shock, or vibration to the permanent Structure.
6. Vent cofferdams at the elevation commensurate with seal weight design, or as shown in the Plans.
7. Remove all bracing extending into the concrete being placed.

When the Work is completed, the Contractor shall:

1. Remove all structural shoring to at least 2 feet below the finished ground line.
2. Remove all cofferdams to the natural bed of the waterway.

2-09.3(3)E Bearing Tests

The Engineer may stop the excavation to make bearing tests at any time. The Contractor shall assist with these tests in any way the Engineer requires.

During any test period, the Contractor shall, at no expense to the Contracting Agency, maintain ordinary working conditions at the bottom of the hole. The Contracting Agency will pay force account for all labor and materials the Contractor supplies for such tests. A single test shall not exceed 72 hours.

2-09.3(4) Construction Requirements, Structure Excavation, Class B

The above requirements for Structure excavation Class A, shall apply also to Structure excavation Class B, except as revised below. In addition, the Contractor shall follow Division 7 of these Specifications as it applies to the specific kinds of Work.

The hole for any catch basin or manhole shall provide at least 1 foot of clearance between outside structural surfaces and the undisturbed earth bank.

If workers enter any trench or other excavation 4 feet or more in depth that does not meet the open pit requirements of Section 2-09.3(3)B, it shall be shored or other safety method constructed in conformance with WISHA requirements. The Contractor alone shall be responsible for worker safety and the Contracting Agency assumes no responsibility.

The Contractor shall submit Type 2E Working Drawings in accordance with Section 2-09.3(3)D.

Trench boxes may be used for Structure excavation, Class B. Acceptance of trench boxes as a shoring method for Class B Structure excavation can be done by the Engineer provided it is not used to support adjacent traffic, existing footings, or other Structures. The Working Drawing submittal shall include the manufacturer's certified trench box plans with depth restrictions, and the serial number for field verification of the trench box.

Upon completing the Work, the Contractor shall remove all shoring unless the Plans or the Engineer direct otherwise.

2-09.4 Measurement

Excavated materials will be measured in their original position by the cubic yard. The Contracting Agency will measure and pay for only the material excavated from inside the limits this section defines. If the Contractor excavates outside these limits or performs extra excavation as described in Section 2-09.3(3)B, it shall be considered for the Contractor's benefit and shall be included in the cost of other Bid items.

Horizontal Limits – The Contracting Agency will use the sides of the trench or pit as horizontal limits in measuring excavation. No payment for Structure excavation will be made for material removed (1) more than 1 foot outside the perimeter of any pile cap, footing, or seal; (2) more than 3 feet beyond the Roadway side of a wing wall; (3) more than 1 foot beyond the other sides and end of a wing wall; (4) more than 1 foot outside the perimeter of the soil reinforcement area for geosynthetic and structural earth walls; and (5) more than 4-feet beyond the inside opening of precast reinforced concrete box culverts and precast reinforced concrete split box culverts. For precast reinforced concrete three sided structures, no payment for Structure excavation will be made for material removed more than 1 foot outside the perimeter of the footing or more than 4 feet beyond the inside opening, whichever is greater.

For all pipes, pipe arches, structural plate pipes, and underpasses, the Structure excavation quantity will be calculated based on the following trench widths:

For drain and underdrain pipes, trench width = I.D. + 12 inches.

For pipes 15 inches and under, trench width = I.D. + 30 inches.

For pipes 18 inches and over, trench width = (1.5 × I.D.) + 18 inches.

For a manhole, catch basin, grate inlet, or drop inlet, the limits will be 1 foot outside the perimeter of the Structure.

For drywells, the limits shall be in accordance with the *Standard Plans*.

Lower Limits – For a pile cap, footing, or seal, the bottom elevation shown in the Plans, or set by the Engineer, will serve as the lower limit in measuring Structure excavation. For a wing wall, the lower limit will follow a line parallel to the bottom and 1 foot below it. Any swell from pile driving will be excluded from excavation quantities.

For pipelines the lower limit in measuring structure excavation will be the foundation level as shown in the Plans or as directed by the Engineer.

Upper Limits – The top surface of the ground or streambed as the Work begins will be the upper limit for measuring excavation. If the Contract, or a separate contract, includes a pay item for grading to remove materials, the upper limit will be the neat lines of the grading section shown in the Plans.

The Engineer may order the Contractor to partially build the embankment before placing pipe. In this case, the upper limit for measurement will be not more than 4 feet above the invert of the pipe. For a structural plate pipe, arch, or box, the upper limit will be the top of the embankment at the time of installation as specified in Section 6-20.

Gravel Backfill – Gravel backfill, except when used as bedding for culvert, storm sewer, sanitary sewer, manholes, and catch basins, will be measured by the cubic yard in place determined by the neat lines required by the Plans.

Shoring or Extra Excavation – No specific unit of measurement shall apply to the lump sum item of shoring or extra excavation Class A. Shoring or extra excavation Class B will be measured by the square foot as follows:

The area for payment will be one vertical plane measured along the centerline of the trench, including Structures. Measurement will be made from the existing ground line to the bottom of the excavation and for the length of the Work actually performed. If the Contract includes a pay item for grading to remove materials, the upper limit for measurement will be the neat lines of the grading section shown in the Plans. The bottom elevation for measurement will be the bottom of the excavation as shown in the Plans or as otherwise established by the Engineer.

Controlled density fill will be measured by the cubic yard for the quantity of material placed in accordance with the producer's invoice.

2-09.5 Payment

Payment will be made for the following Bid items when they are included in the Proposal:

"Structure Excavation Class A", per cubic yard.

"Structure Excavation Class B", per cubic yard.

"Structure Excavation Class A Incl. Haul", per cubic yard.

"Structure Excavation Class B Incl. Haul", per cubic yard.

Payment for reconstruction of surfacing and paving within the limits of Structure excavation will be at the applicable unit prices for the items involved.

If the Engineer orders the Contractor to excavate below the elevations shown in the Plans, the unit Contract price per cubic yard for "Structure Excavation Class A or B" will apply. But if the Contractor excavates deeper than the Plans or the Engineer requires, the Contracting Agency will not pay for material removed from below the required elevations. In this case, the Contractor, at no expense to the Contracting Agency, shall replace such material with concrete or other material the Engineer approves.

"Shoring or Extra Excavation Cl. A _____", lump sum.

When extra excavation is used in lieu of constructing the shoring, cofferdam or caisson, the lump sum Contract price shall be full pay for all excavation, backfill, compaction, and other Work required. If select backfill material is required for backfilling within the limits of Structure excavation, it shall also be required as backfill material for the extra excavation at the Contractor's expense.

If it is necessary to place riprap outside of cofferdams to repair local scour, it shall be paid by agreed price or force account.

If the Engineer requires shoring, cofferdams, or caissons when the Contract provides no Bid item for such Work, the Contracting Agency will pay as provided in Section 1-04.4.

If the Engineer requires the Contractor to build shoring or extra excavation Class A that extends below the elevation shown in the Plans, the Contracting Agency shall pay the lump sum price and no more when the extra depth does not exceed 3 feet. For depths greater than 3 feet below the elevations shown, payment will be as provided in Section 1-04.4.

"Shoring or Extra Excavation Class B", per square foot.

The unit Contract price per square foot shall be full pay for all excavation, backfill, compaction, and other Work required when extra excavation is used in lieu of constructing shoring. If select backfill material is required for backfilling within the limits of the Structure excavation, it shall also be required as backfill material for the extra excavation at the Contractor's expense.

If there is no Bid item for shoring or extra excavation Class B on a square foot basis and the nature of the excavation is such that shoring or extra excavation is required as determined by the Engineer, payment to the Contractor for the Work will be made in accordance with Section 1-04.4.

"Gravel Backfill (_____)", per cubic yard.

"Controlled Density Fill", per cubic yard.

2-10 Vacant

2-11 Trimming and Cleanup

2-11.1 Description

This Work consists of dressing and trimming the entire Roadway(s) improved under the Contract, including Frontage Roads, connecting ramps, Auxiliary Lanes, and approach roads. This Work extends to Roadbeds, Shoulders, and ditches.

2-11.2 Vacant

2-11.3 Construction Requirements

The Contractor shall:

1. Trim Shoulders and ditches to produce smooth surfaces and uniform cross-sections that conform to the grades set by the Engineer.
2. Open and clean all channels, ditches, and gutters to ensure proper drainage.
3. Dress the back slope of any ditch or borrow pit that will remain adjacent to the Roadway. Round off the top of the back slope and distribute the material evenly along its base.
4. Remove and dispose of all weeds, brush, refuse, and debris that lie on the Roadbed, Shoulders, ditches, and slopes.
5. Remove from paved Shoulders all loose rocks and gravel.
6. Distribute evenly along the embankment any material not needed to bring the Shoulders to the required cross-section.

The Contractor shall not:

1. Use heavy equipment (tractors, graders, etc.) to trim the Shoulders of an existing or new bituminous surface.
2. Drag, push, or scrape Shoulder material across completed surfacing or pavement.

When the Contract requires the Contractor to rebuild part of a Roadway only the rebuilt areas shall be trimmed and cleaned up. If the Contractor's Work obstructs ditches or side roads, they shall be cleared and the debris disposed of as the Engineer directs.

2-11.4 Vacant

2-11.5 Payment

Payment shall be made for the following Bid item when it is included in the Proposal:

"Trimming and Cleanup", lump sum.

2-12 Construction Geosynthetic

2-12.1 Description

The Contractor shall furnish and place construction geosynthetic in accordance with the details shown in the Plans.

2-12.2 Materials

Materials shall meet the requirements of the following section:

Construction Geosynthetic 9-33

Geosynthetic roll identification, storage, and handling shall be in conformance to ASTM D4873. During periods of shipment and storage, the geosynthetic shall be stored off the ground. The geosynthetic shall be covered at all times during shipment and storage such that it is fully protected from ultraviolet radiation including sunlight, site construction damage, precipitation, chemicals that are strong acids or strong bases, flames including welding sparks, temperatures in excess of 160°F, and any other environmental condition that may damage the physical property values of the geosynthetic.

Unless specified otherwise in the Plans, the geotextile required for underground drainage shall be “Moderate Survivability” and “Drainage Class C” and permanent erosion control applications shall be “High Survivability” and “Drainage Class C”.

2-12.3 Construction Requirements

The area to be covered by the geosynthetic shall be graded to a smooth, uniform condition free from ruts, potholes, and protruding objects such as rocks or sticks. The geosynthetic shall be spread immediately ahead of the covering operation. The geosynthetic shall not be left exposed to sunlight during installation for a total of more than 14 calendar days. The geosynthetic shall be laid smooth without excessive wrinkles. Under no circumstances shall the geosynthetic be dragged through mud or over sharp objects which could damage the geosynthetic. The cover material shall be placed on the geosynthetic such that the minimum initial lift thickness required will be between the equipment tires or tracks and the geosynthetic at all times. Construction vehicles shall be limited in size and weight, to reduce rutting in the initial lift above the geosynthetic, to not greater than 3 inches deep to prevent overstressing the geosynthetic. Turning of vehicles on the first lift above the geosynthetic will not be permitted.

Soil piles or the manufacturer’s recommended method, shall be used as needed to hold the geosynthetic in place until the specified cover material is placed.

Should the geosynthetic be torn, punctured, or the overlaps or sewn joints disturbed, as evidenced by visible geosynthetic damage, Subgrade pumping, intrusion, or Roadbed distortion, the backfill around the damaged or displaced area shall be removed and the damaged area repaired or replaced by the Contractor at no expense to the Contracting Agency. The repair shall consist of a patch of the same type of geosynthetic placed over

the damaged area. The patch shall overlap the existing geosynthetic from the edge of any part of the damaged area by the minimum required overlap for the application.

If geotextile seams are to be sewn in the field or at the factory, the seams shall consist of one row of stitching unless the geotextile where the seam is to be sewn does not have a selvage edge. If a selvage edge is not present, the seams shall consist of two parallel rows of stitching, or shall consist of a J-seam, Type SSn-1, using a single row of stitching. The two rows of stitching shall be 1.0 inch apart with a tolerance of plus or minus 0.5 inch and shall not cross except for restitching. The stitching shall be a lock-type stitch. The minimum seam allowance, i.e., the minimum distance from the geotextile edge to the stitch line nearest to that edge, shall be 1½ inches if a flat or prayer seam, Type SSa-2, is used. The minimum seam allowance for all other seam types shall be 1.0 inch. The seam, stitch type, and the equipment used to perform the stitching shall be as recommended by the manufacturer of the geotextile and as approved by the Engineer.

The seams shall be sewn in such a manner that the seam can be inspected readily by the Engineer or a representative. The seam strength will be tested and shall meet the requirements stated herein.

2-12.3(1) Underground Drainage

Trench walls shall be smooth and stable. The geotextile shall be placed in a manner which will ensure intimate contact between the soil and the geotextile (i.e., no voids, folds, or wrinkles).

The geotextile shall either be overlapped a minimum of 12 inches at all longitudinal and transverse joints, or the geotextile joints shall be sewn for medium survivability drainage applications. In those cases where the trench width is less than 12 inches, the minimum overlap shall be the trench width.

In moderate survivability geotextile underdrain applications, the minimum overlap shall be 12 inches, or the geotextile joints shall be sewn, except where the geotextile is used in area drains. An area drain is defined as a geotextile layer placed over or under a horizontal to moderately sloping layer of drainage aggregate. For area drains, the geotextile shall be overlapped a minimum of 2 feet at all longitudinal and transverse joints, or the geotextile joints shall be sewn together. The minimum initial lift thickness over the geotextile in the area drain shall be 12 inches.

In all cases, the upstream geotextile sheet shall overlap the next downstream sheet.

2-12.3(2) Separation

The geotextile shall either be overlapped a minimum of 2 feet at all longitudinal and transverse joints, or the geotextile joints shall be sewn together. The initial lift thickness shall be 6 inches or more.

2-12.3(3) Soil Stabilization

The geotextile shall either be overlapped a minimum, of 2 feet at all longitudinal and transverse joints, or the geotextile shall be sewn together. The initial lift thickness shall be 12 inches or more. Compaction of the first lift above the geotextile shall be by Method A according to Section 2-03.3(14)C. No vibratory compaction will be allowed on the first lift.

2-12.3(4) Permanent Erosion Control and Ditch Lining

Unless otherwise shown in the Plans, the geotextile shall either be overlapped a minimum of 2 feet at all longitudinal and transverse joints, or the geotextile joints shall be sewn together. If overlapped, the geotextile shall be placed so that the upstream strip of geotextile will overlap the next downstream strip. When placed on slopes, each strip shall overlap the next downhill strip.

Placement of aggregate and riprap or other cover material on the geotextile shall start at the toe of the slope and proceed upwards. The geotextile shall be keyed at the top and the toe of the slope as shown in the Plans. The geotextile shall be secured to the slope, but shall be secured loosely enough so that the geotextile will not tear when the riprap or other cover material is placed on the geotextile. The geotextile shall not be keyed at the top of the slope until the riprap or other cover material is in place to the top of the slope.

All voids in the riprap or other cover material that allow the geotextile to be visible shall be backfilled with quarry spalls or other small stones, as designated by the Engineer, so that the geotextile is completely covered. When an aggregate cushion between the geotextile and the riprap or other cover material is required, it shall have a minimum thickness of 12 inches.

An aggregate cushion will be required to facilitate drainage when hand placed riprap, as specified in Section 9-13.1(4), is used with the geotextile.

Grading of slopes after placement of the riprap or other cover material will not be allowed if grading results in stone movement directly on the geotextile. Under no circumstances shall stones with a weight of more than 100 pounds be allowed to roll down slope. Stones shall not be dropped from a height greater than 3 feet above the geotextile surface if an aggregate cushion is present, or 1 foot if a cushion is not present. Lower drop heights may be required if geotextile damage from the stones is evident, as determined by the Engineer. If the geotextile is placed on slopes steeper than 2:1, the stones shall be placed on the slope without free-fall for moderate survivability, high survivability, and ditch lining geotextiles.

2-12.4 Measurement

Construction geotextile, with the exception of temporary silt fence geotextile and underground drainage geotextile used in trench drains, will be measured by the square yard for the ground surface area actually covered.

Underground drainage geotextile used in trench drains will be measured by the square yard for the perimeter of drain actually covered.

2-12.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Construction Geotextile for Underground Drainage", per square yard.

"Construction Geotextile for Separation", per square yard.

"Construction Geotextile for Soil Stabilization", per square yard.

"Construction Geotextile for Permanent Erosion Control", per square yard.

"Construction Geotextile for Ditch Lining", per square yard.

Sediment removal behind silt fences will be paid by force account under temporary water pollution/erosion control. If a new silt fence is installed in lieu of sediment removal, the silt fence will be paid for at the unit Contract price per linear foot for "Construction Geotextile for Temporary Silt Fence".

Division 3 Aggregate Production and Acceptance

3-01 Production From Quarry and Pit Sites

3-01.1 Description

This Work shall consist of manufacturing and producing crushed and screened aggregates including pit run aggregates of the kind, quality, and grading specified for use in the construction of concrete, hot mix asphalt, crushed surfacing, maintenance rock, ballast, gravel base, gravel backfill, gravel borrow, riprap, and bituminous surface treatments of all descriptions.

The requirements specified shall apply whether the source is ledge rock, talus, gravel, sand, or any combination thereof.

3-01.2 Material Sources, General Requirements

3-01.2(1) Approval of Source

Material sources must be approved in advance of use in the Work in accordance with the requirements of Section 1-06. This approval of source may require sampling and testing. If sampling is required, the samples must be taken at locations designated and witnessed by the Engineer or a designated representative. The Contractor is responsible for providing representative preliminary samples of aggregate sources to the Engineer.

3-01.2(2) Preparation of Site

The portion of the quarry or pit site to be used shall be cleared and grubbed, and the area from which materials are to be taken shall be stripped of overburden as provided in Section 3-01.2(3). All combustible debris resulting from these operations shall be disposed of by the Contractor in a manner satisfactory to the Engineer.

The Contractor shall provide sufficient space as required for the setup and operation of the Contracting Agency's field testing facilities at the site of crushing or hot mix asphalt production.

As directed by the Engineer, the Contractor shall provide one of the following to ensure 24-hour per day operation of the Contracting Agency's laboratory trailer(s) that may be set up at the site during production:

1. A power source and a power cord of sufficient length to reach the Contracting Agency's laboratory trailer(s) which may be set up at the site. The cord shall be capable of carrying at least 120/240 volts, 60 cycles at a sustained load of up to 200 amps. The cord and trailer(s) electrical hookup shall meet the NEC code. Power shall be provided and connected when requested by the Engineer. The laboratory trailer(s) hookup shall be protected by a 2 pole 50 amp 240 VAC circuit breaker.
2. A daily supply of fuel adequate for operation of the Contracting Agency's generator(s).

Potable water shall be provided to the Contracting Agency's laboratory trailer(s) for use during plant operations when requested by the Engineer.

3-01.2(3) Stripping Quarries and Pits

Stripping of quarries and pits shall consist of the removal, after clearing and grubbing, of the surface material and overburden which is unsuitable for the kind of material to be borrowed or produced for use. Materials from stripping, to be used later as provided on the site reclamation plan specified in Section 3-03, shall be deposited within the quarry or pit site at such a location as not to interfere with future development within the site.

3-01.2(4) Production Requirements

All oversize stones, rock fragments, or boulders occurring in the source, up to and including those measuring 18 inches in the greatest dimension, shall be utilized in the manufacture of crushed material.

If the grading or quality of raw material in sources used for the manufacture of products covered by this section is such that the fracture, grading, or quality of the product specified cannot be obtained by utilizing the natural material, fine portions of the raw material shall be rejected to the extent necessary to produce products meeting all requirements of these Specifications. Failure of the Contracting Agency to include a scalping requirement in the Special Provisions shall not relieve the Contractor of the responsibility for rejecting fine portions of the material if such becomes necessary to produce products meeting all requirements of these Specifications. Scalping shall be performed after the pit-run or quarry-run material has passed through the primary crusher.

When scalping over a screen of a specified size is required in the Special Provisions, the scalping screen shall be of such size and capacity that enough of the fine material will be removed to produce Work that conforms to the Specifications.

Washing and reclaiming of the reject material and subsequent addition of this material to any finished products will not be allowed unless specifically authorized in writing by the Engineer.

Surplus screenings accumulated during the crushing and screening of specified Roadway materials will be considered separate and distinct from reject material resulting from scalping operations.

Both fine and coarse concrete aggregates shall be thoroughly washed in order to remove clay, loam, alkali, bark, sticks, organic castings, or other deleterious matter. Washing will be required in the production of other materials if necessary to produce products meeting all the quality requirements of these Specifications.

When producing screened gravel or sand materials, the Contractor shall remove all oversize material by screening at the pit site. The Contractor's operations in the pit shall be conducted so that the grading of individual loads will be reasonably uniform. In

general, the Contractor shall utilize the most suitable materials available and shall make as many moves of the loading equipment as may be necessary to fulfill these requirements.

Where pit-run materials meet Specifications, screening or processing will not be required.

3-01.2(5) Final Cleanup

Upon completion of the Contractor's operation, the quarry or pit shall be cleared of all rubbish, temporary Structures, and equipment, and shall be left in a neat and presentable condition. The pit or quarry shall be reclaimed in accordance with the approved site reclamation plan specified in Section 3-03.

3-01.3 State Furnished Material Sources

Unless specified in the Special Provisions, no Contracting Agency material sources are provided and the Contractor shall bear full responsibility for furnishing all materials.

3-01.3(1) Quality and Extent of Material

Contracting Agency furnished material sources will be shown in the Plans and described in the Special Provisions. The quality of material in such sources will be acceptable in general, but the Contractor shall determine the amount of Work required to produce the material meeting these Specifications. It shall be understood that it is not feasible to ascertain from samples, the limits for an entire source, and that variations shall be considered as usual and are to be expected. The Engineer may order procurement of material from any portion of a source and may reject portions of the source as unacceptable.

Since many material sources are acquired in fee by the Contracting Agency for use on future projects as well as for this Contract, it is in the public interest to preserve the future usefulness and adequacy of a source insofar as may be practical. To achieve this end, the Contractor shall not perform any Work within the source until receiving the Engineer's approval of the Contractor's work plan within the limits of the source.

3-01.3(2) When More Than One Site is Provided

When more than one quarry or pit site is provided in the Special Provisions, the Contractor may obtain material from any of the sources. The Contracting Agency will specify the quantity of raw material available, as determined by tests, in each quarry or pit site. If the Contractor sets up in a site, and it is found that the quantity of raw material from that site, when the site is exhausted, is less than that specified by the Contracting Agency, then the provisions of Section 3-01.3(5) will apply.

3-01.3(3) Reject Materials

All scalpings that are unsatisfactory for use under these Specifications or Special Provisions shall be considered as reject material, subject to disposal as approved by the Engineer. Reject material shall be placed at such a location as not to interfere with future development within the site.

3-01.3(4) Surplus Screenings

The surplus screenings accumulated during the production of the specified materials shall be stockpiled at a location within the site provided and become the property of the Contracting Agency. The stockpile site shall be prepared and constructed by the Contractor in accordance with the provisions of Section 3-02. All costs incurred in producing, hauling, and stockpiling the surplus screenings shall be incidental to the production of the specified materials and shall be included by the Contractor in the unit Bid prices in the Contract.

3-01.3(5) Moving Plant

If, in the opinion of the Engineer, there should be insufficient suitable material in any quarry or pit site made available by the Contracting Agency, the Contracting Agency will acquire at its expense an additional source, in which event the Contractor will be required to move the crushing plant to the new quarry or site. Under such conditions, payment for the Contractor's costs for the move will be made on a force account basis. Payment will be limited to the labor, equipment, and materials required for the move, and no allowance will be made for payment of standby costs for the crushing plant nor other equipment which may be temporarily idle as a result of the move.

The clearing, grubbing, and preparing of the new quarries or pit sites as specified in Section 3-01.2(2) will be paid for in the manner provided in these Specifications for "Clearing", "Grubbing", and "Stripping Including Haul". If there is no Bid item applicable, the payment for the preparation of the new site will be as provided in Section 1-04.4.

If the moving of the plant due to shortage of the supply of material necessitates a longer haul on materials than required from the original source, the Contracting Agency will reimburse the Contractor for the additional haul at the rate of $0.25 per ton-mile haul. The unit ton-mile shall be the equivalent of 1 ton of material hauled a distance of 1 mile. The haul distance will be measured in ½-mile units, fractional half-miles being allowed as full half-miles. If the requirement for moving of the crushing plant results in a delay of performance of Work which is critical to completion of the project, as shown by the Contractor's approved progress schedule, the Engineer will authorize a suspension of Work for the time required for the move.

The above allowances, insofar as they may be applicable, shall be full pay for all claims of any kind or description by reason of the necessity of changing from one site to another due to shortage of the supply from sources made available by the Contracting Agency. Before moving a crushing plant as outlined above, the Contractor shall secure from the Engineer an order in writing to do so. Should the Contractor fail to secure such order, it shall be considered sufficient proof that the move was immaterial insofar as to cost, and no allowance or pay will be made by reason of such move.

3-01.4 Contractor Furnished Material Sources

3-01.4(1) Acquisition and Development

If, under the terms of the Contract, the Contractor is required to provide a source of materials, or if the Contractor elects to use materials from sources other than those provided by the Contracting Agency, the Contractor shall, at no expense to the Contracting Agency, make all necessary arrangements for obtaining the material and shall ensure the quantity of suitable material is available. Preliminary samples shall be taken by or in the presence of the Engineer or a designated representative unless the Engineer permits otherwise. Approval of the source does not relieve the Contractor from meeting these Specification requirements, nor does it guarantee that the material will meet these requirements without additional or proper processing. The Engineer may require additional preliminary samples at any time.

Approval of a Contractor's source offered in lieu of a Contracting Agency-provided source will be contingent upon the material therein being of equal quality, and no additional costs will accrue to the Contracting Agency as a result of such approval. Equivalency of quality will be based on those test values listed in the Special Provisions as being representative of material in the Contracting Agency-provided source. If no such values are listed, the minimum Specification requirements will apply. When measurement by weight is specified and when the specific gravity of material produced from the Contractor's source is greater than that from the Contracting Agency-furnished source, any additional material required to construct the minimum specified surfacing depth shall be furnished by the Contractor at no expense to the Contracting Agency.

The Contractor shall notify the State Departments of Ecology, Fish and Wildlife, and Natural Resources, in writing, of the intent to furnish the source, and shall, at no expense to the Contracting Agency, make all necessary arrangements with these agencies for the determinations of regulations which might be imposed upon the Contractor during removal of materials from the source.

The source shall be selected so that, after the materials have been removed, the pit will drain to a natural drainage course and no ponding will result. Should the source selected by the Contractor be one which would not drain as outlined herein, permission shall be obtained by the Contractor from the governing body of the city or county for the removal of materials from the pit or quarry.

The Contractor will not be permitted to operate a pit or a quarry site visible from a State Highway unless it can be demonstrated to the complete satisfaction of the Engineer that no unsightly condition will result from or remain as a result of the Contractor's operations. If, in the opinion of the Engineer, unsightly conditions exist after removal of materials from the site, the Contractor shall correct such unsightly conditions as hereinafter provided.

Following removal of materials from the pit, the entire site shall be cleared of all rubbish, temporary Structures, and equipment which have resulted from the Contractor's occupancy and operations. The Contractor shall obliterate or screen to the satisfaction of the Engineer any unsightly conditions that remain. The Contractor shall secure a written release from the permitter upon fulfillment of these requirements. All costs for cleaning up the pit site and for the installation or erection of screening or for other work required to correct unsightly conditions shall be at the Contractor's expense. The requirements of this paragraph shall not apply to pits being operated commercially.

All costs in connection with acquiring the rights to take materials from the source, for exploring and developing the site, for complying with the regulations of the aforesaid State agencies, for preparing the site as provided in Sections 3-01.2(2) and 3-03, for cleaning up the site, and for correcting unsightly conditions, shall be included in the unit Contract prices for the various pay items of Work involved.

3-01.4(2) Surplus Screenings

Surplus screenings accumulated during the manufacture of specified material shall remain the property of the Contractor.

3-01.4(3) Substitution of Gravel Deposit in Lieu of Ledge Rock or Talus Source Provided by the Contracting Agency

If the Contractor elects to substitute a gravel deposit of an approved source for the manufacture of ballast, crushed surfacing, or mineral aggregate in lieu of a ledge rock or talus source provided by the Contracting Agency in the Contract, all pit run materials passing a ½-inch-square sieve, or larger if ordered by the Engineer, shall be removed prior to crushing.

3-01.4(4) Gravel Base

If the Contract requires the Contractor to provide the source of Gravel Base, or if the Contractor elects to furnish said material from sources other than those provided by the Contracting Agency, the material shall be produced from approved sources in accordance with the requirements of Section 3-01. The grading and quality shall be as specified in Section 9-03.10.

Measurement and payment will be in accordance with Section 4-02.

3-01.5 Measurement

For payment purposes, all crushed, screened, or naturally occurring materials that are to be paid for by the ton, dependent upon their grading, will be limited to the following water contents naturally occurring in the material source:

Percent By Weight Passing No. 4	Maximum Water Content Percent By Weight
Less than 20	4
20 or more	8

Water in excess of the maximum permissible amounts naturally occurring in the material source, as determined by the Engineer, will be deducted from the tonnage of material to be paid for on a daily basis.

If the Contractor uses the Central Plant Mix Method of mixing water and surfacing materials in accordance with Section 4-04, the added water will be measured in accordance with Section 4-04.4. All other water added to the materials by the Contractor will be deducted from the weight of the aggregates including the added water, on a daily basis.

Clearing and grubbing of quarries and pit sites will be measured in accordance with Section 2-01 when the Proposal includes such Bid items and such Work is required on a source provided by the Contracting Agency, except as modified in Section 3-01.3(5).

Stripping of quarries and pit sites will be measured in cubic yards in its original position by cross-sectioning when the Proposal includes such Bid item and such stripping is required on a source provided by the Contracting Agency, except as modified in Section 3-01.3(5).

Measurement of the particular materials or aggregates to be produced will be as specified in the appropriate section of these Specifications.

3-01.6 Payment

All costs, except as specified, in connection with the production of materials meeting all quality requirements of these Specifications shall be included in the unit Contract prices of the various Bid items involved.

Clearing and grubbing of quarries and pit sites will be paid in accordance with Section 2-01 when the Proposal includes such Bid items and such Work is required on a source provided by the Contracting Agency, except as modified in Section 3-01.3(5).

"Stripping Incl. Haul", shall be paid for at the unit Contract price per cubic yard when the Proposal includes such Bid item and such stripping is required on a source provided by the Contracting Agency, except as modified in Section 3-01.3(5).

3-02 Stockpiling Aggregates

3-02.1 Description

This Work shall consist of preparing the stockpile sites and placing the specified aggregates in the stockpiles at the sites and in the amounts as shown in the Plans or as approved by the Engineer.

This section also includes the requirements pertaining to the removal of aggregates from stockpiles and the requirements for dressing up the stockpiles and stockpile site at the completion of the Work.

3-02.2 General Requirements

3-02.2(1) Stockpile Sites Provided by the Contracting Agency

The Contracting Agency may acquire and make available to the Contractor suitable areas as shown in the Plans for the construction of stockpiles. The stockpiled aggregates may be for use in the immediate Work or may be for future use as more fully described below. In either event, if the aggregates are required by these Specifications to be stockpiled, all costs in connection with the preparation of the stockpile sites as required in Section 3-02.2(5) shall be included in the various Bid items involved in the Contract; except that clearing and grubbing of the site will be measured and paid for in accordance with Section 2-01 only when such Bid items are included in the Proposal. In the event there is no Bid item included in the Proposal for construction and maintenance of haul roads to the stockpile site, the Contractor shall construct and maintain the haul roads as necessary and the cost thereof shall be included in the various Bid items in the Contract.

3-02.2(2) Stockpile Site Provided by the Contractor

If the Plans do not provide a stockpile site for the use of the Contractor in stockpiling certain types and sizes of aggregates which are required by these Specifications to be stockpiled prior to use in the immediate Work, all costs in connection with the acquisition of a site, the preparation of the site, construction of the stockpiles, and the removal of the aggregates from the stockpiles shall be included in the Contract prices of the various Bid items of Work involved.

3-02.2(3) Stockpiling Aggregates for Future Use

The Contracting Agency may require the production and stockpiling of aggregates on sites provided by the Contracting Agency for use on future construction or maintenance projects to be performed under a subsequent contract or by Contracting Agency forces.

When the Contract includes the Bid item or items for specific aggregates in stockpile and these aggregates are not to be used in Work required under the Contract, the Contractor shall produce or furnish these aggregates complying with the quality and grading requirements of these Specifications and shall prepare the site and place the aggregates in stockpile in accordance with the requirements of this section or as ordered by the Engineer in accordance with Section 1-04.4.

3-02.2(4) Stockpiling Aggregates for Immediate Use

If the Contractor elects to stockpile aggregates from a source owned or controlled by the Contracting Agency prior to use in the immediate Work, the stockpiling shall be done within the area of the site provided by the Contracting Agency and in accordance with the requirements of these Specifications. If the Contractor elects to lease land to stockpile the aggregates, the stockpiling shall be done in accordance with these Specifications and upon proof that the lease will extend for a period of not less than one year beyond the completion date of the Contract. All excess aggregates remaining in stockpiles after satisfying the needs of the Contract—whether upon the site provided by the Contracting Agency or upon land leased by the Contractor—shall be disposed of in accordance with Section 1-09.10. All costs resulting from the production of the excess aggregates shall be included in the cost of production of the aggregates actually incorporated in the Work.

If the Contractor elects to stockpile aggregates from a source not provided by the Contracting Agency prior to use in the immediate Work, it will be subject to the approval of the Engineer and provided that the aggregates comply with the quality and grading requirements of these Specifications. All costs in connection with the acquisition of the stockpile site, the preparation of the site, construction of the stockpiles, and the removal of the aggregates from the stockpiles shall be included in the Contract prices of the various Bid items of Work involved.

3-02.2(5) Preparation of Site

Before placing aggregates upon the stockpile site, the site shall be cleared of vegetation, trees, stumps, brush, rocks, or other debris and the ground leveled to a smooth, firm, uniform surface. The debris resulting from clearing and preparing the site shall be disposed of in a manner satisfactory to the Engineer.

3-02.2(6) Construction of Stockpiles

Stockpiles shall be constructed upon the prepared sites in accordance with stakes set by the Engineer. The piles when completed shall be neat and regular in shape. The stockpile height shall be limited to a maximum of 24 feet.

Stockpiles in excess of 200 cubic yards shall be built up in layers not more than 4 feet in depth. Stockpile layers shall be constructed by trucks, clamshells, or other methods approved by the Engineer. Pushing aggregates into piles with a bulldozer will not be permitted. Each layer shall be completed over the entire area of the pile before depositing aggregates in the succeeding layer. The aggregate shall not be dumped so that any part of it runs down and over the lower layers in the stockpile. The method of dropping from a bucket or spout in one location to form a cone shaped pile will not be permitted. Any method of placing aggregates in stockpiles, which in the opinion of the Engineer, breaks, degrades, or otherwise damages the aggregate, will not be permitted. Plank runways will be required, when deemed necessary by the Engineer, for operating trucks on stockpiles to avoid tracking dirt or other foreign matter onto the stockpiled materials. Stockpiles of less than 200 cubic yards shall be piled in a manner to prevent segregation of the various sizes of material.

No equipment other than pneumatic tired equipment shall be used in constructing the stockpiles of processed or manufactured aggregates.

Stockpiles of different types or sizes of aggregate shall be spaced far enough apart, or separated by suitable walls or partitions, to prevent the mixing of the aggregates. Aggregate shall not be deposited where traffic, vehicles, or Contractor's equipment will either run over or through the piles, or in any way cause foreign matter to become mixed with the aggregates.

3-02.2(7) Removing Aggregates From Stockpiles

Aggregates shall be removed from stockpile in a manner to avoid separation of sizes or admixture of dirt or foreign material. The method and equipment used for loading will be approved by the Engineer.

No equipment other than pneumatic tired equipment shall be used on stockpiles of processed or manufactured aggregates in removing the materials from the stockpiles. When removing materials from the face of the stockpile, the equipment shall be operated in a manner to face-load from the floor to the top of the stockpile to obtain maximum uniformity of material.

The Contractor shall remove only the amount of materials from the stockpile required to satisfy the needs of the Contract. If a surplus remains in the stockpile, the Contractor shall leave the surplus material in neat, compact piles, free of foreign matter. The entire stockpile site shall be left in a neat and presentable condition.

3-02.3 Additional Requirements for Specific Aggregates

3-02.3(1) Washed Aggregates

Drainpipes under the stockpile shall be provided at the Contractor's expense when, in the opinion of the Engineer, such drains are necessary to properly drain the aggregates.

The roads and ground adjacent to the stockpile shall be kept free of dust. Washed aggregate that has become coated with foreign material prior to use shall be washed until free of all foreign material or it may be rejected.

Washed aggregate shall drain in hauling conveyances or stockpiles at least 12 hours before being weighed or measured for batching and for a longer time if so directed by the Engineer.

3-02.4 Measurement

Clearing and grubbing of the stockpile site will be measured in accordance with Section 2-01 when the Proposal includes such Bid items and such Work is required on a stockpile site provided by the Contracting Agency.

Specific materials or aggregates designated in the Proposal to be in stockpile will be measured by the ton unless the Proposal shows by the cubic yard. The cubic yard volume for pay quantity will be determined by cross-sectioning the completed stockpile or by computation of the volume between the original ground surface and the stockpile surface using digital terrain modeling survey techniques.

Specific materials or aggregates designated in the Proposal to be from stockpile will be measured by the ton or by the cubic yard, whichever is shown in the Proposal. If payment is to be made on the basis of cubic yards, measurement will be made of the volume in the hauling vehicle at the point of delivery on the Roadway.

3-02.5 Payment

All costs involved in preparing stockpile sites shall be included in the unit Contract prices for the various Bid items being stockpiled, excepting that clearing and grubbing will be paid in accordance with Section 2-01 when the Proposal includes such Bid items and such Work is required on a stockpile site provided by the Contracting Agency.

3-03 Site Reclamation

3-03.1 Description

This Work shall consist of reclaiming land used for borrowing material, mining for aggregates, sorting, or wasting materials as specified.

3-03.2 General Requirements

3-03.2(1) Contracting Agency-Provided Sites

All borrow, quarry, or pit sites of over 3 acres in size of disturbed land or resulting in pit walls more than 30 feet high and steeper than a one to one slope which are owned or furnished by the Contracting Agency shall be reclaimed as shown in the Plans and as designated by the Engineer.

Ultimate reclamation plans are not normally required for borrow, quarry, or pit sites not meeting the above criteria or for stockpile or waste sites. However, all such sites shall be reclaimed to the extent necessary to control erosion and provide a satisfactory appearance consistent with anticipated future use.

3-03.2(2) Contractor-Provided Sites

All borrow, quarry, and pit sites of over 3 acres in size of disturbed land or resulting in pit walls more than 30 feet high and steeper than a 1:1 slope which are owned or furnished by the Contractor shall be reclaimed in accordance with the conditions and requirements of an approved reclamation permit acquired from the Department of Natural Resources.

When the Contractor obtains a reclamation permit from the Department of Natural Resources, evidence of such approval shall be furnished to the Engineer prior to any Work within the site.

Ultimate reclamation plans are not required for borrow, quarry, or pit sites not meeting the above criteria or for stockpile or waste sites. However, all such sites shall be reclaimed to the extent necessary to control erosion and provide a satisfactory appearance consistent with anticipated future use.

Compliance with the State Environmental Policy Act (SEPA) is required for sites involving more than 100 cubic yards of excavation or landfill throughout the lifetime of the site unless the local agency in which the project is located establishes a greater amount. Sites involving more than 500 cubic yards of excavation or landfill throughout the lifetime of the site always require compliance with SEPA.

Under no circumstance will the Contractor be allowed to waste material within a wetland as defined in Section 2-03.3(7).

3-03.2(3) Out-of-State Sites

All out-of-State borrow, quarry or pit, stockpile, and waste sites which are furnished by the Contractor exclusively for use on this Contract shall be reclaimed in accordance with an approved reclamation plan that is in compliance with local area restrictions.

3-03.3 Reclamation Plans

3-03.3(1) Contracting Agency-Provided Sites

Reclamation plans for all borrow, quarry, or pit sites which are owned or furnished by the Contracting Agency will normally be furnished by the Contracting Agency and the requirements thereof included in the Contract documents. Should conditions require operations within a Contracting Agency-owned or Contracting Agency-furnished site not provided for in the Plans, the Contractor shall reclaim these sites in accordance with a reclamation plan furnished by the Engineer.

3-03.3(2) Contractor-Provided Sites

A plan will not be required except on specific request for those sources of material for which the Contractor has obtained a valid surface mining permit issued by the Department of Natural Resources and has paid all required fees.

3-03.4 Construction Requirements

3-03.4(1) Erosion Control

All sites owned or furnished by the Contracting Agency will specify the kind and amount of erosion control, if any, and include the requirements thereof in the Contract documents.

All sites owned or furnished by the Contractor shall, if specified on a reclamation plan approved by the Engineer, require erosion control in accordance with Section 8-01 or plant materials in accordance with Section 8-02.

3-03.4(2) Deviations From Approved Reclamation Plans

Reclamation of any site which deviates from the approved reclamation plan will not be permitted without first revising the approved reclamation plan and obtaining the approval of the Engineer.

3-03.5 Payment

3-03.5(1) Contracting Agency-Provided Sites

All costs in connection with reclaiming sites to the full extent required by the Contract shall be included in the costs of other items of Work involved in the project.

Payment will be made for any Work described in Sections 8-01 or 8-02 at applicable unit Contract prices.

3-03.5(2) Contractor-Provided Sites

All costs involved in complying with the requirements of a reclamation permit acquired from the Department of Natural Resources, complying with the requirements of a reclamation plan approved by the Engineer, or with reclaiming sites to the full extent required by the Contract shall be included in the costs of other items of Work involved in the project.

3-04 Acceptance of Aggregate

3-04.1 Description

This work shall consist of acceptance of aggregate as provided for under statistical or nonstatistical evaluation.

All aggregates shall meet the requirements in Section 9-03.

Acceptance of aggregate by statistical evaluation is administered under Section 1-06.2. Statistical evaluation will be used for an aggregate material when the proposed plan quantity of the aggregate material exceeds two sublots as shown in Table 1.

Nonstatistical evaluation will be used for the acceptance of aggregate materials when the proposed plan quantity is equal to or less than two sublots as shown in Table 1.

3-04.2 Materials

Material shall meet the requirements of the following section:

Aggregates	9-03

3-04.3 Construction Requirements

3-04.3(1) General

For the purpose of statistical and nonstatistical acceptance sampling and testing, all test results obtained for a material type will be evaluated collectively. Sublot sampling and testing will be performed on a random basis at the frequency of one sample per sublot. Based on plan quantities, the sublot size will be determined to the nearest 100 tons (50 cy). The maximum sublot size will be as defined in Table 1.

3-04.3(2) Point of Acceptance

The point of acceptance shall be as designated by the Engineer. Multiple sources shall not be placed within the same limits of each separate spreading operation or in such a way that the intermingling of different sources occurs. Individual compaction lifts may be of a different source.

3-04.3(3) Sampling

The sampling of aggregate materials shall be performed on a random basis using WSDOT T 716, Method of Random Sampling. Samples for acceptance testing shall be obtained by the Engineer, or their designated representative. If ordered by the Engineer, the Contractor shall obtain the sample in the presence of the Engineer or their representative. The aggregate material shall be sampled in accordance with FOP for AASHTO R 90 and Section 1-05.6. The sample size shall be equal to the minimum requirements of FOP for AASHTO R 90.

3-04.3(4) Testing Results

The results of all acceptance testing performed in the field and the Composite Pay Factor (CPF) of the lot after three sublots have been tested will be available to the Contractor through WSDOT's website.

3-04.3(5) Nonstatistical Evaluation

Each lot of aggregate materials produced under nonstatistical evaluation and having all constituents falling within the specification limits shall be accepted with no further evaluation. When one or more constituents fall outside the specification limits, the material will be statistically evaluated. A minimum of three sublots will be sampled and tested, when less than three sublots exist additional samples shall be tested to provide a minimum of three sets of results for evaluation. The test results of the sublots shall be evaluated in accordance with Section 1-06.2 using the price adjustment factors from Table 2 to determine the appropriate CPF. The maximum CPF shall be 1.00. If the CPF is below 1.00 but is equal to or above 0.75, a price adjustment will be calculated in accordance with Section 3-04.3(8).

When the aggregate does not have established price adjustment factors, use the appropriate price adjustment factors from "Other Materials" as listed in Table 2.

3-04.3(6) Statistical Evaluation

For statistical evaluation a lot is defined as 15 sublots, the final lot will be increased to a maximum of 25 sublots. All test results obtained for a material type will be evaluated in accordance with Section 1-06.2. Each lot of aggregate materials produced under statistical evaluation will be determined to be acceptable if the Composite Pay Factor (CPF) when calculated in accordance with Section 1-06.2(2) using the price adjustment factors from Table 2 is 1.00 or greater. The Contractor shall be paid the unit bid price for aggregate materials with a CPF of 1.00 or greater. If the CPF is below 1.00 but is equal to or above 0.75, calculate the price adjustment in accordance with Section 3-04.3(8).

When the aggregate does not have established price adjustment factors, use the appropriate price adjustment factors from "Other Materials" as listed in Table 2.

3-04.3(7) Rejected Work

3-04.3(7)A General

Work that is defective or does not conform to Contract requirements shall be rejected.

3-04.3(7)B Rejection by Contractor

The Contractor may, prior to sampling, elect to remove any defective material and replace it with new material. Any such new material will be sampled, tested, and evaluated for acceptance.

3-04.3(7)C Rejection Without Testing

The Engineer may, without sampling, reject any load or stockpile that appears defective. Material rejected before placement shall not be incorporated into the work. Any rejected work shall be removed.

No payment will be made for the rejected materials unless the Contractor requests that the rejected material be tested. If the Contractor elects to have the rejected material tested, a minimum of three representative samples shall be obtained and tested. Acceptance of rejected material will be based on conformance with the statistical acceptance Specification. If the CPF for the rejected material is less than 0.75, no payment will be made for the rejected material; in addition, the cost of sampling and testing shall be borne by the Contractor. If the CPF is greater than or equal to 0.75, the cost of sampling and testing will be borne by the Contracting Agency. If the material is rejected before placement and the CPF is greater than or equal to 0.75, compensation for the rejected material will be at a CPF of 0.75. If rejection occurs after placement and the CPF is greater than 0.75, compensation for the rejected mix will be at the calculated CPF with an addition of 25 percent of the unit Contract price added for the cost of removal and disposal.

3-04.3(7)D Lots and Sublots

3-04.3(7)D1 A Partial Sublot

In addition to the preceding random acceptance sampling and testing, the Engineer may also isolate from a normal sublot any material that is suspected of being defective. Such isolated material will not include an original sample location. A minimum of three random samples of the suspect material will be obtained and tested. The material will then be evaluated as an independent lot in accordance with Section 1-06.2(2).

3-04.3(7)D2 An Entire Sublot

An entire sublot that is suspect of being defective may be rejected. When a sublot is rejected a minimum of two additional samples from this sublot will be obtained. These additional samples and the original sublot will be evaluated as an independent lot in accordance with Section 1-06.2(2).

3-04.3(7)D3 A Lot in Progress

The Contractor shall shut down operations and shall not resume placement of the aggregate until such time as the Engineer is satisfied that material conforming to the specification can be produced:

a. When the Composite Pay Factor (CPF), for a lot in progress, is less than 1.00 and the contractor is taking no corrective action; or

b. When the Pay Factor (PF) for any component of the lot in progress, is less than 0.95 and the contractor is taking no corrective action; or

c. When either the PF_i for any constituent or the CPF for a lot in progress is less than 0.75.

3-04.3(7)D4 An Entire Lot

An entire lot with a CPF of less than 0.75 will be rejected.

3-04.3(8) Price Adjustments for Quality of Aggregate

All aggregate material will be subject to price adjustments. The maximum attainable Composite Pay Factor (CPF) shall be 1.00. The aggregate Compliance Price Adjustment for acceptance of the aggregate will be calculated as follows:

> Aggregate Compliance Price Adjustment = (Composite Pay Factor – 1.00) (quantity of material) (unit bid price or Contingent Unit Price as shown in Table 1, whichever is higher)

For aggregate materials lacking a separate unit bid price, the unit bid prices shall be taken as the value listed in Table 1 for “Contingent Unit Price”.

If a component is not measured in accordance with these specifications, its individual pay factor will be considered 1.00 in calculating the composite pay factor.

3-04.4 Vacant

3-04.5 Payment

"Aggregate Compliance Price Adjustment", by calculation.

"Aggregate Compliance Price Adjustment" shall be calculated and paid for as described under Section 3-04.3(8) Price Adjustments for Quality of Aggregate.

Table 1 Aggregate Acceptance Parameters

Standard Specifications	Item	Maximum Sublot Size (Tons)	Maximum Sublot Size (CY)	Contingent Unit Price Per Ton	Contingent Unit Price Per CY
9-03.1	Concrete Aggregate (except pavement)	2000	1000[1]	$15.00[2]	$30.00[2]
9-03.1	Concrete Aggregate (pavement)	4000	2000[1]	$15.00[2]	$30.00[2]
9-03.4(2)	Crushed Screening[3]	1000	500	$20.00	$40.00
9-03.8(2)	HMA Aggregate	2000		$15.00	
9-03.9(1)	Ballast	2000	1000	$20.00	$40.00
9-03.9(2)	Permeable Ballast	2000	1000	$25.00	$50.00
9-03.9(3)	Crushed Surfacing	2000	1000	$20.00	$40.00
9-03.9(4)	Maintenance Rock	2000	1000	$20.00	$40.00
9-03.10	Gravel Base	4000	2000	$15.00	$30.00
9-03.11(1)	Streambed Sediment	500	250	$30.00	$60.00
9-03.12(1)A	Gravel Backfill for Foundations Class A	1000	500	$30.00	$60.00
9-03.12(1)B	Gravel Backfill for Foundations Class B	1000	500	$30.00	$60.00
9-03.12(2)	Gravel Backfill for Walls	1000	500	$30.00	$60.00
9-03.12(3)	Gravel Backfill for Pipe Zone Bedding	1000	500	$30.00	$60.00
9-03.12(4)	Gravel Backfill for Drains	500	250	$30.00	$60.00
9-03.12(5)	Gravel Backfill for Drywells	500	250	$30.00	$60.00
9-03.13	Backfill for Sand Drains	2000	1000	$30.00	$60.00
9-03.13(1)	Sand Drainage Blanket	4000	2000	$30.00	$60.00
9-03.14(1)	Gravel Borrow	4000	2000	$15.00	$30.00
9-03.14(2)	Select Borrow	4000	2000	$15.00	$30.00
9-03.14(4)	Gravel Borrow for Structural Earth Walls	4000	2000	$30.00	$60.00
9-03.17	Foundation Material, Class A and B	1000	500	$25.00	$50.00
9-03.18	Foundation Material Class C	1000	500	$25.00	$50.00
9-03.19	Bank Run Gravel for Trench Backfill	4000	2000	$30.00	$60.00

[1]Based on 1000 CY of Concrete.

[2] Price adjustment only applies to the actual quantity of aggregate used in the concrete.

[3]Contingent unit price per S.Y. is $0.30.

Table 2 Price Adjustment Factors

Standard Specifications	Item	Maximum Size Sieve: 100% Pass	Nominal Maximum Size Sieve: 100% Pass[1]	Other Specifications Sieves #4 and Larger	Specification Sieves: #8 to #100	#200 Sieve	Sand Equivalent	Fracture[2]	Other
9-03.1	Concrete Aggregate (all concrete aggregate -including pavement)	2	2	2	10	20			
9-03.4(2)	Crushed Screening	2	2	5	5	20		15	
9-03.8(2)	HMA Aggregate						15	15	Uncompacted Void Content 15
9-03.9(1)	Ballast	2	2	5	5	10	15		Dust Ratio 15
9-03.9(2)	Permeable Ballast	2	2	5	5			15	
9-03.9(3)	Crushed Surfacing	2	2	5	5	10	15	15	
9-03.9(4)	Maintenance Rock	2	2	5	5	10	15	15	
9-03.10	Gravel Base		2	5		6	10		Dust Ratio 10
9-03.11(1)	Streambed Sediment	2	2	5	5	10			
9-03.12(1)A	Gravel Backfill for Foundations Class A[3]								
9-03.12(1)B	Gravel Backfill for Foundations Class B		2	5		6	10		Dust Ratio 10
9-03.12(2)	Gravel Backfill for Walls	2	2	5		6	10		Dust Ratio 10
9-03.12(3)	Gravel Backfill for Pipe Zone Bedding	2	2	5	5	6	10		
9-03.12(4)	Gravel Backfill for Drains	2	2	5		6			
9-03.12(5)	Gravel Backfill for Drywells	2	2	5		6			
9-03.13	Backfill for Sand Drains		2	5	3	10			
9-03.13(1)	Sand Drainage Blanket		2	5	3	10			
9-03.14(1)	Gravel Borrow	2	2	5	5	5	10		
9-03.14(2)	Select Borrow	2	2	5	5	6	10		
9-03.14(4)	Gravel Borrow for Structural Earth Walls	2	2	5	5	5	10		Other[4]
9-03.17	Foundation Material, Class A & B		2	3					
9-03.18	Foundation Material Class C	2		3					
9-03.19	Bank Run Gravel for Trench Backfill	2	2	5		6	10		Dust Ratio 10
	Other Materials	2	2	5	5	10	15	15	Dust Ratio 10

[1]For Aggregate, the nominal maximum size sieve is the largest standard sieve opening listed in the applicable specification upon which more than 1-percent of the material by weight is permitted to be retained. For concrete aggregate, the nominal maximum size sieve is the smallest standard sieve opening through which the entire amount of aggregate is permitted to pass.

[2]Price adjustment factor applies where criteria is contained in the material specification.

[3]Use the price adjustment factors for the material that is actually used.

[4]Resistivity 10, pH 10, Chlorides 5, and Sulfates 5.

4-01 Vacant

4-02 Gravel Base

4-02.1 Description

This Work shall consist of constructing one or more layers of gravel base upon a prepared Subgrade in accordance with these Specifications and in conformity with the lines, grades, depth, and typical cross-section shown in the Plans or as established by the Engineer.

4-02.2 Materials

Materials shall meet the requirements of the following section:

Gravel Base	9-03.10

4-02.3 Construction Requirements

Gravel base shall be uniformly spread upon the prepared Subgrade to the depth, width, and cross-section shown in the Plans. Construction methods used shall meet the applicable requirements of Sections 4-04.3.

4-02.4 Measurement

Gravel base will be measured in the same manner prescribed for the measurement of crushed surfacing materials as set forth in Section 4-04.4.

4-02.5 Payment

Payment will be made for the following Bid item when shown in the Proposal:

"Gravel Base", per ton, or per cubic yard.

4-03 Vacant

4-04 Ballast and Crushed Surfacing

4-04.1 Description

This Work consists of constructing one or more courses of crushed stone upon a prepared Subgrade in accordance with these Specifications in conformity with the lines, grades, depth, and typical cross-sections shown in the Plans or as established by the Engineer.

Surfacing materials and ballast may also be specified to be placed in stockpiles for future use.

4-04.2 Materials

Materials shall meet the requirements of the following sections:

Ballast	9-03.9(1)
Permeable Ballast	9-03.9(2)
Crushed Surfacing	9-03.9(3)
Maintenance Rock	9-03.9(4)

4-04.3 Construction Requirements

4-04.3(1) Equipment

All equipment necessary for the satisfactory performance of this construction shall be on the project and approved by the Engineer prior to beginning work. If central mix plant methods are used, the central mixing plant shall comply with the following requirements:

The cold aggregate feeder shall be mechanically operated and adjustable to the extent necessary to provide a uniform and continuous flow of materials. These materials shall be deposited in an approved mixer with a sufficient amount of water being added to obtain the required density when spread and compacted. The water shall be weighed or metered, and dispensed through a device providing uniform dispersion across the mixer.

The mixing plant shall be provided with weighing or calibrating devices, feeders, provisions for sampling, and other devices and equipment so designed, coordinated, and operated to produce a uniform mixture, and to permit the sampling of the materials before and after mixing. The mixer shall be kept in good condition, and mixing blades or paddles shall be of proper size, adjustment, and clearance to provide positive and uniform mixing of the mixture at all times.

The capacity of the plant and equipment furnished for the Work shall be adequate at all times to provide for efficient and continuous operations insofar as practical.

4-04.3(2) Subgrade

The Subgrade shall be prepared as specified in Section 2-06 and shall be approved by the Engineer before placing ballast or surfacing materials.

4-04.3(3) Mixing

Unless otherwise specified, the Contractor may use either, or both, of the following described methods:

1. **Central Plant Mix Method** – The surfacing material and water shall be mixed in an approved mixing plant as described in Section 4-04.3(1). The completed mixture shall be a thoroughly mixed combination of proportioned materials and water, uniform in distribution of particle sizes and moisture content. A mixture containing water in excess of the proportion established by the Engineer will not be accepted.
2. **Road Mix Method –** After material for each layer of surfacing has been placed, the material shall be mixed until uniform throughout by motor graders or other equipment approved by the Engineer. Water to facilitate mixing and compacting shall be added in amounts approved by the Engineer.

4-04.3(4) Placing and Spreading

1. **Central Plant Mix Method** – After mixing, material for each layer of surfacing shall be transported to the Roadway in approved vehicles. Vehicles for hauling the mixture shall be capable of depositing the mixture within the receiving hopper of the spreading equipment, or in windrows of uniform size in front of the spreading equipment, with a minimum of segregation of the mix.

   A motor grader may be used as the spreading machine or the spreading machine shall be capable of receiving the material by direct deposit in its hopper from the hauling vehicle or from a uniform windrow, and be capable of spreading and screeding the material to a depth and surface that when compacted will be true to line, grade, depth of course, and cross-section without further shaping.
2. **Road Mix Method –** Each layer of surfacing material shall be spread by equipment that is approved by the Engineer. Equipment that causes segregation of the surfacing material during the spreading operation will not be allowed. Similar types of spreading equipment shall be used throughout the limits of each separate spreading operation. Spreading on small areas of less than 2,000 square yards or on areas irregular in shape, may be accomplished by other means as approved by the Engineer.

The following nominal depth of compacted material shall not be exceeded in any one course without the approval of the Engineer:

Ballast	0.50 foot
Gravel Base	0.75 foot
Crushed Surfacing	0.35 foot

4-04.3(5) Shaping and Compaction

Immediately following spreading and final shaping, each layer of surfacing shall be compacted to at least 95 percent of maximum density determined by the requirements of Section 2-03.3(14)D before the next succeeding layer of surfacing or pavement is placed. The determination of field in-place density shall be made by the Nuclear gauge. When the thickness of surfacing is less than 0.15 foot, density testing will not be required and the Engineer will determine the number of coverages required for the particular compaction equipment available. Vibratory compactors and rollers shall obtain the specified density for each layer. A mist spray of water shall be applied as needed to replace moisture lost by evaporation. The completed layer shall have a smooth, tight, uniform surface true to the line, grade, and cross-section shown in the Plans, or as staked.

When using 100% Recycled Concrete Aggregate, the Contractor may submit a written request to use a test point evaluation for compaction acceptance testing in lieu of compacting to 95% of the standard density as determined by the requirements of Section 2-03.3(14)D. The test point evaluation shall be performed in accordance with SOP 738.

4-04.3(6) Keystone

When necessary, as determined by the Engineer, crushed surfacing top course shall be used for keystone to key the top surface of ballast, gravel base, crushed surfacing base course, or any other surfacing course that requires keying. The keystone shall be spread evenly on top of the surfacing course by means of approved spreading equipment. The surface shall be watered and, if necessary, bladed lightly until the keystone is worked into the interstices of the surfacing course without excessive displacement and shall be compacted. The operations of adding keystone, wetting, blading, and compacting shall be continued until the course has become thoroughly keyed and compacted.

When keystone is required, that is subject to public traffic, it shall be placed before terminating each day's operation.

Keystone placed for the convenience of the Contractor, with approval of the Engineer, for the purpose of creating a more dense surface on which to pave will be allowed within the top 0.20 foot of crushed surfacing base course, gravel base, or ballast. Keystone placed for this purpose will be paid for at the lower unit Contract price for either the base material being keyed or crushed surfacing top course.

4-04.3(7) Miscellaneous Requirements

The surface of each layer of surfacing material shall be maintained true to line, grade, and cross-section by grading, watering, and rolling until placing the next succeeding course. The first course of surfacing material shall be placed on all available Subgrade before placing the succeeding course unless otherwise authorized by the Engineer. Unless otherwise approved, there shall be a distance of not less than one station between the construction of any two courses of surfacing or ballast.

Should irregularities develop in any surface during or after compaction, they shall be remedied by loosening the surface and correcting the defects after which the entire area including the surrounding surface shall be thoroughly recompacted. Any additional materials necessary to make the repairs shall be furnished by the Contractor at the unit Contract price.

4-04.3(8) Weather Limitations

When, in the opinion of the Engineer, the weather is such that satisfactory results cannot be obtained, the Contractor shall suspend operations until the weather is favorable. No surfacing materials shall be placed in snow or on a soft, muddy, or frozen Subgrade.

4-04.3(9) Hauling

Hauling equipment shall be routed over the Roadway in a manner to be most effective in the compacting of the surfacing. Hauling over any of the surfacing in the process of construction will not be permitted when, in the opinion of the Engineer, the effect will be detrimental. All loads shall be of uniform capacity unless deviation is expressly authorized by the Engineer.

4-04.3(10) Hours of Work

The Contractor shall arrange surfacing operations so that the placing of materials will be accomplished during daylight hours. However, when necessary to complete the project within the time specified, or to avoid peak periods of public traffic, Work may be undertaken during the hours of darkness, provided the Contractor furnishes and operates adequate lighting. Inability to demonstrate reliable and satisfactory results will be reason to order termination of night operations, and the Contractor shall procure additional equipment and personnel necessary to satisfactorily complete the Work as specified while operating during daylight hours only.

4-04.3(11) Permeable Ballast

Permeable ballast shall not be placed until the abutting pavement has been completed unless designated by the Engineer. Permeable ballast shall be placed through a spreader box in one lift. Processing of the permeable ballast course on the Roadway will not be permitted. Compaction shall be accomplished by making a minimum of three passes over the aggregate with a vibratory compactor of a type acceptable to the Engineer. The density requirements of Section 4-04.3(5) shall not apply.

4-04.4 Measurement

Crushed surfacing top course, base course, ballast, and gravel base, when mixed at a central plant, will be measured by the ton. The weight of water added at the plant will be deducted on a daily basis from the total tonnage of aggregates, including water, placed that day which were processed through the central plant and placed on the Roadway. The resultant tonnage of surfacing materials will be paid for at the unit Contract price. The weight of deducted water will be converted to gallons and will be paid for at the unit Contract price for water.

Crushed surfacing top course, base course, ballast, and gravel base, when mixed by the road mix method, will be measured by the ton or by the cubic yard. If measured by the cubic yard, measurement will be made in the hauling conveyance at the point of delivery on the Roadway.

Permeable ballast will be measured by the ton or by the cubic yard.

Crushed surfacing materials for placement in stockpile will be measured by the ton or cubic yard. If measured by the cubic yard, the volume will be determined by cross-sectioning the stockpile.

Maintenance rock will be measured in the same manner prescribed for crushed surfacing materials.

Water used in placing and compacting surfacing materials on the Roadway will be measured in accordance with Section 2-07.

4-04.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Crushed Surfacing Top Course (or Base Course)", per ton, or per cubic yard.

"Crushed Surfacing Top Course (or Base Course) in Stockpile", per ton, or per cubic yard.

"Crushed Surfacing Top Course (or Base Course) from Stockpile", per ton, or per cubic yard.

"Ballast", per ton, or per cubic yard.

"Ballast in Stockpile", per ton, or per cubic yard.

"Ballast from Stockpile", per ton, or per cubic yard.

"Permeable Ballast", per ton, or per cubic yard.

"Permeable Ballast in Stockpile", per ton or per cubic yard.

"Permeable Ballast from Stockpile", per ton or per cubic yard.

"Maintenance Rock ½ In. Minus in Stockpile", per ton, or per cubic yard.

5-01 Cement Concrete Pavement Rehabilitation

5-01.1 Description

This Work consists of rehabilitating or replacing section(s) of cement concrete pavement in accordance with these Specifications and in conformity with the lines, grades, thicknesses, and typical cross-sections shown in the Plans or established by the Engineer.

5-01.2 Materials

Materials shall meet the following requirements of the following sections:

Cement	9-01
Fine Aggregate	9-03
Coarse Aggregate	9-03
Combined Aggregate	9-03
Joint Filler	9-04.1
Joint Sealants	9-04.2
Closed Cell Foam Backer Rod	9-04.2(3)A
Dowel Bars	9-07.5
Tie Bars	9-07.6
Concrete Patching Material, Grout, and Mortar	9-20.1
Curing Materials and Admixtures	9-23
Water	9-25
Epoxy Resins (bonding agents)	9-26

Parting Compound shall be a curing compound, grease or other substance approved by the Engineer.

Dowel Bar Retrofit

Dowel bar expansion caps shall be tight fitting and made of non-metallic material, which will allow for ¼ inch of movement at each end of the bar.

Chairs for supporting the dowel bar shall be epoxy coated according to Section 9-07.3 or made from non-metallic material.

The foam insert shall be closed cell foam faced with poster board material or plastic faced material on each side commonly referred to as foam core board by office suppliers. The foam insert shall be capable of remaining in a vertical position and tight to all edges during the placement of the concrete patching material. Caulking filler used for sealing the transverse joint at the bottom and sides of the slot shall be a silicone caulk.

5-01.3 Construction Requirements

5-01.3(1) Vacant

5-01.3(1)A Mix Designs

The Contractor shall use either concrete patching materials or cement concrete for the rehabilitation of cement concrete pavement. Concrete patching materials shall be used for spall repair and dowel bar retrofitting and cement concrete shall be used for concrete panel replacement.

5-01.3(1)A1 Concrete Patching Materials

1. **Materials –** The prepackaged concrete patching material and the aggregate extender shall conform to Section 9-20.1.
2. **Submittals and Mix Approval –** The Contractor shall use the Manufacturer's recommended proportions for the mix design to be submitted to the Engineer for the concrete patching material. The Contractor's submittal shall include the mix proportions of the prepackaged concrete patching material, water, aggregate extender, and the proposed sources for all aggregates. If not approved for use on the QPL, submit test data indicating compliance with Section 9-20.1.

5-01.3(1)A2 Cement Concrete for Panel Replacement

Cement concrete for panel replacement shall meet the requirements of Sections 5-05.3(1) and 5-05.3(2) and be air entrained with a design air content of 5.5 percent. Cement concrete for panel replacement may use rapid hardening hydraulic cement meeting the requirements of Section 9-01.2(2). Rapid hardening hydraulic cement will be considered a cementitious material for the purpose of calculating the water/cementitious materials ratio and the minimum cementitious materials requirement.

5-01.3(1)B Equipment for Panel Replacement

In addition to Sections 5-05.3(3)A, 5-05.3(3)B, 5-05.3(3)D, and 5-05.3(3)E the following shall apply:

1. Mobile volumetric mixers shall be calibrated in accordance with Section 6-09.3(1)H. The references to the latex admixture shall not apply.
2. The equipment for grinding cement concrete pavement shall use diamond embedded saw blades gang mounted on a self propelled machine that is specifically designed to smooth and texture concrete pavement. The equipment shall not damage the underlying surface, cause fracture, or spalling of any joints.

5-01.3(2) Material Acceptance

5-01.3(2)A Concrete Patching Material

Acceptance shall be based on field verification of the prepackaged patching material, and whether the amount of added water and aggregate extender complies with the mix design.

5-01.3(2)B Cement Concrete for Panel Replacement

The point of acceptance will be at the discharge of the placement system.

The concrete producer shall provide a certificate of compliance for each truckload of concrete in accordance with Section 6-02.3(5)B.

Acceptance testing for compliance of air content and 28-day compressive strength shall be conducted from samples obtained according to FOP for WAQTC TM 2. Air content shall be determined by conducting FOP for AASHTO T 152. Compressive Strength shall be determined by FOP for AASHTO T 22 and FOP for AASHTO T 23. The lower Specification limit for air content shall be 3 percent, and the upper Specification limit for air content shall be 7 percent. The lower Specification limit for compressive strength shall be 4,000 psi.

The Contractor shall provide cure boxes in accordance with Section 6-02.3(5)H, and protect concrete cylinders in cure boxes from excessive vibration and shock waves during the curing period in accordance with Section 6-02.3(6)D. Payment for cure boxes shall be in accordance with Section 6-02.5.

5-01.3(2)B1 Conformance to Mix Design

Acceptance of cement concrete pavement for panel replacement shall be in accordance with Section 5-01.3(2)B. The cement, coarse, and fine aggregate weights shall be within the tolerances of the mix design in accordance with Section 5-05.3(1).

5-01.3(2)B2 Rejection of Concrete

Rejection by the Contractor: The Contractor may, prior to sampling, elect to remove any defective material and replace it with new material at no expense to the Contracting Agency. The replacement material will be sampled, tested and evaluated for acceptance.

Rejection without Testing: The Engineer may reject any load that appears defective prior to placement. Material rejected before placement shall not be incorporated into the pavement. No payment will be made for the rejected materials unless the Contractor requests that the rejected material be tested. If the Contractor elects to have the rejected materials tested, a sample will be taken and both the air content and strength shall be tested by WSDOT.

Payment for rejected material will be based on the results of the one sample, which was taken and tested. If the rejected material fails either test, no payment will be made for the rejected material and in addition, the cost of sampling and testing, at the rate of $250.00 per sample shall be borne by the Contractor. If the rejected material passes both tests the mix will be compensated for at actual invoice cost and the cost of the sampling and testing will borne by the Contracting Agency.

5-01.3(3) Vacant

5-01.3(4) Replace Cement Concrete Panel

5-01.3(4)A General

Curing, cold weather Work, concrete pavement construction in adjacent lanes, and protection of pavement shall meet the requirements of Section 5-05.3(13) through Section 5-05.3(15). The Contractor, at no cost to the Contracting Agency, shall repair any damage to existing pavement caused by the Contractor's operations.

5-01.3(4)B Sawing and Dimensional Requirements

Concrete slabs to be replaced as shown in the Plans or staked by the Engineer shall be at least 6.0 feet long and full width of an existing pavement panel. The portion of the panel to remain in place shall have a minimum dimension of 6 feet in length and full panel width; otherwise the entire panel shall be removed and replaced. There shall be no new joints closer than 3.0 feet to an existing transverse joint or crack. A vertical full depth saw cut is required along all longitudinal joints and at transverse locations and, unless the Engineer allows otherwise, an additional vertical full depth relief saw cut located 12 to 18 inches from and parallel to the initial longitudinal and transverse saw cut locations is also required. Removal of existing cement concrete pavement shall not cause damage to adjacent slabs that are to remain in place. In areas that will be ground, slab replacements shall be performed prior to pavement grinding.

Side forms shall meet the requirements of Section 5-05.3(7)B whenever a sawed full depth vertical face cannot be maintained.

5-01.3(4)C Dowel Bars and Tie Bars

For the half of a dowel bar or tie bar placed in fresh concrete, comply with the requirements of Section 5-05.

For the half of a dowel bar or tie bar placed in hardened concrete, comply with the Standard Plans and the following.

After drilling, secure dowel bars and tie bars into the existing pavement with either an epoxy bonding agent Type I or IV as specified in Section 9-26.1, or a grout Type 2 for non-shrink applications as specified in Section 9-20.3.

Dowel bars shall be placed at the mid depth of the concrete slab, centered over the transverse joint, and parallel to the centerline and to the Roadway surface, within the tolerances within the table below. Dowel bars may be adjusted to avoid contact with existing dowel bars in the transverse joint at approach slabs or existing panels provided the adjusted dowel bars meet the tolerances below.

Tie bars shall be placed at the mid depth of the concrete slab, centered over the joint, perpendicular to centerline, and parallel to the Roadway surface, within the tolerances in the table below. The horizontal position of tie bars may be adjusted to avoid contact with existing tie bars in the longitudinal joint where panel replacement takes place, provided the adjusted tie bars meet the tolerances below.

Placement Tolerances		
	Dowel Bars	**Tie Bars**
Vertical: Center of Bar to Center of Slab Depth	± 1.00 inch max	± 1.00 inch max
Dowel Bar Centered Over the Transverse Joint	± 1.00 inch max	N/A
Tie Bar Centered Over the Longitudinal Joint	N/A	± 1.00 inch max
Parallel to Centerline Over the Length of the Dowel Bar	± 0.50 inch max	N/A
Perpendicular to Longitudinal Joint Over the Length of the Tie Bar	N/A	± 1.00 inch max
Parallel to Roadway Surface Over the Length of the Bar	± 0.50 inch max	± 1.00 inch max

Dowel bars and tie bars shall be placed according to the Standard Plan when multiple panels are placed. Panels shall be cast separately from the bridge approach slab.

Dowel bars to be drilled into existing concrete or at a new transverse contraction joint shall have a parting compound, such as curing compound, grease, or other Engineer accepted equal, applied to them prior to placement.

Clean the drilled holes in accordance with the epoxy or grout manufacturer's instructions. Holes shall be clean and dry at the time of placing the epoxy, or grout and tie bars. Completely fill the void between the tie bar and the outer limits of the drilled hole with epoxy or grout. Use retention rings to prevent leakage of the epoxy or grout and support the tie bar to prevent movement until the epoxy or grout has cured the minimum time recommended by the manufacturer.

5-01.3(4)D Foundation Preparation

The Contractor shall smooth the surfacing below the removed panel and compact it to the satisfaction of the Engineer. Crushed surfacing base course, or hot mix asphalt may be needed to bring the surfacing to grade prior to placing the new concrete.

If the material under the removed panel is uncompactable and the Engineer requires it, the Contractor shall excavate the Subgrade 2 feet, place a soil stabilization construction geotextile meeting the requirements of Section 9-33, and backfill with crushed surfacing base course. This Work may include:

1. Furnishing and hauling crushed surfacing base course to the project site.
2. Excavating uncompactable material.

3. Furnishing and placing a soil stabilization construction geotextile.
4. Backfilling and compacting crushed surfacing base course.
5. Removing, hauling and restocking any unused crushed surfacing base course.

5-01.3(4)E Concrete Finishing

Grade control shall be the responsibility of the Contractor.

All panels shall be struck off level with the adjacent panels and floated to a smooth surface.

Final finish texturing shall meet the requirements of Section 5-05.3(11).

In areas where the Plans do not require grinding, the surface smoothness will be measured with a 10-foot straightedge by the Engineer in accordance with Section 5-05.3(12). If the replacement panel is located in an area that will be ground as part of concrete pavement grinding in accordance with Section 5-01.3(9), the surface smoothness shall be measured, by the Contractor, in conjunction with the smoothness measurement done in accordance with Section 5-01.3(10).

5-01.3(4)F Joints

All transverse and longitudinal joints shall be sawed and sealed in accordance with Section 5-05.3(8). The Contractor may use a hand pushed single blade saw for sawing joints.

5-01.3(4)G Cracked Panels

Replacement panels that crack shall be repaired as specified in Section 5-05.3(22) at no cost to the Contracting Agency. When repairing replacement panels that have cracked, epoxy-coated dowel bars meeting the requirements of Section 9-07.5(1) may be substituted for the corrosion resistant dowel bars specified.

5-01.3(4)H Opening to Traffic

Opening to traffic shall meet the requirements of Section 5-05.3(17).

5-01.3(5) Partial Depth Spall Repair

Removal of the existing pavement shall not damage any pavement to be left in place. Any existing pavement that is to remain that has been damaged shall be repaired at the Contractor's expense. If jackhammers are used for removing pavement, they shall not weigh more than 30 pounds, and chipping hammers shall not weigh more than 15 pounds. All power driven hand tools used for the removal of pavement shall be operated at angles less than 45 degrees as measured from the surface of the pavement to the tool. The patch limits shall extend beyond the spalled area a minimum of 3 inches. Repair areas shall be kept square, rectangular or circular. Repair areas that are within 12 inches of another repair area shall be combined.

A vertical cut shall be made to a minimum depth of 2 inches around the area using a saw or core drill to be patched as marked by the Engineer. The Contractor shall remove material within the perimeter of the saw cut to a depth of 2 inches, or to sound concrete as determined by the Engineer.

The surface patch area shall be sand blasted and all loose material removed. All sandblasting residue shall be removed.

Spall repair shall not be done in areas where dowel bars are encountered.

When a partial depth repair is placed directly against an adjacent longitudinal joint, a bond-breaking material such as polyethylene film, roofing paper, or other material as approved by the Engineer shall be placed between the existing concrete and the area to be patched.

Patches that abut working transverse joints or cracks require placement of a compressible insert. The new joint or crack shall be formed to the same width as the existing joint or crack. The compressible joint material shall be placed into the existing joint 1 inch below the depth of repair. The compressible insert shall extend at least 3 inches beyond each end of the patch boundaries.

Patches that abut the lane/Shoulder joint require placement of a formed edge, along the slab edge, even with the surface.

The patching material shall be mixed, placed, consolidated, finished, and cured according to manufacturer's recommendations. Slab/patch interfaces that will not receive pavement grinding shall be sealed (painted) with a 1:1 cement-water grout along the patch perimeter.

The Contractor shall reseal all joints in accordance with Section 5-03.3(3)C.

Opening to traffic shall meet the requirements of Section 5-05.3(17).

5-01.3(6) Dowel Bar Retrofit

Dowel bars shall be installed in the existing concrete pavement joints and transverse cracks where shown in the Plans or as marked by the Engineer.

Saw cut slots will be required in the pavement to place the center of the dowel at mid-depth in the concrete slab. The completed slot shall provide a level, secure surface for the feet of the dowel bar chairs. Slots that intersect longitudinal or random cracks shall not be retrofitted. When gang saws are used, slots that are not used shall be cleaned and sealed with either Type I or IV epoxy resin as specified in Section 9-26. The transverse joint between cement concrete pavement and a Bridge approach slab shall not be retrofitted.

Saw cut slots shall be prepared such that dowel bars can be placed at the mid depth of the concrete slab, centered over the transverse joint, and parallel to the centerline and to the Roadway surface.

Placement Tolerances for Dowel Bars

1. ± 1 inch of the middle of the concrete slab depth.
2. ± 1 inch of being centered over the transverse joint.
3. ± ½ inch from parallel to the centerline.
4. ± ½ inch from parallel to the Roadway surface.

If jackhammers are used to break loose the concrete they shall weigh less than 30 pounds.

All slot surfaces shall be cleaned to bare concrete by sand blasting. The cleaning shall remove all slurry, parting compound, and other foreign materials prior to installation of the dowel. Any damage to the concrete shall be repaired by the Contractor at no cost to the Contracting Agency. Traffic shall not be allowed on slots where concrete has been removed.

Prior to placement, the dowel bars shall be lightly coated with a parting compound and placed on a chair that will provide a minimum of ½-inch clearance between the bottom of the dowel and the bottom of the slot.

The chair design shall hold the dowel bar tightly in place during placement of the concrete patching material. If the transverse joint or crack is open ¼ inch or more, the Contractor shall caulk the transverse joint or crack at the bottom and sides of the slot as shown in the Plans immediately prior to placement of the dowel bar and concrete patching material. The caulking filler shall not be placed any farther than ½ inch outside either side of the joint or crack. The transverse joint or crack shall be caulked sufficiently to satisfy the above requirements and to prevent any of the patching material from entering the joint/crack at the bottom or sides of the slot.

A ⅜-inch-thick foam insert shall be placed at the middle of the dowel to maintain the transverse joint. The foam insert shall fit tightly around the dowel and to the bottom and edges of the slot and extend to the top of the existing pavement surface. The foam insert shall be capable of remaining in a vertical position and held tightly to all edges during placement of the patch. If for any reason the foam insert shifts during placement of the patch the Work shall be rejected and redone at the Contractor's expense.

Patching material shall be consolidated by using a 1-inch or less diameter vibrator as approved by the Engineer. The Contractor shall not overwork the patching material during the patch consolidation process.

The patching material on the surface of the dowel bar slots shall not be overworked, causing segregation and leaving the fine material on the surface. The patching material shall be left ⅛ to ¼ inch high and not finished flush with the existing concrete surface.

The joint shall be maintained by saw cutting the surface with a hand pushed single blade saw. The cut width shall be 3⁄16 to 5⁄16 inch and the depth 1½ inches. The cut length shall be 2¼ feet long centered over the three retrofit dowel bars and shall be sawed within 24 hours after placement of the concrete patching material.

5-01.3(7) Sealing Existing Concrete Random Cracks

Sealing existing random cracks shall be in accordance with Section 5-03.

5-01.3(8) Sealing Existing Longitudinal and Transverse Joint

Sealing existing longitudinal and transverse joints shall be in accordance with Section 5-03.

5-01.3(9) Cement Concrete Pavement Grinding

Pavement grinding shall begin within 10 working days of placing dowel bar retrofit patching materials. Once the grinding operation has started it shall be continuous until completed. If new cement concrete pavement, in accordance with Section 5-05, is to be placed next to rehabilitated cement concrete pavement, grind one pass along the edge of the rehabilitated cement concrete pavement adjacent to where the new cement concrete pavement is to be placed before the new cement concrete pavement is placed.

The pavement shall be ground in a longitudinal direction beginning and ending at lines normal to the pavement centerline. Ninety-five percent of the surface area of the pavement to be ground shall have a minimum of ⅛ inch removed by grinding.

Bridge decks, bridge approach slabs, and bridge overlay insets shall not be ground. The ground pavement shall be feathered to match the elevation of the above features.

5-01.3(9)A Surface Finish

The final surface texture shall be uniform in appearance with longitudinal corduroy type texture. The grooves shall be between 3⁄32 and 5⁄32 inches wide, and no deeper than 1⁄16 inch. The land area between the grooves shall be between 1⁄16 and ⅛ inches wide.

5-01.3(10) Pavement Smoothness

Pavement surface smoothness for cement concrete pavement grinding on this project will include International Roughness Index (IRI) testing. Ride quality will be evaluated using the Mean Roughness Index (MRI) calculated by averaging the IRI data for the left and right wheel path within the section.

Smoothness Testing Equipment and Operator Certification

Use an inertial profiler and operator that meet the requirements of Section 5-05.3(3)E.

Surface Smoothness

Operate the inertial profiler in accordance with AASHTO R 57. Collect two longitudinal traces, one in each wheel path. Collect the control profile at locations designated in Table 2 prior to any pavement rehabilitation Work on the areas to be tested. Collect an acceptance profile at locations designated in Table 2 after completion of all cement concrete pavement grinding on the project. Profiles shall be collected in a continuous pass including areas excluded from pay adjustments. Provide notice to the Engineer a minimum of seven calendar days prior to testing.

Table 2 Locations Requiring MRI Testing

Travel lanes where cement concrete grinding is shown in the plans	Control profile
Additional locations designated by the Engineer	Control profile
Travel lanes with completed cement concrete pavement grinding	Acceptance profile
Bridges, approach panels and 0.02 miles before and after bridges and approach panels and other excluded areas within lanes requiring testing	Control and acceptance profile
Ramps, Shoulders and Tapers	Do not test

Within 30 calendar days after the Contractor's testing, the Engineer may perform verification testing. If the verification testing shows a difference in MRI greater than the 10 percent, the following resolution process will be followed:

1. The profiles, equipment and procedures will be evaluated to determine the cause of the difference.
2. If the cause of the discrepancy cannot be resolved the pavement shall be retested with both profilers at a mutually agreed time. The two profilers will test the section within 30 minutes of each other. If the retest shows a difference in MRI equal or greater than the percentages shown in Table 2 of AASHTO R 54 the Engineer's test results will be used for pavement smoothness acceptance.

The Contractor shall evaluate profiles for acceptance or corrective action using the current version of ProVAL and provide the results including the profile data in unfiltered electronic Engineering Research Division (ERD) file format to the Engineer within 3 calendar days of completing each days profile testing. If the profile data files are created using an export option in the manufacturer's software where filter settings can be specified, use the filter settings that were used to create data files for certification.

Analyze the entire profile. Exclude areas listed in Table 3.

Table 3 Areas Excluded from MRI Acceptance Requirements

Location	Exclude
Beginning and end of grinding	Pavement within 0.02 mile
Bridges and approach slabs	The bridge and approach slab and 0.02 mile from the ends of the bridge or approach slab
Defects in the existing roadway identified by the Contractor that adversely affect the MRI such as dips, depressions and wheel path longitudinal joints.[1]	0.01-mile section containing the defect and the 0.01-mile section following the section with the defect.

[1] The presence of defects is subject to verification by the Engineer

Report the MRI results in inches per mile for each 0.01-mile section and each 0.10-mile section. Do not truncate 0.10-mile sections for areas excluded from MRI acceptance requirements. MRI requirements will not apply to 0.10-mile sections with more than three 0.01 mile-sections excluded. MRI requirements for the individual 0.01-mile sections shall still apply. The Engineer will verify the analysis.

The MRI for each 0.10 mile of ground lane will comply with the following:

Control Profile per 0.10 Mile	Maximum MRI of Acceptance Profile per 0.10 Mile
≤130 inches/mile	78 inches/mile
>130 inches/mile	0.6 x Control Profile MRI

The MRI for each 0.01 mile of the completed cement concrete grinding shall not exceed 160 inches/mile.

All Work is subject to parallel and transverse 10-foot straightedge requirements, corrective work and disincentive adjustments.

Surface smoothness of travel lanes including areas subject to MRI testing shall not vary more than ⅛ inch from the lower edge of a 10-foot straightedge placed on the surface parallel to the centerline.

The smoothness perpendicular to the centerline will be measured with a 10-foot straightedge within the lanes. There shall be not vertical elevation difference of more than a ¼ inch between lanes.

Pavement that does not meet these requirements will be subject to corrective Work. All corrective Work shall be completed at no additional expense, including traffic control, to the Contracting Agency. Pavement shall be repaired by one or more of the following methods:

1. Diamond grinding.
2. By other method accepted by the Engineer.

Repair areas shall be re-profiled to ensure they no longer require corrective Work. With concurrence of the Engineer, a 10-foot straight edge may be used in place of the inertial profiler.

If correction of the roadway as listed above either will not or does not produce satisfactory results as to smoothness or serviceability the Engineer may accept the completed pavement and a credit will be calculated in accordance with Section 5-01.5. Under these circumstances, the decision whether to accept the completed pavement or to require corrective work as described above shall be vested entirely in the Engineer.

5-01.3(11) Concrete Slurry and Grinding Residue

All concrete slurry and grinding residue shall be removed from the pavement surface on a continual basis immediately behind the grinding or cutting operations. Slurry shall not be allowed to drain into an area open to traffic, off of the paved surface, into any drainage structure, water of the state, or wetlands.

The Contractor shall collect the concrete slurry and grinding residue from the pavement surface and dispose of it in accordance with Section 2-03.3(7)C. The Contractor shall submit copies of all disposal tickets to the Engineer within 5 calendar days.

Opening to traffic shall meet the requirements of Section 5-05.3(17).

5-01.4 Measurement

Replacement cement concrete panels will be measured by the square yard, based on the actual width and length of the surface area placed.

Retrofit dowel bars will be measured per each for the actual number of bars used in the completed Work.

Cement concrete pavement grinding will be measured by the square yard, based on the actual width and length of area ground. Extra passes to meet the Specifications or overlaps will not be measured.

5-01.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Replace Cement Concrete Panel", per square yard.

The unit Contract price per square yard shall be full payment for all costs to complete the Work as specified, including saw cutting full depth, removal and disposal of the existing panels off of the Contracting Agency's Right of Way, preparing the surfacing below the new panel, provide, place and compact the crushed surfacing or hot mix asphalt, furnishing and placing polyethylene film or building paper, furnishing and placing the cement concrete, drilling the holes, providing and anchoring the dowel bars and tie bars, and for all incidentals required to complete the Work as specified.

"Retrofit Dowel Bars", per each.

The unit Contract price per each shall be full payment for all costs to complete the Work as specified, including furnishing and installing parting compound, dowel bar expansion caps, caulking filler, foam core insert material, cement patch where pavement is removed for dowel bar retrofit and for all incidentals required to complete the Work as specified.

"Partial Depth Spall Repair", by force account as provided in Section 1-09.6.

To provide a common Proposal for all Bidders, the Contracting Agency has entered an amount in the Proposal to become a part of the total Bid by the Contractor.

"Grinding Smoothness Compliance Adjustment", by calculation.

Grinding Smoothness Compliance Adjustments will be based on the requirements in Section 5-01.3(10) and the following calculations:

A smoothness compliance adjustment will be calculated in the sum of minus $100 for each and every section of single traffic lane 0.01 mile in length and $1,000 for each and every section of single traffic lane 0.10 mile in length that does not meet the requirements in Section 5-01.3(10) after corrective Work.

"Cement Concrete Pavement Grinding", per square yard.

The unit Contract price per square yard for "Cement Concrete Pavement Grinding", when multiplied by the number of units measured, shall be full payment for all costs to complete the Work as specified. The costs of any additional pavement grinding and profiling required to complete the Work as specified is also included in this payment.

"Replace Uncompactable Material", by force account as provided in Section 1-09.6.

Payment for "Replace Uncompactable Material" will be by force account as provided in Section 1-09.6 and will be full payment for all work required to replace uncompactable material and provide base for the Concrete panel. This will include, but not be limited to, excavating the subgrade, placement of a soil stabilization construction geotextile, and backfilling with crushed surfacing base course, as well as the work detailed in items 1 through 5 noted in Section 5-01.3(4). For the purpose of providing a common Proposal for Bidders, the Contracting Agency has entered an amount in the Proposal to become a part of the total Bid by the Contractor.

All costs associated with the containment, collection and disposal of concrete slurry and grinding residue shall be included in the applicable concrete grinding or cutting items of Work.

5-02 Bituminous Surface Treatment

5-02.1 Description

This Work shall consist of constructing a single or multiple course bituminous surface treatment (BST) in accordance with these Specifications and in conformity with the lines and cross-sections shown in the Plans or as designated by the Engineer.

5-02.1(1) New Construction

This method of treatment requires two applications of emulsified asphalt and three applications of aggregate. The first application of emulsified asphalt is applied to an untreated Roadway that is followed with an application of aggregate. The second application of emulsified asphalt is followed with two additional applications of aggregate.

5-02.1(2) Seal Coats

This method requires the placing of one application of emulsified asphalt and one or more sizes of aggregate as specified to an existing pavement to seal and rejuvenate the surface and to produce a uniform Roadway surface with acceptable nonskid characteristics.

5-02.1(3) Pavement Sealers – Fog Seal

This method of treatment requires an application of emulsified asphalt over an existing or newly constructed pavement as specified.

5-02.2 Materials

Materials shall meet the requirements of the following sections:

Cationic Emulsified Asphalt	9-02.1(6)
Aggregates for Bituminous Surface Treatment	9-03.4

Each source of aggregate for bituminous surface treatment shall be evaluated separately for acceptance in accordance with Section 3-04.

5-02.3 Construction Requirements

5-02.3(1) Equipment

The equipment used by the Contractor shall be subject to approval by the Engineer before its use.

The distributor shall be capable of uniformly applying emulsified asphalt at the required application temperature and rate. A temperature measuring device shall be capable of reporting the temperature of emulsified asphalt in the tank. A tachometer shall be required to accurately control the application of emulsified asphalt. Distributors shall be equipped with an adjustable spray bar with pressure pump and gauge. The power for operating the pressure pump shall be supplied by a power unit which will provide a uniform spray from each of the nozzles across the spray bar and extensions. The distributor truck shall have a volume control gauge. All reading devices and gauges shall be easily accessible by Inspectors from the ground.

Rollers for seal coats shall be self-propelled pneumatic tired rollers. Rollers for new construction shall be a combination of self-propelled pneumatic tired rollers and smooth-wheeled rollers. Each roller shall not weigh less than 12 tons and shall be capable of providing constant contact pressure. Operation of the roller shall be in accordance with the manufacturer's recommendations.

Aggregate spreading equipment shall be self-propelled, supported on at least four pneumatic tires, with an approved device for accurately metering and distributing the aggregate uniformly over the Roadway surface. Spreading equipment shall be so equipped that the operator has positive width control. This control shall allow the operator to adjust the spreading width of aggregates in 6-inch increments without stopping the machine.

Brooms shall be motorized and capable of controlling vertical pressure.

Other equipment necessary to satisfactorily perform the Work as specified herein or as designated by the Engineer shall be subject to approval by the Engineer before its use in the Work.

Additional units shall be used in the Work when, in the opinion of the Engineer, it is considered necessary in order to fulfill the requirements of these Specifications, or to complete the Work within the time specified.

5-02.3(2) Preparation of Roadway Surface

5-02.3(2)A New Construction

The existing Roadway surface shall be shaped to a uniform grade and cross-section as shown in the Plans, or as designated by the Engineer.

The Roadway shall be dampened, bladed and rolled until the entire Roadway surface shows a uniform grading and conforms to the line, grade, and cross-section shown in the Plans, or as staked. During the operation of blading and rolling, water shall be applied, if necessary, in the amount and at the locations designated by the Engineer.

The entire surface shall be rolled with a smooth-wheeled or pneumatic-tired roller, or both, as designated by the Engineer, except that the final rolling shall be accomplished with a smooth-wheeled roller as specified in Section 5-02.3(1). Rolling shall continue until the entire Roadway presents a firm, damp and unyielding surface.

Immediately before the first application of emulsified asphalt, the Roadway surface shall be in the following condition: firm and unyielding, damp, free from irregularities and material segregation, and true to line, grade, and cross-section.

No traffic will be allowed on the prepared surface until the first application of emulsified asphalt and aggregate has been completed.

5-02.3(2)B Seal Coats

The existing bituminous surface shall be swept with a power broom until it is free from dirt or other foreign matter. Hand push brooms shall be used to clean omissions of the power broom. In addition to power and hand brooms, the use of other equipment may be necessary to thoroughly clean the Roadway prior to the application of emulsified asphalt. Berms created by the removal of dirt or other foreign matter shall be evenly distributed over the fore slope.

Repair of existing pavement shall be done in accordance with Section 5-04. The HMA in repaired areas shall be fog sealed. HMA repaired areas may require a second fog seal depending on surface texture as required by the Engineer. The pavement surface shall be dry prior to fog sealing.

5-02.3(2)C Pavement Sealing – Fog Seal

Where shown in the Plans or directed by the Engineer, the Contractor shall apply a fog seal. Before application of the fog seal, all surfaces shall be thoroughly cleaned of dust, soil, pavement grindings, and other foreign matter. The existing pavement surface shall be dry.

5-02.3(2)D Soil Residual Herbicide

Where shown in the Plans, soil residual herbicide shall be applied in accordance with Section 5-04. Application of the BST shall begin within 24 hours after application of the herbicide.

5-02.3(2)E Crack Sealing

Crack sealing shall be in accordance with Section 5-03.

5-02.3(3) Application of Emulsified Asphalt and Aggregate

Upon the properly prepared Roadway surface, emulsified asphalt of the grade specified in the Special Provisions shall be uniformly applied with distributors and specified aggregates spread at the following rates:

Application Rate			
	Undiluted Emulsified Asphalt (gal. per sq. yd.) Applied	**Aggregate Size**	**Aggregate Application Rate (lbs. per sq. yd.)**
New Construction			
First Application	0.35-0.65	½ inch - No. 4 or ¾ inch - ½ inch	25-45
Second Application	0.35-0.60	½ inch - No. 4	25-40
Choke Stone	N/A	No. 4 - 0	4-6
Seal Coats			
⅝ inch – No. 4 Choke Stone	0.40-0.65	⅝ inch - No. 4 No. 4 - 0	25-45 4-6
½ inch – No. 4 Choke Stone	0.35-0.55	½ inch - No. 4 No. 4 - 0	20-35 4-6
⅜ inch – No. 4	0.35-0.55	⅜ inch - No. 4	20-30
Choke Stone	N/A	No. 4 - 0	4-6

The Engineer will determine the application rates. The second application of emulsified asphalt shall be applied the next day, or as approved by the Engineer.

Longitudinal joints will be allowed at only the centerline of the Roadway, the center of the driving lanes, or the edge of the driving lanes.

To ensure uniform distribution of emulsified asphalt and that the distributor is correctly calibrated, the Contractor shall provide a minimum 1,000-foot test strip when beginning a BST section.

To avoid gaps and ridges at transverse junctions of separate applications of emulsified asphalt and aggregate, the Contractor shall spread sufficient building paper over the treated surface to ensure that the distributor will be functioning normally when the untreated surface is reached. If ordered by the Engineer, the joints shall be cut back to a neat edge prior to placing the building paper.

Should ridges, overlaps, or gaps occur at transverse joints, the Contractor shall repair the defects to the satisfaction of the Engineer. In lieu of repair the Engineer may elect to accept the completed joints and will deduct from monies due or that may become due the Contractor, the sum of $200 for each joint where the deviations described above are found. Should longitudinal joints occur outside the centerline of the Roadway, the center of the driving lanes, or the edge of the driving lanes, the Contractor shall repair the defects to the satisfaction of the Engineer.

All costs involved in making the corrections to defects described above shall be borne by the Contractor and no payment will be made for this Work.

Omissions (skips) by the distributor or tire marks on the uncovered emulsified asphalt shall be immediately covered by hand patching with the same grade of emulsified asphalt and aggregate used on the project.

The area covered by any one spread of emulsified asphalt shall be no more than can be covered with aggregate within 1 minute from the time of application upon any part of the spread. If field conditions warrant, this time may be increased as designated by the Engineer.

Unless otherwise designated by the Engineer, emulsified asphalt shall be spread toward the source of aggregate to avoid injury to the freshly treated surface.

Before application to the Roadway, emulsified asphalt shall be heated to the following temperatures or that recommended by the manufacturer:

Type and Grade of Emulsified Asphalt	Distributor Temperature	
	Min. °F	Max. °F
New Construction and Seal Coats		
CRS-1, CRS-2, CRS-2P	125	195
CMS-2, CMS-2S, CMS-2h	125	185
Fog Seal		
CSS-1, CSS-1h	70	140

Before application of the fog seal, all surfaces shall be thoroughly cleaned of dust, soil, pavement grindings, and other foreign matter. The fog seal emulsified asphalt shall be CSS-1 or CSS-1h diluted with water at a rate of one part water to one part emulsified asphalt unless otherwise approved by the Engineer. The fog seal shall be uniformly applied to the pavement at a diluted rate of 0.10 – 0.18 gal/sy. The finished application shall be free of streaks and bare spots.

Fog sealing shall be applied no sooner than 3 days, but no later than 14 days after new construction or seal coat. If required, newly placed aggregates shall be swept prior to the fog seal application. Rebrooming for fog seal applications shall be paid under “Additional Brooming”, per hour as specified in Section 5-02.5.

5-02.3(4) Vacant

5-02.3(5) Application of Aggregates

All aggregate stockpiles shall be watered down to provide aggregates that are uniformly damp at the time of placement on the Roadway.

After the emulsified asphalt has been spread evenly over the Roadway surface, aggregates of the type specified shall be evenly applied to the Roadway surface by spreader equipment.

The aggregate shall be spread in one operation in such a manner that an 8-inch strip of emulsified asphalt is left exposed along the longitudinal joint to form a lap for the succeeding applications of emulsified asphalt. If necessary, thin or bare spots in the spread of aggregate shall be corrected immediately by re-spreading with the chip spreader or by hand spreading the aggregate.

A minimum of three pneumatic tired rollers providing a minimum of two complete coverages to the Roadway immediately behind the spreading equipment for the coarse aggregate shall be required.

The maximum rate of roller travel shall be limited to 8 mph.

The Contractor shall apply choke stone to the Roadway with additional spreading equipment immediately following the initial rolling of the coarse aggregate unless otherwise specified in the Contract documents or specified by the Engineer. Excess aggregate shall be removed from the Roadway. A minimum of one pass with a pneumatic roller shall be made across the entire width of the applied choke stone.

The operation of trucks hauling aggregate from the stockpile shall be so regulated that no damage, as determined by the Engineer, will result to the Highway or the freshly applied asphalt surface.

The completed surface shall be allowed to cure and then broomed as soon as practical.

If brooming causes rock to be turned or if the Engineer determines that additional cure is needed, the Contractor shall broom the Roadway when directed by the Engineer. If, after completion of the initial brooming, the Engineer determines the need to remobilize for additional brooming, the Contractor shall rebroom the areas designated by the Engineer. The Contractor shall apply water for dust control during brooming operations when safety or environmental concerns arise, or as otherwise determined by the Engineer.

The Contractor shall be held responsible for protecting all surface waters, riparian habitats, or other sensitive areas that may be encroached upon by brooming operations. Materials such as dirt, foreign material, or aggregates removed from these areas shall become the property of the Contractor and shall be disposed of in accordance with Section 2-03.3(7).

The Contractor shall use a pickup broom in all curbed areas, on all bridges, within city limits, within sensitive areas, and where shown in the Plans both before the application of emulsified asphalt and during the final brooming operation. When the pickup broom does not satisfactorily pickup the aggregate, manual methods shall be used. Materials collected by the pick up broom shall become the property of the Contractor and shall be disposed of in accordance with Section 2-03.3(7).

Aggregates accumulated in intersections and driveways due to brooming operations shall become the property of the Contractor and shall be disposed of in accordance with Section 2-03.3(7).

The Contractor shall notify the Engineer when the brooming for each section is considered complete. The Engineer will indicate acceptance or inform the Contractor of deficiencies within 24 hours of notification.

5-02.3(6) Additional Emulsified Asphalt and Aggregate

If the application of emulsified asphalt or aggregate, or both, is insufficient or excessive for the required results, the Engineer may require the Contractor to make an additional application of one or both materials in accordance with these Specifications, or at the direction of the Engineer. Additional emulsified asphalt or aggregate used will be paid for at the unit Contract prices for the materials used.

5-02.3(7) Patching and Correction of Defects

Omissions by the distributor or damage to the treated surface of any coat shall be immediately covered by hand patching with emulsified asphalt in adequate quantities. Holes which develop in the surface shall be patched in the same manner as specified in Section 5-02.3(2)A. All costs incurred by the Contractor, in coating omissions and patching, shall be included in the unit Contract prices for the materials used.

Defects such as raveling, lack of uniformity, or other imperfections caused by faulty workmanship shall be corrected and new Work shall not be started until such defects have been remedied.

All improper workmanship and defective materials resulting from overheating, improper handling or application, shall be removed from the Roadway by the Contractor and be replaced with approved materials and workmanship at no expense to the Contracting Agency.

If the Engineer determines a fog seal is necessary at any time during the life of the Contract, the Contractor shall apply a fog seal. The CSS-1 or CSS-1h emulsified asphalt may be diluted with water at a rate of one part water to one part emulsified asphalt unless otherwise specified by the Engineer.

5-02.3(8) Progress of Work

The Contractor shall organize the Work so that no longitudinal joints shall remain open overnight.

5-02.3(9) Protection of Structures

The Contractor shall be responsible for protecting monument covers, sewer lids, manhole covers, water valve covers, drainage grates, inlets, railroad tracks, bridge handrails and expansion joints, guardrails, curbs, road signs, guide posts, or other facilities from the application of emulsified asphalt and aggregates. This protective effort is to include uncovering these items the same working day that the completed BST or seal coat construction has passed the protected locations. If needed, drainage inlets shall be cleaned out immediately after final brooming is completed. All costs incurred by the Contractor in necessary protective measures shall be included in the unit Contract prices for the various Bid items of Work involved.

5-02.3(10) Unfavorable Weather

Emulsified asphalt shall not be applied to a wet Roadway. Subject to the determination of the Engineer, emulsified asphalt shall not be applied during rainfall, sand or dust storms, or before any imminent storms that might damage the construction. The Engineer will have the discretion as to whether the surface and materials are dry enough to proceed with construction.

The application of any emulsified asphalt to the Roadway shall be restricted to the following conditions:

1. The Roadway surface temperature shall be at least 55°F. The air temperature shall be at least 60°F and rising. The air temperature shall be not less than 70°F when falling and the wind shall be less than 10 mph as estimated by the Engineer.
2. The surface temperature shall be not more than 130° F or as otherwise determined by the Engineer.
3. No emulsified asphalt shall be applied which cannot be covered 1 hour before darkness. The Engineer may require the Contractor to delay application of emulsified asphalt until the atmospheric and Roadway conditions are satisfactory.
4. Construction of bituminous surface treatments shall not be carried out before May 1 or after August 31 of any year except upon written order of the Engineer.

5-02.3(11) Temporary Pavement Markings

During bituminous surface treatment paving operations, temporary pavement markings shall be maintained throughout the project. Temporary pavement markings shall be installed on the Roadway that was paved that day. Temporary pavement markings shall be in accordance with Section 8-23.

5-02.4 Measurement

Processing and finishing will be measured by the mile to the nearest 0.01 mile along the main line Roadway. All related supplemental Roadways and irregular shaped areas will be incidental.

Emulsified asphalt of the grade or grades specified will be measured by the ton in accordance with Section 1-09.

Asphalt for fog seal will be measured by the ton, before dilution, in accordance with Section 1-09.

Aggregate from stockpile for BST will be measured by the cubic yard in trucks at the point of delivery on the Roadway.

Furnishing and placing crushed aggregate will be measured by the cubic yard in trucks at the point of delivery on the Roadway, or by the ton in accordance with Section 1-09.1.

Additional brooming will be measured by the hour.

Water will be measured in accordance with Section 2-07.

5-02.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Processing and Finishing", per mile.

The unit Contract price per mile for "Processing and Finishing" shall be full pay for all costs to perform the specified Work including blading, scarifying, processing, leveling, finishing, and the manipulation of aggregates as required. In the event the Proposal does not include a Bid item for "Processing and Finishing" then all costs for processing and finishing shall be included in other related items of Work.

"Emulsified Asphalt (_____)", per ton.

The unit Contract price per ton for "Emulsified Asphalt (_____) shall be full pay for all costs to perform the specified Work including furnishing, heating, hauling, and spreading the emulsified asphalt on the Roadway.

"Asphalt for Fog Seal", per ton.

The unit Contract price per ton for "Asphalt for Fog Seal" shall be full pay for all costs to perform the specified Work for fog seal.

"Agg. from Stockpile for BST", per cubic yard.

The unit Contract price per cubic yard for "Aggregate from Stockpile for BST" shall be full pay for all costs to perform the specified Work including loading, transporting, and placing the material in the finished Work.

"Furnishing and Placing Crushed (_____)", per cubic yard.

"Furnishing and Placing Crushed (_____)", per ton.

The unit Contract price per cubic yard or per ton for "Furnishing and Placing Crushed (_____) shall be full pay for all costs to perform the specified Work including furnishing, transporting, and placing the material in the finished Work.

"Additional Brooming", per hour.

The unit Contract price per hour for "Additional Brooming" shall be full pay for all costs to perform the specified Work including rebrooming the Roadway.

"Water", per M gal.

Payment for "Water" shall be in accordance with Section 2-07.5.

If the Proposal does not include a Bid item for water, the Contractor shall dampen stockpiled or furnished aggregate as required, and the cost thereof shall be included in other related items of the Work.

Any incidental Work required to complete the bituminous surface treatment that is not specifically mentioned as included with the Bid items above shall be performed by the Contractor and shall be included in the unit Contract prices of the various related Bid items.

5-03 Crack and Joint Sealing

5-03.1 Description

This Work consists of preparing and sealing cracks and joints in pavement.

5-03.2 Materials

Materials shall meet the requirements of the following sections:

Cationic Emulsified Asphalt	9-02.1(6)
Hot Poured Sealant for Cement Concrete Pavement	9-04.2(1)A1
Hot Poured Sealant for Bituminous Pavement	9-04.2(1)A2
Sand Slurry for Bituminous Pavement	9-04.2(1)B
Polymer Modified Asphalt Mastic	9-04.2(1)C
Closed Cell Foam Backer Rod	9-04.2(3)A

5-03.3 Construction Materials

5-03.3(1) General Requirements

5-03.3(1)A Weather Limitations

The Contractor shall follow the weather limitations recommended by the manufacturer.

Sand Slurry, or in the absence of manufacturer recommendations Hot Poured Sealant or Polymer Modified Asphalt Mastic shall not be placed when the pavement temperature is less than 40°F, or during any precipitation.

5-03.3(1)B Cleaning, Drying and Debris Removal

The Contractor shall ensure that cracks and joints are thoroughly clean, dry and free of all loose and foreign material immediately prior to filling with sealant material.

For bituminous pavements when the pavement temperature is less than 50°F, or there is any moisture in the cracks or joint the Contractor shall use a hot compressed air lance to dry and warm the pavement surfaces within the crack or joint immediately prior to filling with sealant. The pavement shall not be overheated. Direct flame dryers shall not be used.

Routing cracks in bituminous pavements is not required unless required by the manufacturer's installation instructions.

5-03.3(1)C Polymer Modified Asphalt Mastic

The Contractor shall furnish a Type 2 working drawing of the manufacturer's product information and recommendations to the Engineer prior to the start of work. The manufacturer's recommendations shall include the heating time and temperatures, allowable storage time and temperatures after initial heating, allowable reheating criteria, and application temperature range. The polymer modified asphalt mastic shall be confined within the crack. Any overflow of polymer modified asphalt mastic shall be cleaned from the pavement surface. If, in the opinion of the Engineer, the Contractor's method results in an excessive amount of polymer modified asphalt mastic on the pavement surface, the operation shall be stopped and corrected to eliminate the excess. BST or HMA shall not be placed over polymer modified asphalt mastic until a minimum of 14 calendar days have elapsed following application.

5-03.3(1)D Sand Slurry

The sand slurry components shall be thoroughly mixed and the mixture shall be poured into the cracks until full. Additional CSS-1 cationic emulsified asphalt may be added to the sand slurry as needed for workability to ensure the mixture will completely fill the cracks. The Contractor shall strike off the sand slurry flush with the existing pavement surface and allow the mixture to cure. Cracks that were not completely filled shall be topped off with additional sand slurry. Placement of the HMA overlay shall not commence until the slurry has fully cured.

5-03.3(1)E Hot Poured Sealant

The Contractor shall furnish a Type 2 working drawing of the manufacturer's product information and recommendations to the Engineer prior to the start of work. The manufacturer's recommendations shall include the heating time and temperatures, allowable storage time and temperatures after initial heating, allowable reheating criteria, and application temperature range. The sealant material shall be confined within the crack or joint. Any overflow of sealant shall be cleaned from the pavement surface. If, in the opinion of the Engineer, the Contractor's method results in an excessive amount of sealant on the pavement surface, the operation shall be stopped and corrected to eliminate the excess. BST or HMA shall not be placed over hot poured sealant until a minimum of 14 calendar days have elapsed following application.

5-03.3(2) Sealing Bituminous Pavement

Where shown in the Plans all cracks ¼ inch in width and greater or joints in HMA or BST pavement shall be sealed.

5-03.3(2)A Material Selection

The material to be used for crack or joint sealing shall be selected from the following table based on the width of the cracks and the nature of the material that will be placed over the crack sealing material.

Crack or Joint Seal Material Selection			
	Material to be Placed Over the Sealed Crack or Joint		
Crack or Joint to be Sealed	HMA	BST	Areas not Paved under the Contract
Cracks with widths form ¼ inch to 1 inch	Sand Slurry	Hot Poured Sealant	Hot Poured Sealant
Cracks with widths greater than 1 inch	Polymer Modified Asphalt Mastic	Polymer Modified Asphalt Mastic	Polymer Modified Asphalt Mastic
All Joints	Hot Poured Sealant		

5-03.3(2)B Longitudinal Joint Seal

When HMA is placed adjacent to cement concrete pavement, the Contractor shall construct longitudinal joints between the HMA and the cement concrete pavement. The joint shall be sawed to the dimensions shown on Standard Plan A-40.10 and filled with joint sealant meeting the requirements of Section 9-04.2(1)A2.

5-03.3(2)C Bridge Paving Joint Seals

5-03.3(2)C1 HMA Sawcut and Seal

Prior to placing HMA on the bridge deck sawcut alignment points shall be established at both ends of the bridge paving joint seals to be placed at the bridge ends, and at interior joints within the bridge deck when and where shown in the Plans. The sawcut alignment points shall be established in a manner that they remain functional for use in aligning the sawcut after placing the HMA overlay.

The Contractor shall construct the bridge paving joint seal as specified in the Plans and in accordance with the detail shown in the Standard Plans. The sawed joint shall be constructed in accordance with Section 5-05.3(8) and filled with joint sealant meeting the requirements of Section 9-04.2(1)A2.

5-03.3(2)C2 Paved Panel Joint Seal

The Contractor shall construct the paved panel joint seal in accordance with the requirements specified in Section 5-03.3(2)C1 and the following requirement:

1. The existing joint between concrete panels shall be cleaned and sealed in accordance with Section 5-03.3(3)B and the details shown in the Standard Plans.

5-03.3(3) Sealing Cement Concrete Pavement

5-03.3(3)A Sealing Existing Concrete Random Crack

The Contractor shall route, clean and seal existing concrete random cracks in existing cement concrete pavement where indicated by the Engineer. Cracks smaller than 5⁄16 inch in width shall be routed to 5⁄16 inch wide by 1 inch deep prior to placing the sealant. Cracks over 5⁄16 inch in width shall be cleaned and sealed.

All incompressible material shall be completely removed from the existing random crack to a depth of ¾ inch. Immediately prior to sealing, the cracks shall be clean.

The top surface of the sealant shall be at least ¼ inch below the surface of the pavement.

5-03.3(3)B Sealing Existing Transverse and Longitudinal Joint

The Contractor shall clean and seal existing longitudinal and transverse joints in cement concrete pavement where shown in the Plans or as marked by the Engineer.

Old sealant and incompressible material shall be completely removed from the joint to the depth of the new reservoir with a diamond blade saw in accordance with the detail shown in the Standard Plans. The removed sealant shall become the property of the Contractor and be removed from the jobsite.

Removal of the old sealant for the entire depth of the joint is not required if the depth of the new reservoir is less than the depth of the existing joint.

Joints constructed with joint tape do not require cleaning and sealing.

If shown in the Plans, a backer rod shall be placed at the base of the sawn reservoir. The joints shall be completely dry before the sealing installation may begin. Immediately following the cleaning and backer rod replacement, if required, the sealant material shall be installed in conformance to manufacturer's recommendations and in accordance with Section 5-03.3(3)C.

The top surface of the sealant shall be at least ¼ inch below the surface of the pavement.

5-03.3(3)C Sealing Sawed Contraction Joints

Sawed contraction joints shall be filled with a joint sealant conforming to the requirements of Section 9-04.2(1)A1. Care shall be taken to avoid air pockets. The joint sealant shall be applied in two or more layers, if necessary. The joint sealant shall be applied under sufficient pressure to fill the groove from bottom to top and the cured joint sealant shall be between ¼ and ⅝ inch below the top surface of the concrete.

5-03.3(3)D Construction Joints

All transverse and longitudinal construction joints, including the joint between new and existing pavement when widened, shall be sawed and sealed with joint sealant conforming to the requirements of Sections 5-03.3(3)C and 9-04.2(1)A1.

5-03.4 Measurement

"Crack Sealing ¼ inch to 1 inch in width - LF" will be measured by the linear foot along the line of the cracks.

"Crack Sealing greater than 1 inch in width - LF" will be measured by the linear foot along the line of the cracks.

"Crack Sealing-CM" will be measured by the centerline mile. Measurement will begin and end at the stations indicated in the Plans. Shoulders, road approaches, gores and irregular shaped areas will be incidental and not measures separately for payment.

"Crack Sealing-LF" will be measured by the linear foot along the line of the cracks that have been completed as required by Section 5-03.

Sealing existing concrete random cracks will be measured by the linear foot, measured along the crack sealed.

Sealing existing longitudinal and transverse joint will be measured by the linear foot, measured along the line of the completed joint.

Longitudinal joint seals between the HMA and cement concrete pavement will be measured by the linear foot along the line and slope of the completed joint seal.

HMA sawcut and seal, and paved panel joint seal, will be measured by the linear foot along the line and slope of the completed joint seal.

5-03.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Crack Sealing-FA", by force account.

"Crack Sealing-FA" will be paid for by force account as specified in Section 1-09.6. For the purpose of providing a common Proposal for all Bidders, the Contracting Agency has entered an amount in the Proposal to become a part of the total Bid by the Contractor.

"Crack Sealing ¼ inch to 1 inch in width - LF", per linear foot.

The unit Contract price per linear foot for "Crack Sealing ¼ inch to 1 inch in width - LF" shall be full payment for all costs incurred to perform the Work required in Section 5-03 related to cracks that are ¼ inch to 1 inch in width.

"Crack Sealing greater than 1 inch in width - LF", per linear foot.

The unit Contract price per linear foot for "Crack Sealing greater than 1 inch in width - LF" shall be full payment for all costs incurred to perform the Work required in Section 5-03 related to cracks that are greater than 1 inch in width.

"Crack Sealing-CM", per centerline mile.

The unit contract price per lane mile for "Crack Sealing-CM", shall be full payment for all costs incurred to perform the Work described in Section 5-03 including all lanes, paved shoulders, road approaches, gores and irregular shaped areas.

"Crack Sealing-LF", per linear foot.

The unit contract price per linear foot for "Crack Sealing-LF" shall be full payment for all costs incurred to perform the Work described in Section 5-03.

"Sealing Existing Concrete Random Crack", per linear foot.

The unit Contract price per linear foot for "Sealing Existing Concrete Random Crack" shall be full payment for all costs to complete the Work as specified, including removing incompressible material, preparing and sealing existing random cracks where existing random cracks are cleaned and for all incidentals required to complete the Work as specified.

"Sealing Existing Longitudinal and Transverse Joint", per linear foot.

The unit Contract price per linear foot for "Sealing Existing Longitudinal and Transverse Joint", shall be full payment for all costs to complete the Work as specified, including removing incompressible material, preparing and sealing existing transverse and longitudinal joints where existing transverse and longitudinal joints are cleaned and for all incidentals required to complete the Work as specified.

"Longitudinal Joint Seal", per linear foot.

The unit Contract price per linear foot for "Longitudinal Joint Seal" shall be full payment for all costs incurred to construct the longitudinal joint between HMA and cement concrete pavement, as described in Section 5-03.

"HMA Sawcut And Seal", per linear foot.

The unit Contract price per linear foot for "HMA Sawcut And Seal" shall be full payment for all costs incurred to perform the Work described in Section 5-03.3(2)C1.

"Paved Panel Joint Seal", per linear foot.

The unit Contract price per linear foot for "Paved Panel Joint Seal" shall be full payment for all costs incurred to perform the Work described in Section 5-03.3(2)C2.

Sealing Sawed Contraction Joints and Construction Joints shall be included in the cost of "Cement Concrete Pavement".

5-04 Hot Mix Asphalt

This Section 5-04 is written in a style which, unless otherwise indicated, shall be interpreted as direction to the Contractor.

5-04.1 Description

This Work consists of providing and placing one or more layers of plant-mixed hot mix asphalt (HMA) on a prepared foundation or base, in accordance with these Specifications and the lines, grades, thicknesses, and typical cross-sections shown in the Plans. The manufacture of HMA may include additives or processes that reduce the optimum mixing temperature (Warm Mix Asphalt) or serve as a compaction aid in accordance with these Specifications.

HMA shall be composed of asphalt binder and mineral materials as required, and may include reclaimed asphalt pavement (RAP) or reclaimed asphalt shingles (RAS), mixed in the proportions specified to provide a homogeneous, stable, and workable mix.

5-04.2 Materials

Provide materials as specified in these sections:

Asphalt Binder	9-02.1(4)
Cationic Emulsified Asphalt	9-02.1(6)
Anti-Stripping Additive	9-02.4
HMA Additive	9-02.5
Aggregates	9-03.8
Reclaimed Asphalt Pavement (RAP)	9-03.8(3)B, 9-03.21
Reclaimed Asphalt Shingles (RAS)	9-03.8(3)B, 9-03.21
Mineral Filler	9-03.8(5)
Recycled Material	9-03.21

5-04.2(1) How to Get an HMA Mix Design on the QPL

Comply with each of the following:

- Develop the mix design in accordance with WSDOT SOP 732.
- Develop a mix design that complies with Sections 9-03.8(2) and 9-03.8(6).
- Develop a mix design no more than 6 months prior to submitting it for QPL evaluation.
- Submit mix designs to the WSDOT State Materials Laboratory in Tumwater, including WSDOT Form 350-042.
- Include representative samples of the materials that are to be used in the HMA production as part of the mix design submittal.
- Identify the brand, type, and percentage of anti-stripping additive in the mix design submittal.
- Include with the mix design submittal a certification from the asphalt binder supplier that the anti-stripping additive is compatible with the crude source and the formulation of asphalt binder proposed for use in the mix design.

- Do not include HMA additives that reduce the optimum mixing temperature or serve as a compaction aid when developing a mix design or submitting a mix design for QPL evaluation. The use of HMA additives is not part of the process for obtaining approval for listing a mix design on the QPL. Refer to Section 5-04.2(2)B.

The Contracting Agency's basis for approving, testing, and evaluating HMA mix designs for approval on the QPL is dependent on the contractual basis for acceptance of the HMA mixture, as shown in Table 1.

Table 1 Basis for Contracting Agency Evaluation of HMA Mix Designs for Approval on the QPL

Contractual Basis for Acceptance of HMA Mixture [see Section 5-04.3(9)]	Basis for Contracting Agency Approval of Mix Design for Placement on QPL	Contracting Agency Materials Testing for Evaluation of the Mix Design
Statistical Evaluation	WSDOT Standard Practice QC-8 located in the WSDOT *Materials Manual* M 46-01	The Contracting Agency will test the mix design materials for compliance with Sections 9-03.8(2) and 9-03.8(6).
Visual Evaluation	Review of Form 350-042 for compliance with Sections 9-03.8(2) and 9-03.8(6))	The Contracting Agency may elect to test the mix design materials, or evaluate in accordance with WSDOT Standard Practice QC-8, at its sole discretion.

If the Contracting Agency approves the mix design, it will be listed on the QPL for 12 consecutive months. The Contracting Agency may extend the 12 month listing provided the Contractor submits a certification letter to the Qualified Products Engineer verifying that the aggregate source and job mix formula (JMF) gradation, and asphalt binder crude source and formulation have not changed. The Contractor may submit the certification no sooner than three months prior to expiration of the initial 12 month mix design approval. Within 7 calendar days of receipt of the Contractor's certification, the Contracting Agency will update the QPL. The maximum duration for approval of a mix design and listing on the QPL will be 24 months from the date of initial approval or as approved by the Engineer.

5-04.2(1)A Mix Designs Containing RAP and/or RAS

Mix designs are classified by the RAP and/or RAS content as shown in Table 2.

Table 2 Mix Design Classification Based on RAP/RAS Content

RAP/RAS Classification	RAP/RAS Content[1]
Low RAP/No RAS	0% ≤ RAP% ≤ 20% and RAS% = 0%
High RAP/Any RAS	20% < RAP% ≤ Maximum Allowable RAP[2] and/or 0% < RAS% ≤ Maximum Allowable RAS[2]

[1]Percentages in this table are by total weight of HMA.

[2]See Table 4 in Section 5-04.2(1)A2 to determine the limits on the maximum amount RAP and/or RAS.

5-04.2(1)A1 Low RAP/No RAS – Mix Design Submittals for Placement on QPL

For Low RAP/No RAS mix designs, comply with the following additional requirements:

1. Develop the mix design with or without the inclusion of RAP.
2. The asphalt binder grade shall be the grade indicated in the Bid item name or as otherwise required by the Contract.
3. Submit samples of RAP if used in development of the mix design.
4. Testing RAP or RAS stockpiles is not required for obtaining approval for placing these mix designs on the QPL.

5-04.2(1)A2 High RAP/Any RAS – Mix Design Submittals for Placement on QPL

For High RAP/Any RAS mix designs, comply with the following additional requirements:

1. For mix designs with any RAS, test the RAS stockpile (and RAP stockpile if any RAP is in the mix design) in accordance with Table 3.
2. For High RAP mix designs with no RAS, test the RAP stockpile in accordance with Table 3.
3. For mix designs with High RAP/Any RAS, construct a single stockpile for RAP and a single stockpile for RAS and isolate (sequester) these stockpiles from further stockpiling before beginning development of the mix design. Test the RAP and RAS during stockpile construction as required by item 1 and 2 above. Use the test data in developing the mix design, and report the test data to The Contracting Agency on WSDOT Form 350-042 as part of the mix design submittal for approval on the QPL. Account for the reduction in asphalt binder contributed from RAS in accordance with AASHTO PP 78. Do not add to these stockpiles after starting the mix design process.

Table 3 Test Frequency of RAP/RAS During RAP/RAS Stockpile Construction for Approving a High RAP/Any RAS Mix Design for Placement on the QPL

Test Frequency[1]	Test for	Test Method
• 1/1000 tons of RAP (minimum of 10 per mix design) and • 1/100 tons of RAS (minimum of 10 per mix design)	Asphalt Binder Content and Sieve Analysis of Fine and Coarse Aggregate	FOP for AASHTO T 308 and FOP for AASHTO T 30/T 11
• 1/500 tons of RAS (minimum of 3 per mix design)	Asbestos Containing Material (ACM)	See Section 9-03.21(1)A

[1]"tons", in this table, refers to tons of the reclaimed material before being incorporated into HMA.

4. Limit the amount of RAP and/or RAS used in a High RAP/Any RAS mix design by the amount of binder contributed by the RAP and/or RAS, in accordance with Table 4.

Table 4 Maximum Amount of RAP and/or RAS in HMA Mixture

Maximum Amount of Binder Contributed from:	
RAP	**RAS**
40%[1] minus contribution of binder from RAS	20%[2]

[1] Calculated as the weight of asphalt binder contributed from the RAP as a percentage of the total weight of asphalt binder in the mixture.

[2] Calculated as the weight of asphalt binder contributed from the RAS as a percentage of the total weight of asphalt binder in the mixture.

5. Develop the mix design including RAP, RAS, recycling agent, and new binder.
6. Extract, recover, and test the asphalt residue from the RAP and RAS stockpiles to determine the percent of recycling agent and/or grade of new asphalt binder needed to meet but not exceed the performance grade (PG) of asphalt binder required by the Contract.
   a. Perform the asphalt extraction in accordance with AASHTO T 164 or ASTM D 2172 using reagent grade solvent.
   b. Perform the asphalt recovery in accordance with AASHTO R 59 or ASTM D 1856.
   c. Test the recovered asphalt residue in accordance with AASHTO R 29 to determine the asphalt binder grade in accordance with Section 9-02.1(4).
   d. After determining the recovered asphalt binder grade, determine the percent of recycling agent and/or grade of new asphalt binder in accordance with ASTM D 4887.
   e. Test the final blend of recycling agent, binder recovered from the RAP and RAS, and new asphalt binder in accordance with AASHTO R 29. The final blended binder shall meet but not exceed the performance grade of asphalt binder required by the Contract and comply with the requirements of Section 9-02.1(4).
7. Include the following test data with the mix design submittal:
   a. All test data from RAP and RAS stockpile construction.
   b. All data from testing the recovered and blended asphalt binder.
8. Include representative samples of the following with the mix design submittal:
   a. RAP and RAS.
   b. 150 grams of recovered asphalt residue from the RAP and RAS that are to be used in the HMA production.

5-04.2(1)B Commercial HMA – Mix Design Submittal for Placement on QPL

For HMA used in the Bid item Commercial HMA, in addition to the requirements of Section 5-04.2(1) identify the following in the submittal:

1. Commercial HMA
2. Class of HMA
3. Performance grade of binder
4. Equivalent Single Axle Load (ESAL)

The Contracting Agency may elect to approve Commercial HMA mix designs without evaluation.

5-04.2(1)C Mix Design Resubmittal for QPL Approval

Develop a new mix design and resubmit for approval on the QPL when any of the following changes occur. When these occur, discontinue using the mix design until after it is reapproved on the QPL.

1. Change in the source of crude petroleum used in the asphalt binder.
2. Changes in the asphalt binder refining process.
3. Changes in modifiers used in the asphalt binder.
4. Changes in the anti-strip additive, brand, type or quantity.
5. Changes to the source of material for aggregate.
6. Changes to the job mix formula that exceed the amounts as described in item 2 of Section 9-03.8(7), unless otherwise approved by the Engineer.
7. Changes in the percentage of material from a stockpile, when such changes exceed 5 percent of the total aggregate weight.
    a. For Low RAP/No RAS mix designs developed without RAP, changes to the percentage of material from a stockpile will be calculated based on the total aggregate weight not including the weight of RAP.
    b. For Low RAP/No RAS mix designs developed with RAP, changes to the percentage of material from a stockpile will be calculated based on the total aggregate weight including the weight of RAP.
    c. For High RAP/Any RAS mix designs, changes in the percentage of material from a stockpile will be based on total aggregate weight including the weight of RAP (and/or RAS when included in the mixture).

Prior to making any change in the amount of RAS in an approved mix design, notify the Engineer for determination of whether a new mix design is required, and obtain the Engineer's approval prior to implementing such changes.

5-04.2(2) Mix Design – Obtaining Project Approval

Use only mix designs listed on the Qualified Products List (QPL). Submit WSDOT Form 350-041 to the Engineer to request approval to use a mix design from the QPL. Changes to the job mix formula (JMF) that have been approved on other contracts may be included. The Engineer may reject a request to use a mix design if production of HMA using that mix design on any contract is not in compliance with Section 5-04.3(11)D, E, F, and G for mixture or compaction.

5-04.2(2)A Changes to the Job Mix Formula

The approved mix design obtained from the QPL will be considered the starting job mix formula (JMF) and shall be used as the initial basis for acceptance of HMA mixture, as detailed in Section 5-04.3(9).

During production the Contractor may request to adjust the JMF. Any adjustments to the JMF will require approval of the Engineer and shall be made in accordance with item 2 of Section 9-03.8(7). After approval by the Engineer, such adjusted JMFs shall constitute the basis for acceptance of the HMA mixture.

5-04.2(2)B Using HMA Additives

The Contractor may, at the Contractor's discretion, elect to use additives that reduce the optimum mixing temperature or serve as a compaction aid for producing HMA. Additives include organic additives, chemical additives, and foaming processes. The use of Additives is subject to the following:

- Do not use additives that reduce the mixing temperature in accordance with Section 5-04.3(6) in the production of High RAP/Any RAS mixtures.
- Before using additives, obtain the Engineer's approval using WSDOT Form 350-076 to describe the proposed additive and process.

5-04.3 Construction Requirements

5-04.3(1) Weather Limitations

Do not place HMA for wearing course on any Traveled Way beginning October 1st through March 31st of the following year, without written concurrence from the Engineer.

Do not place HMA on any wet surface, or when the average surface temperatures are less than those specified in Table 5, or when weather conditions otherwise prevent the proper handling or finishing of the HMA.

Table 5 Minimum Surface Temperature for Paving

Compacted Thickness (Feet)	Wearing Course	Other Courses
Less than 0.10	55°F	45°F
0.10 to 0.20	45°F	35°F
More than 0.20	35°F	35°F

5-04.3(2) Paving Under Traffic

These requirements apply when the Roadway being paved is open to traffic.

In hot weather, the Engineer may require the application of water to the pavement to accelerate the finish rolling of the pavement and to shorten the time required before reopening to traffic.

During paving operations, maintain temporary pavement markings throughout the project. Install temporary pavement markings on the Roadway prior to opening to traffic. Temporary pavement markings shall comply with Section 8-23.

5-04.3(3) Equipment

5-04.3(3)A Mixing Plant

Equip mixing plants as follows:

1. **Use tanks for storage and preparation of asphalt binder which:**
   - Heat the contents by means that do not allow flame to contact the contents or the tank, such as by steam or electricity.
   - Heat and hold contents at the required temperatures.
   - Continuously circulate contents to provide uniform temperature and consistency during the operating period.
   - Provide an asphalt binder sampling valve, in either the storage tank or the supply line to the mixer.
2. **Provide thermometric equipment:**
   - In the asphalt binder feed line near the charging valve at the mixer unit, capable of detecting temperature ranges expected in the HMA and in a location convenient and safe for access by Inspectors.
   - At the discharge chute of the drier to automatically register or indicate the temperature of the heated aggregates, and situated in full view of the plant operator.
3. **When heating asphalt binder:**
   - Do not exceed the maximum temperature of the asphalt binder recommended by the asphalt binder supplier.
   - Avoid local variations in heating.
   - Provide a continuous supply of asphalt binder to the mixer at a uniform average temperature with no individual variations exceeding 25°F.
4. **Provide a mechanical sampler for sampling mineral materials that:**
   - Meets the crushing or screening requirements of Section 1-05.6.
5. **Provide HMA sampling equipment that complies with FOP for AASHTO T 168:**
   - Use a mechanical sampling device accepted by the Engineer, or
   - Platforms or devices to enable sampling from the truck transport without entering the truck transport for sampling HMA.

6. **Provide for setup and operation of the Contracting Agency's field testing:**
   - As required in Section 3-01.2(2).
7. **Provide screens or a lump breaker:**
   - When using any RAP or any RAS, to eliminate oversize RAP or RAS particles from entering the pug mill or drum mixer.
8. Hydrated Lime Marination Treatment:
   - Wet cure the coarse aggregates with lime at a minimum rate of 1.00% of the mass of the dry aggregate. Wet cure the fine aggregate with lime at a minimum rate of 2.00% of the mass of the dry aggregate. Marinate (wet cure) the aggregate in stockpiles for a minimum of 48 hours. Fine aggregate stockpiles shall be defined as to have a minimum of 50% passing the No. 4 sieve. All other stockpiles shall be defined as coarse aggregate. Marinate stockpiles individually. Do not use the marination treatment process to combine stockpiles. Use the wet cured aggregate in stockpiles within 60 days. Protect stockpiles from weather events such as, but not limited to; rain, wind, and other weather events that will compromise the activated lime coating.
   - Before the introduction of the lime, add sufficient moisture by way of spray bars at the aggregate bins to bring the aggregate moisture content where enough free surface moisture is available to thoroughly wet the aggregate and activate the lime.
   - After the addition of water and lime, mix aggregate using horizontal twin-shaft pugmill with a minimum effective length of five feet.
   - Use mixing paddles which are adjustable for angular position on the shaft to permit altering of the mixing pattern or retarding the flow to insure that the aggregate is thoroughly coated with lime.
   - Do not extend the volume of material in the pugmill above the vertical position of the blade tips. Retard the flow of material through the pugmill by reversing a minimum of the last two rows of paddles or providing a material dam.
   - Draw lime from a storage facility in which the lime is agitated by air or other means to keep it in a uniform free flowing condition. Deliver the lime to the mixer from a positive weighing device which is interlocked, (actuate electric driven feeders from the same circuit) to the flow of each aggregate feed. Equip the lime feeder to provide a continuous uniform flow to within 5% of the required amount.
   - Calibrate the lime feeder at two different speeds (the lowest and highest speed of the anticipated operation) in relation to the speed of the aggregate feed. Use a target 1% lime for low speed tons per hour and 2% lime for high speed tons per hour. Provide an approved calibrated scale or weigh metering device to determine the actual mass of lime for each test. Furnish a test box having a sufficient capacity to perform the calibration testing. Calibrate the lime feed so the masses show on the metering device are within ± 5% of the weighed mass.

5-04.3(3)B Hauling Equipment

Provide HMA hauling equipment with tight, clean, smooth metal beds and a cover of canvas or other suitable material of sufficient size to protect the HMA from adverse weather. Securely attach the cover to protect the HMA whenever the weather conditions during the work shift include, or are forecast to include, precipitation or an air temperature less than 45°F.

Prevent HMA from adhering to the hauling equipment. Spray metal beds with an environmentally benign release agent. Drain excess release agent prior to filling hauling equipment with HMA. Do not use petroleum derivatives or other coating material that contaminate or alter the characteristics of the HMA. For hopper trucks, operate the conveyer during the process of applying the release agent.

5-04.3(3)C Pavers

Use self-contained, power-propelled pavers provided with an internally heated vibratory screed that is capable of spreading and finishing courses of HMA in lane widths required by the paving section shown in the Plans.

When requested by the Engineer, provide written certification that the paver is equipped with the most current equipment available from the manufacturer for the prevention of segregation of the coarse aggregate particles. The certification shall list the make, model, and year of the paver and any equipment that has been retrofitted to the paver.

Operate the screed in accordance with the manufacturer's recommendations and in a manner to produce a finished surface of the required evenness and texture without tearing, shoving, segregating, or gouging the mixture. Provide a copy of the manufacturer's recommendations upon request by the Contracting Agency. Extensions to the screed will be allowed provided they produce the same results, including ride, density, and surface texture as obtained by the primary screed. In the Traveled Way do not use extensions without both augers and an internally heated vibratory screed.

Equip the paver with automatic screed controls and sensors for either or both sides of the paver. The controls shall be capable of sensing grade from an outside reference line, sensing the transverse slope of the screed, and providing automatic signals that operate the screed to maintain the desired grade and transverse slope. Construct the sensor so it will operate from a reference line or a mat referencing device. The transverse slope controller shall be capable of maintaining the screed at the desired slope within plus or minus 0.1 percent.

Equip the paver with automatic feeder controls, properly adjusted to maintain a uniform depth of material ahead of the screed.

Manual operation of the screed is permitted in the construction of irregularly shaped and minor areas. These areas include, but are not limited to, gore areas, road approaches, tapers and left-turn channelizations.

When specified in the Contract, provide reference lines for vertical control. Place reference lines on both outer edges of the Traveled Way of each Roadway. Horizontal

control utilizing the reference line is permitted. Automatically control the grade and slope of intermediate lanes by means of reference lines or a mat referencing device and a slope control device. When the finish of the grade prepared for paving is superior to the established tolerances and when, in the opinion of the Engineer, further improvement to the line, grade, cross-section, and smoothness can best be achieved without the use of the reference line, a mat referencing device may be substituted for the reference line. Substitution of the device will be subject to the continued approval of the Engineer. A joint matcher may be used subject to the approval of the Engineer. The reference line may be removed after completion of the first course of HMA when approved by the Engineer. Whenever the Engineer determines that any of these methods are failing to provide the necessary vertical control, the reference lines will be reinstalled by the Contractor.

Furnish and install all pins, brackets, tensioning devices, wire, and accessories necessary for satisfactory operation of the automatic control equipment.

If the paving machine in use is not providing the required finish, the Engineer may suspend Work as allowed by Section 1-08.6.

5-04.3(3)D Material Transfer Device or Material Transfer Vehicle

Use a material transfer device (MTD) or material transfer vehicle (MTV) to deliver the HMA from the hauling equipment to the paving machine for any lift in (or partially in) the top 0.30 feet of the pavement section used in traffic lanes. However, an MTD/V is not required for HMA placed in irregularly shaped and minor areas such as tapers and turn lanes, or for HMA mixture that is accepted by Visual Evaluation. At the Contractor's request the Engineer may approve paving without an MTD/V; the Engineer will determine if an equitable adjustment in cost or time is due. If a windrow elevator is used, the Engineer may limit the length of the windrow in urban areas or through intersections.

To be approved for use, an MTV:

1. Shall be self-propelled vehicle, separate from the hauling vehicle or paver.
2. Shall not be connected to the hauling vehicle or paver.
3. May accept HMA directly from the haul vehicle or pick up HMA from a windrow.
4. Shall mix the HMA after delivery by the hauling equipment and prior to placement into the paving machine.
5. Shall mix the HMA sufficiently to obtain a uniform temperature throughout the mixture.

To be approved for use, an MTD:

1. Shall be positively connected to the paver.
2. May accept HMA directly from the haul vehicle or pick up HMA from a windrow.
3. Shall mix the HMA after delivery by the hauling equipment and prior to placement into the paving machine.
4. Shall mix the HMA sufficiently to obtain a uniform temperature throughout the mixture.

5-04.3(3)E Rollers

Operate rollers in accordance with the manufacturer's recommendations. When requested by the Engineer, provide a Type 1 Working Drawing of the manufacturer's recommendation for the use of any roller planned for use on the project. Do not use rollers that crush aggregate, produce pickup or washboard, unevenly compact the surface, displace the mix, or produce other undesirable results.

5-04.3(4) Preparation of Existing Paved Surfaces

Before constructing HMA on an existing paved surface, the entire surface of the pavement shall be clean. Entirely remove all fatty asphalt patches, grease drippings, and other deleterious substances from the existing pavement to the satisfaction of the Engineer. Thoroughly clean all pavements or bituminous surfaces of dust, soil, pavement grindings, and other foreign matter. Thoroughly remove any cleaning or solvent type liquids used to clean equipment spilled on the pavement before paving proceeds. Fill all holes and small depressions with an appropriate class of HMA. Level and thoroughly compact the surface of the patched area.

Apply a uniform coat of asphalt (tack coat) to all paved surfaces on which any course of HMA is to be placed or abutted. Apply tack coat to cover the cleaned existing pavement with a thin film of residual asphalt free of streaks and bare spots. Apply a heavy application of tack coat to all joints. For Roadways open to traffic, limit the application of tack coat to surfaces that will be paved during the same working shift. Equip the spreading equipment with a thermometer to indicate the temperature of the tack coat material.

Do not operate equipment on tacked surfaces until the tack has broken and cured. Repair tack coat damaged by the Contractor's operation, prior to placement of the HMA.

Unless otherwise allowed by the Engineer, use cationic emulsified asphalt CSS-1, CSS-1h, or Performance Graded (PG) asphalt for tack coat. The CSS-1 and CSS-1h may be diluted with water at a rate not to exceed one part water to one part emulsified asphalt. Do not allow the tack coat material to exceed the maximum temperature recommended by the asphalt supplier.

When shown in the Plans, prelevel uneven or broken surfaces over which HMA is to be placed by using an asphalt paver, a motor patrol grader, or by hand raking, as approved by the Engineer.

5-04.3(4)A Crack Sealing

Crack sealing shall be in accordance with Section 5-03.

5-04.3(4)B Soil Residual Herbicide

Where shown in the Plans, apply one application of an approved soil residual herbicide. Comply with Section 8-02.3(3)B. Complete paving within 48 hours of applying the herbicide.

Use herbicide registered with the Washington State Department of Agriculture for use under pavement. Before use, obtain the Engineer's approval of the herbicide and the proposed rate of application. Include the following information in the request for approval of the material:

1. Brand Name of the Material,
2. Manufacturer,
3. Environmental Protection Agency (EPA) Registration Number,
4. Material Safety Data Sheet, and
5. Proposed Rate of Application.

5-04.3(4)C Pavement Repair

Excavate pavement repair areas and backfill these with HMA in accordance with the details shown in the Plans and as staked. Conduct the excavation operations in a manner that will protect the pavement that is to remain. Repair pavement not designated to be removed that is damaged as a result of the Contractor's operations to the satisfaction of the Engineer at no cost to the Contracting Agency. Excavate only within one lane at a time unless approved otherwise by the Engineer. Do not excavate more area than can be completely backfilled and compacted during the same shift.

Unless otherwise shown in the Plans or determined by the Engineer, excavate to a depth of 1.0 feet. The Engineer will make the final determination of the excavation depth required.

The minimum width of any pavement repair area shall be 40 inches unless shown otherwise in the Plans. Before any excavation, sawcut the perimeter of the pavement area to be removed unless the pavement in the pavement repair area is to be removed by a pavement grinder.

Excavated materials shall be the property of the Contractor and shall be disposed of in a Contractor-provided site off the Right of Way or used in accordance with Sections 2-02.3(3) or 9-03.21.

Apply a heavy application of tack coat to all surfaces of existing pavement in the pavement repair area, in accordance with Section 5-04.3(4).

Place the HMA backfill in lifts not to exceed 0.35-foot compacted depth. Thoroughly compact each lift by a mechanical tamper or a roller.

5-04.3(5) Producing/Stockpiling Aggregates, RAP, & RAS

Produce aggregate in compliance with Section 3-01. Comply with Section 3-02 for preparing stockpile sites, stockpiling, and removing from stockpile each of the following: aggregates, RAP, and RAS. Provide sufficient storage space for each size of aggregate, RAP and RAS. Fine aggregate or RAP may be uniformly blended with the RAS as a method of preventing the agglomeration of RAS particles. Remove the aggregates, RAP and RAS from stockpile(s) in a manner that ensures minimal segregation when being moved to the HMA plant for processing into the final mixture. Keep different aggregate sizes separated until they have been delivered to the HMA plant.

When hydrated lime is required by use of the marination treatment, the aggregates shall be stockpiled in accordance with Section 5-04.3(3)A.

5-04.3(5)A Stockpiling RAP or RAS for High RAP/Any RAS Mixes

Do not place any RAP or RAS into a stockpile which has been sequestered for a High RAP/Any RAS mix design. Do not incorporate any RAP or RAS into a High RAP/Any RAS mixture from any source other than the stockpile which was sequestered for approval of that particular High RAP/Any RAS mix design.

RAP that is used in a Low RAP/No RAS mix is not required to come from a sequestered stockpile.

5-04.3(6) Mixing

The asphalt supplier shall introduce recycling agent and anti-stripping additive, in the amount designated on the QPL for the mix design, into the asphalt binder prior to shipment to the asphalt mixing plant.

Anti-strip is not required for temporary work that will be removed prior to Physical Completion.

Use asphalt binder of the grade, and from the supplier, in the approved mix design.

Prior to introducing reclaimed materials into the asphalt plant, remove wire, nails, and other foreign material. Discontinue use of the reclaimed material if the Engineer, in their sole discretion, determines the wire, nails, or other foreign material to be excessive.

Size RAP and RAS prior to entering the mixer to provide uniform and thoroughly mixed HMA. If there is evidence of the RAP or RAS not breaking down during the heating and mixing of the HMA, immediately suspend the use of the RAP or RAS until changes have been approved by the Engineer.

After the required amount of mineral materials, RAP, RAS, new asphalt binder and recycling agent have been introduced into the mixer, mix the HMA until complete and uniform coating of the particles and thorough distribution of the asphalt binder throughout the mineral materials, RAP and RAS is ensured.

Upon discharge from the mixer, ensure that the temperature of the HMA does not exceed the optimum mixing temperature shown on the accepted Mix Design Report by more

than 25°F, or as allowed by the Engineer. When an additive is included in the manufacture of HMA, do not heat the additive (at any stage of production including in binder storage tanks) to a temperature higher than the maximum recommended by the manufacturer of the additive.

A maximum water content of 2 percent in the mix, at discharge, will be allowed providing the water causes no problems with handling, stripping, or flushing. If the water in the HMA causes any of these problems, reduce the moisture content.

During the daily operation, HMA may be temporarily held in approved storage facilities. Do not incorporate HMA into the Work that has been held for more than 24 hours after mixing. Provide an easily readable, low bin-level indicator on the storage facility that indicates the amount of material in storage. Waste the HMA in storage when the top level of HMA drops below the top of the cone of the storage facility, except as the storage facility is being emptied at the end of the working shift. Dispose of rejected or waste HMA at no expense to the Contracting Agency.

5-04.3(7) Spreading and Finishing

Do not exceed the maximum nominal compacted depth of any layer in any course, as shown in Table 6, unless approved by the Engineer:

Table 6 Maximum Nominal Compacted Depth of Any Layer

HMA Class	Wearing Course	Other than Wearing Course
1 inch	0.35 feet	0.35 feet
¾ and ½ inch	0.30 feet	0.35 feet
⅜ inch	0.25 feet	0.30 feet

Use HMA pavers complying with Section 5-04.3(3) to distribute the mix. On areas where irregularities or unavoidable obstacles make the use of mechanical spreading and finishing equipment impractical, the paving may be done with other equipment or by hand.

When more than one JMF is being utilized to produce HMA, place the material produced for each JMF with separate spreading and compacting equipment. Do not intermingle HMA produced from more than one JMF. Each strip of HMA placed during a work shift shall conform to a single JMF established for the class of HMA specified unless there is a need to make an adjustment in the JMF.

5-04.3(8) Aggregate Acceptance Prior to Incorporation in HMA

Sample aggregate for meeting the requirements of Section 3-04 prior to being incorporated into HMA. (The acceptance data generated for the Section 3-04 acceptance analysis will not be commingled with the acceptance data generated for the Section 5-04.3(9) acceptance analysis.) Aggregate acceptance samples shall be taken as described in Section 3-04. Aggregate acceptance testing will be performed by the Contracting Agency. Aggregate contributed from RAP and/or RAS will not be evaluated under Section 3-04.

The Contracting Agency's combined aggregate bulk specific gravity (Gsb) blend as shown on the HMA Mix Design will be used for VMA calculations until the Contractor submits a written request for a Gsb test. The new Gsb will be used in the VMA calculations for HMA from the date the Project Engineer receives the written request for a Gsb retest. The Contractor may request aggregate specific gravity (Gsb) testing be performed by the Contracting Agency twice per project. The Gsb blend of the combined stockpiles will be used to calculate voids in mineral aggregate (VMA) of any HMA produced after the new Gsb is determined.

For aggregate that will be used in HMA mixture which will be accepted by Statistical Evaluation, the Contracting Agency's acceptance of the aggregate will be based on:

1. Samples taken prior to mixing with asphalt binder, RAP, or RAS;
2. Testing for the materials properties of fracture, uncompacted void content, and sand equivalent;
3. Evaluation by the Contracting Agency in accordance with Section 3-04, including price adjustments as described therein.

For aggregate that will be used in HMA which will be accepted by Visual Evaluation, evaluation in accordance with items 1, 2, and 3 above is at the discretion of the Engineer.

5-04.3(9) HMA Mixture Acceptance

The Contracting Agency will evaluate HMA mixture for acceptance by one of two methods as determined from the criteria in Table 7.

Table 7 Basis of Acceptance for HMA Mixture

	Visual Evaluation	Statistical Evaluation
Criteria for Selecting the Evaluation Method	• HMA and Commercial HMA placed in the following locations: – sidewalks – road approaches – ditches – slopes – paths – trails – gores – prelevel – temporary pavement[1] – pavement repair	• All HMA mixture other than that accepted by Visual Evaluation

[1] Temporary pavement is HMA that will be removed before Physical Completion of the Contract.

5-04.3(9)A Test Sections

This section applies to HMA mixture accepted by Statistical Evaluation. A test section is not allowed for HMA accepted by Visual Evaluation.

The purpose of a test section is to determine whether or not the Contractor's mix design and production processes will produce HMA meeting the Contract requirements related to mixture. Construct HMA mixture test sections at the beginning of paving, using at least 600 tons and a maximum of 1,000 tons or as specified by the Engineer. Each test section shall be constructed in one continuous operation.

5-04.3(9)A1 Test Section – When Required, When to Stop

Use Tables 8 and 9 to determine when a test section is required, optional, or not allowed, and to determine when performing test sections may end. Each mix design will be evaluated independently for the test section requirements.

If more than one test section is required, each test section shall be evaluated separately by the criteria in Tables 8 and 9.

Table 8 Criteria for Conducting and Evaluating HMA Mixture Test Sections (For HMA Mixture Accepted by Statistical Evaluation)

	High RAP/Any RAS	Low RAP/No RAS
Is Mixture Test Section Optional or Mandatory?	Mandatory[1]	At Contractor's Option
Waiting period after paving the test section.	4 calendar days[2]	4 calendar days[2]
What Must Happen to Stop Performing Test Sections?	Meet "Results Required to Stop Performing Test Sections" in Table 9 for High RAP/Any RAS.	Provide samples and respond to WSDOT test results required by Table 9 for Low RAP/No RAS.

[1] If a mix design has produced an acceptable test section on a previous contract (paved in the same calendar year, from the same plant, using the same JMF) the test section may be waived if approved by the Engineer.

[2] This is to provide time needed by the Contracting Agency to complete testing and the Contractor to adjust the mixture in response to those test results. Paving may resume when this is done.

Table 9 Results Required to Stop Performing HMA Mixture Test Sections[1] (For HMA Mixture Accepted by Statistical Evaluation)

Test Property	Type of HMA	
	High RAP/Any RAS	Low RAP/No RAS
Gradation	Minimum PF_i of 0.95 based on the criteria in Section 5-04.3(9)B4[2]	None[4]
Asphalt Binder	Minimum PF_i of 0.95 based on the criteria in Section 5-04.3(9)B4[2]	None[4]
VMA	Minimum PF_i of 0.95 based on the criteria in Section 5-04.3(9)B4[2]	None[4]
V_a	Minimum PF_i of 0.95 based on the criteria in Section 5-04.3(9)B4[2]	None[4]
Hamburg Wheel Track Indirect Tensile Strength	Meet requirements of Section 9-03.8(2)[2]	These tests will not be done as part of Test Section.
Aggregates Sand Equivalent Uncompacted Void Content Fracture	Nonstatistical Evaluation in accordance with the requirements of Section 3-04[3]	None[3]

[1] In addition to the requirements of this table, acceptance of the HMA mixture used in each test section is subject to the acceptance criteria and price adjustments for Statistical Evaluation (see Table 9a in Section 5-04.3(9)A2).

[2] Divide the test section lot into three sublots, approximately equal in size. Take one sample from each sublot, and test each sample for the properties in the first column.

[3] Take one sample for each test section lot. Test the sample for the property in the first column.

[4] Divide the test section lot into three sublots, approximately equal in size. Take one sample from each sublot, and test each sample for the property in the first column. There are no criteria for discontinuing test sections for these mixes; however, the contractor must comply with Section 5-04.3(11)F before resuming paving.

5-04.3(9)A2 Test Section – Evaluating the HMA Mixture in a Test Section

The Engineer will evaluate the HMA mixture in each test section for rejection, acceptance, and price adjustments based on the criteria in Table 9a using the data generated from the testing required by Table 9 in Section 5-04.3(9)A1. Each test section shall be considered a separate lot.

Table 9a Acceptance Criteria for HMA Mixture Placed in a Test Section (For HMA Mixture Accepted by Statistical Evaluation)

Test Property	Type of HMA	
	High RAP/Any RAS	Low RAP/No RAS
Gradation, Asphalt Binder, VMA and V_a	Statistical Evaluation	Statistical Evaluation
Hamburg Wheel Track Indirect Tensile Strength	Pass/Fail for the requirements of Section 9-03.8(2)[1]	N/A
Aggregates Sand Equivalent Uncompacted Void Content Fracture	Nonstatistical Evaluation in accordance with the requirements of Section 3-04	Nonstatistical Evaluation in accordance with the requirements of Section 3-04

[1]Failure to meet the specifications for Hamburg and/or IDT will cause the mixture in the test section to be rejected.
Refer to Section 5-04.3(11).

5-04.3(9)B Mixture Acceptance – Statistical Evaluation

5-04.3(9)B1 Mixture Statistical Evaluation – Lots and Sublots

HMA mixture which is accepted by Statistical Evaluation will be evaluated by the Contracting Agency dividing that HMA tonnage into mixture lots, and each mixture lot will be evaluated using stratified random sampling by the Contracting Agency sub-dividing each mixture lot into mixture sublots. All mixture in a mixture lot shall be of the same mix design. The mixture sublots will be numbered in the order in which the mixture (of a particular mix design) is paved.

Each mixture lot comprises a maximum of 15 mixture sublots, except:

- The final mixture lot of each mix design on the Contract will comprise a maximum of 25 sublots.
- A mixture lot for a test section will consist of three sublots.

Each mixture sublot shall be approximately uniform in size with the maximum mixture sublot size as specified in Table 10. The quantity of material represented by the final mixture sublot of the project, for each mix design on the project, may be increased to a maximum of two times the mixture sublot quantity calculated.

Table 10 Maximum HMA Mixture Sublot Size For HMA Accepted by Statistical Evaluation

HMA Original Plan Quantity (tons)[1]	Maximum Sublot Size (tons)[2]
< 20,000	1,000
20,000 to 30,000	1,500
>30,000	2,000

[1]"Plan quantity" means the plan quantity of all HMA of the same class and binder grade which is accepted by Statistical Evaluation.

[2]The maximum sublot size for each combination of HMA class and binder grade shall be calculated separately.

- For a mixture lot in progress with a mixture CPF less than 0.75, a new mixture lot will begin at the Contractor's request after the Engineer is satisfied that material conforming to the Specifications can be produced. See also Section 5-04.3(11)F.
- If, before completing a mixture lot, the Contractor requests a change to the JMF which is approved by the Engineer, the mixture produced in that lot after the approved change will be evaluated on the basis of the changed JMF, and the mixture produced in that lot before the approved change will be evaluated on the basis of the unchanged JMF; however, the mixture before and after the change will be evaluated in the same lot. Acceptance of subsequent mixture lots will be evaluated on the basis of the changed JMF.

5-04.3(9)B2 Mixture Statistical Evaluation – Sampling

Comply with Section 1-06.2(1).

Samples of HMA mixture which is accepted by Statistical Evaluation will be randomly selected from within each sublot, with one sample per sublot. The Engineer will determine the random sample location using WSDOT Test Method T 716. The Contractor shall obtain the sample when ordered by the Engineer. The Contractor shall sample the HMA mixture in the presence of the Engineer and in accordance with FOP for AASHTO 168.

5-04.3(9)B3 Mixture Statistical Evaluation – Acceptance Testing

Comply with Section 1-06.2(1).

The Contracting Agency will test the mixture sample from each sublot (including sublots in a test section) for the properties shown in Table 11.

Table 11 Testing Required for each HMA Mixture Sublot

Test	Procedure	Performed by
VMA and V_a	WSDOT SOP 731	Engineer
Asphalt Binder Content	FOP for AASHTO T 308	Engineer
Gradation: percent Passing 1½″, 1″, ¾″, ½″, ⅜″, No. 4, No. 8, No. 200	FOP for AASHTO T 30/T 11	Engineer

The mixture samples and tests taken for the purpose of determining acceptance of the test section (as described in Section 5-04.3(9)A) shall also be used as the test results for acceptance of the mixture described in Sections 5-04.3(9)B3, 5-04.3(9)B4, 5-04.3(9)B5, and 5-04.3(9)B6.

5-04.3(9)B4 Mixture Statistical Evaluation – Pay Factors

Comply with Section 1-06.2(2).

The Contracting Agency will determine a pay factor (PF_i) for each of the properties in Table 11 of Section 5-04.3(9)B3, for each mixture lot, using the quality level analysis in Section 1-06.2(2)D. For Gradation, a pay factor will be calculated for each of the sieve sizes listed in Table 11 of Section 5-04.3(9)B3, which is equal to or smaller than the maximum allowable aggregate size (100 percent passing sieve) of the HMA mixture. The USL and LSL shall be calculated using the Job Mix Formula Tolerances (for Statistical Evaluation) in Section 9-03.8(7).

If a constituent is not measured in accordance with these Specifications, its individual pay factor will be considered 1.00 in calculating the Composite Pay Factor (CPF).

5-04.3(9)B5 Mixture Statistical Evaluation – Composite Pay Factors (CPF)

Comply with Section 1-06.2(2).

In accordance with Section 1-06.2(2)D4, the Contracting Agency will determine a Composite Pay Factor (CPF) for each mixture lot from the pay factors calculated in Section 5-04.3(9)B4, using the price adjustment factors in Table 12. Unless otherwise specified, the maximum CPF for HMA mixture shall be 1.05.

Table 12 HMA Mixture Price Adjustment Factors

Constituent	Factor "f"
All aggregate passing: 1½″, 1″, ¾″, ½″, ⅜″ and No.4 sieves	2
All aggregate passing No. 8 sieve	15
All aggregate passing No. 200 sieve	20
Asphalt binder	40
Voids in Mineral Aggregate (VMA)	10
Air Voids (V_a)	20

5-04.3(9)B6 Mixture Statistical Evaluation – Price Adjustments

For each HMA mixture lot, a Job Mix Compliance Price Adjustment will be determined and applied, as follows:

$$JMCPA = [0.60 \times (CPF - 1.00)] \times Q \times UP$$

Where

JMCPA = Job Mix Compliance Price Adjustment for a given lot of mixture ($)
CPF = Composite Pay Factor for a given lot of mixture (maximum is 1.05)
Q = Quantity in a given lot of mixture (tons)
UP = Unit price of the HMA in a given lot of mixture ($/ton)

5-04.3(9)B7 Mixture Statistical Evaluation – Retests

The Contractor may request that a mixture sublot be retested. To request a retest, submit a written request to the Contracting Agency within 7 calendar days after the specific test results have been posted to the website or emailed to the Contractor, whichever occurs first. The Contracting Agency will send a split of the original acceptance sample for testing by the Contracting Agency to either the Region Materials Laboratory or the State Materials Laboratory as determined by the Engineer. The Contracting Agency will not test the split of the sample with the same equipment or by the same tester that ran the original acceptance test. The sample will be tested for a complete gradation analysis, asphalt binder content, VMA and V_a, and the results of the retest will be used for the acceptance of the HMA mixture in place of the original mixture sublot sample test results. The cost of testing will be deducted from any monies due or that may come due the Contractor under the Contract at the rate of $250 per sample.

5-04.3(9)C Vacant

5-04.3(9)D Mixture Acceptance – Visual Evaluation

Visual Evaluation of HMA mixture will be by visual inspection by the Engineer or, in the sole discretion of the Engineer, the Engineer may sample and test the mixture.

5-04.3(9)D1 Mixture Visual Evaluation – Lots, Sampling, Testing, Price Adjustments

HMA mixture accepted by Visual Evaluation will not be broken into lots unless the Engineer determines that testing is required. When that occurs, the Engineer will identify the limits of the questionable HMA mixture, and that questionable HMA mixture shall constitute a lot. Then, the Contractor will take samples from the truck, or the Engineer will take core samples from the roadway at a minimum of three random locations from within the lot, selected in accordance with WSDOT Test Method T 716, taken from the roadway in accordance with WSDOT SOP 734, and tested in accordance with WSDOT SOP 737. The Engineer will test one of the samples for all constituents in Section 5-04.3(9)B3. If all constituents from that test fall within the Job Mix Formula Tolerances (for Visual Evaluation) in Section 9-03.8(7), the lot will be accepted at the unit Contract price with no further evaluation.

When one or more constituents fall outside those tolerance limits, the other samples will be tested for all constituents in Section 5-04.3(9)B3, and a Job Mix Compliance Price Adjustment will be calculated in accordance with Table 13.

Table 13 Visual Evaluation – Out of Tolerance Procedures

Comply with the Following[1]	
Pay Factors[1]	Section 5-04.3(9)B4
Composite Pay Factors[2]	Section 5-04.3(9)B5
Price Adjustments	Section 5-04.3(9)B6

[1]The Visual Evaluation tolerance limits in Section 9-03.8(7) will be used in the calculation of the PF_i.

[2]The maximum CPF shall be 1.00.

5-04.3(9)E Mixture Acceptance – Notification of Acceptance Test Results

The results of all mixture acceptance testing and the Composite Pay Factor (CPF) of the lot after three sublots have been tested will be available to the Contractor through the Contracting Agency's website.

The Contracting Agency will endeavor to provide written notification (via email to the Contractor's designee) of acceptance test results through its web-based materials testing system Statistical Analysis of Materials (SAM) within 24 hours of the sample being made available to the Contracting Agency. However, the Contractor agrees:

1. Quality control, defined as the system used by the Contractor to monitor, assess, and adjust its production processes to ensure that the final HMA mixture will meet the specified level of quality, is the sole responsibility of the Contractor.
2. The Contractor has no right to rely on any testing performed by the Contracting Agency, nor does the Contractor have any right to rely on timely notification by the Contracting Agency of the Contracting Agency's test results (or statistical analysis thereof), for any part of quality control and/or for making changes or correction to any aspect of the HMA mixture.
3. The Contractor shall make no claim for untimely notification by the Contracting Agency of the Contracting Agency's test results or statistical analysis.

5-04.3(10) HMA Compaction Acceptance

For all HMA, the Contractor shall comply with the General Compaction Requirements in Section 5-04.3(10)A. The Contracting Agency will evaluate all HMA for compaction compliance with one of the following - Statistical Evaluation, Visual Evaluation, or Test Point Evaluation - determined by the criteria in Table 14:

Table 14 Criteria for Determining Method of Evaluation for HMA Compaction[1]

Statistical Evaluation of HMA Compaction is Required For:	Visual Evaluation of HMA Compaction is Required For:	Test Point Evaluation of HMA Compaction is Required For:
• Any HMA for which the specified course thickness is greater than 0.10 feet, and the HMA is in: – traffic lanes, including but not limited to: • ramp lanes • truck climbing lanes • weaving lanes • speed change lanes	• "HMA for Preleveling..." • "HMA for Pavement Repair..."	• Any HMA not meeting the criteria for Statistical Evaluation or Visual Evaluation

[1] This table applies to all HMA, and shall be the sole basis for determining the acceptance method for compaction.

The Contracting Agency may, at its sole discretion, evaluate any HMA for compliance with the Cyclic Density requirements of Section 5-04.3(10)B.

5-04.3(10)A HMA Compaction – General Compaction Requirements

Immediately after the HMA has been spread and struck off, and after surface irregularities have been adjusted, thoroughly and uniformly compact the mix. The completed course shall be free from ridges, ruts, humps, depressions, objectionable marks, and irregularities and shall conform to the line, grade, and cross-section shown in the Plans. If necessary, alter the JMF in accordance with Section 9-03.8(7) to achieve desired results.

Compact the mix when it is in the proper condition so that no undue displacement, cracking, or shoving occurs. Compact areas inaccessible to large compaction equipment by mechanical or hand tampers. Remove HMA that becomes loose, broken, contaminated, shows an excess or deficiency of asphalt, or is in any way defective. Replace the removed material with new HMA, and compact it immediately to conform to the surrounding area.

The type of rollers to be used and their relative position in the compaction sequence shall generally be the Contractor's option, provided the specified densities are attained. An exception shall be that pneumatic tired rollers shall be used for compaction of the wearing course beginning October 1st of any year through March 31st of the following year. Coverage with a steel wheel roller may precede pneumatic tired rolling. Unless otherwise approved by the Engineer, operate rollers in the static mode when the internal temperature of the mix is less than 175°F. Regardless of mix temperature, do not operate a roller in a mode that results in checking or cracking of the mat.

On bridge decks and on roadway approaches within five feet of a bridge/back of pavement seat, rollers shall not be operated in a vibratory mode, defined as a mode in which the drum vibrates vertically. However, unless otherwise noted on the plans, rollers may be operated in an oscillatory mode, defined as a mode in which the drum vibrates in the horizontal direction only.

5-04.3(10)B HMA Compaction – Cyclic Density

Low cyclic density areas are defined as spots or streaks in the pavement that are less than 90 percent of the theoretical maximum density. At the Engineer's discretion, the Engineer may evaluate the HMA pavement for low cyclic density, and when doing so will follow WSDOT SOP 733. A $500 Cyclic Density Price Adjustment will be assessed for any 500-foot section with two or more density readings below 90 percent of the theoretical maximum density.

5-04.3(10)C HMA Compaction Acceptance – Statistical Evaluation

HMA compaction which is accepted by Statistical Evaluation will be based on acceptance testing performed by the Contracting Agency, and statistical analysis of those acceptance tests results. This will result in a Compaction Price Adjustment.

5-04.3(10)C1 HMA Compaction Statistical Evaluation – Lots and Sublots

HMA compaction which is accepted by Statistical Evaluation will be evaluated by the Contracting Agency dividing the project into compaction lots, and each compaction lot will be evaluated using stratified random sampling by the Contracting Agency sub-dividing each compaction lot into compaction sublots. All mixture in any individual compaction lot shall be of the same mix design. The compaction sublots will be numbered in the order in which the mixture (of a particular mix design) is paved.

Each compaction lot comprises a maximum of 15 compaction sublots, except for the final compaction lot of each mix design on the Contract, which comprises a maximum of 25 sublots.

Each compaction sublot shall be uniform in size as shown in Table 15, except that the last compaction sublot of each day may be increased to a maximum of two times the compaction sublot quantity calculated. Minor variations in the size of any sublot shall not be cause to invalidate the associated test result.

Table 15 HMA Compaction Sublot Size

HMA Original Plan Quantity (tons)[1]	Compaction Sublot Size (tons)
<20,000	100
20,000 to 30,000	150
>30,000	200

[1]In determining the plan quantity tonnage, do not include any tons accepted by test point evaluation.

The following will cause one compaction lot to end prematurely and a new compaction lot to begin:

- For a compaction lot in progress with a compaction CPF less than 0.75 using an LSL = 91.5, a new compaction lot will begin at the Contractor's request after the Engineer is satisfied that material conforming to the Specifications can be produced. See also Section 5-04.3(11)F.

All HMA which is paved on a bridge and accepted for compaction by Statistical Evaluation will compose a bridge compaction lot. If the contract includes such HMA on more than one bridge, compaction will be evaluated on each bridge individually, as separate bridge compaction lots.

Bridge compaction sublots will be determined by the Engineer subject to the following:

- All sublots on a given bridge will be approximately the same size.
- Sublots will be stratified from the lot.
- In no case will there be less than 3 sublots in each bridge compaction lot.
- No sublot will exceed 50 tons.
- Compaction test locations will be determined by the Engineer in accordance with WSDOT Test Method T 716.

5-04.3(10)C2 HMA Compaction Statistical Evaluation – Acceptance Testing

Comply with Section 1-06.2(1).

The location of HMA compaction acceptance tests will be randomly selected by the Contracting Agency from within each sublot, with one test per sublot. The Contracting Agency will determine the random sample location using WSDOT Test Method T 716.

Use Table 16 to determine compaction acceptance test procedures and to allocate compaction acceptance sampling and testing responsibilities between the Contractor and the Contracting Agency. HMA cores shall be taken or nuclear density testing shall occur after completion of the finish rolling, prior to opening to traffic, and on the same day that the mix is placed.

Table 16 HMA Compaction Acceptance Testing Procedures and Responsibilities

	When Contract Includes Bid Item "HMA Core – Roadway" or "HMA Core – Bridge"[4]	When Contract Does Not Include Bid Item "HMA Core – Roadway" or "HMA Core – Bridge"[4]	
Basis for Test:	Cores	Cores[3]	Nuclear Density Gauge[3]
In-Place Density Determined by:	Contractor shall take cores[1] using WSDOT SOP 734[2] ——— Contracting Agency will determine core density using FOP for AASHTO T 166	Contracting Agency will take cores[1] using WSDOT SOP 734 ——— Contracting Agency will determine core density using FOP for AASHTO T 166	Contracting Agency, using FOP for AASHTO T 355
Theoretical Maximum Density Determined by:	Contracting Agency, using FOP for AASHTO T 209		
Rolling Average of Theoretical Maximum Densities Determined by:	Contracting Agency, using WSDOT SOP 729		
Percent Compaction in Each Sublot Determined by:	Contracting Agency, using WSDOT SOP 736	Contracting Agency, using WSDOT SOP 736	Contracting Agency, using FOP for AASHTO T 355

[1] The core diameter shall be 4-inches unless otherwise approved by the Engineer.

[2] The Contractor shall take the core samples in the presence of the Engineer, at locations designated by the Engineer, and deliver the core samples to the Contracting Agency.

[3] The Contracting Agency will determine, in its sole discretion, whether it will take cores or use the nuclear density gauge to determine in-place density. Exclusive reliance on cores for density acceptance is generally intended for small paving projects and is not intended as a replacement for nuclear gauge density testing on typical projects.

[4] The basis for test of all compaction sublots in a bridge compaction lot shall be cores. These cores shall be taken by the Contractor when the Proposal includes the bid item "HMA Cores – Bridge". When there is no bid item for "HMA Cores – Bridge", the Engineer will be responsible for taking HMA cores for all compaction sublots in a bridge compaction lot. In either case, the Engineer will determine core location, in-place density of the core, theoretical maximum density, rolling average of theoretical maximum density, and percent compaction using the procedure called for in this section.

When using the nuclear density gauge for acceptance testing of pavement density, the Engineer will follow WSDOT SOP 730 for correlating the nuclear gauge with HMA cores. When cores are required for the correlation, coring and testing will be by the Contracting Agency. When a core is taken for gauge correlation at the location of a sublot, the relative density of the core will be used for the sublot test result and is exempt from retesting.

5-04.3(10)C3 HMA Statistical Compaction – Price Adjustments

For each HMA compaction lot (that is accepted by Statistical Evaluation) which has less than three compaction sublots, for which all compaction sublots attain a minimum of 92 percent compaction determined in accordance with FOP for AASHTO T 355 (or WSDOT SOP 736 when provided by the Contract), the HMA will be accepted at the unit Contract price with no further evaluation.

For each HMA compaction lot (that is accepted by Statistical Evaluation) which does not meet the criteria in the preceding paragraph, the compaction lot shall be evaluated in accordance with Section 1-06.2(2)D5 to determine the appropriate Composite Pay Factor (CPF). All of the test results obtained from the acceptance samples from a given compaction lot shall be evaluated collectively. Additional testing by either a nuclear density gauge or cores will be completed as required to provide a minimum of three tests for evaluation.

For the statistical analysis in Section 1-06.2, use the following values:

x = percent compaction for each sublot
USL = 100
LSL = 92

Determine the Compaction Price Adjustment (CPA) from the table below, selecting the equation for CPA that corresponds to the value of CPF determined above.

Calculating HMA Compaction Price Adjustment (CPA)

Value of CPF	Equation for Calculating CPA
When CPF > 1.00	CPA = [1.00 x (CPF – 1.00)] x Q x UP
When CPF = 1.00	CPA = $0
When CPF < 1.0	CPA = [0.40 x (CPF – 1.00)] x Q x UP

Where

CPA = Compaction Price Adjustment for the compaction lot ($)
CPF = Composite Pay Factor for the compaction lot (maximum is 1.05)
Q = Quantity in the compaction lot (tons)
UP = Unit price of the HMA in the compaction lot ($/ton)

5-04.3(10)C4 HMA Statistical Compaction – Requests for Retesting

For a compaction sublot that has been tested with a nuclear density gauge that did not meet the minimum of 92.0 percent of the theoretical maximum density in a compaction lot with a CPF below 1.00 and thus subject to a price reduction or rejection, the Contractor may request that a core, taken at the same location as the nuclear density test, be used for determination of the relative density of the compaction sublot. The relative density of the core will replace the relative density determined by the nuclear density gauge for the compaction sublot and will be used for calculation of the CPF and acceptance of HMA compaction lot. When cores are taken by the Contracting Agency at the request of the Contractor, they shall be requested by noon of the next workday after the test results for the compaction sublot have been provided or made available to

the Contractor. Traffic control shall be provided by the Contractor as requested by the Engineer. Failure by the Contractor to provide the requested traffic control will result in forfeiture of the request for retesting. When the CPF for the compaction lot based on the results of the cores is less than 1.00, the Contracting Agency will deduct the cost for the coring from any monies due or that may become due the Contractor under the Contract at the rate of $200 per core and the Contractor shall pay for the cost of the traffic control.

5-04.3(10)D HMA Compaction – Visual Evaluation

Visual Evaluation will be the basis of acceptance for compaction of the Bid items "HMA for Pavement Repair Cl. ___ PG ___" and "HMA for Prelevelling Class___ PG___". This HMA shall be thoroughly compacted to the satisfaction of the Engineer. HMA that is used to prelevel wheel ruts shall be compacted with a pneumatic tire roller.

5-04.3(10)E HMA Compaction – Test Point Evaluation

When compaction acceptance is by Test Point Evaluation, compact HMA based on a test point evaluation of the compaction train. Perform the test point evaluation in accordance with instructions from the Engineer. The number of passes with an approved compaction train, required to attain the maximum test point density, shall be used on all subsequent paving.

5-04.3(10)F HMA Compaction Acceptance – Notification of Acceptance Test Results

The obligations and responsibilities for notifying the Contractor of compaction acceptance test results are the same as for mixture acceptance test results. See Section 5-04.3(9)E.

5-04.3(11) Reject Work

This section applies to HMA and all requirements related to HMA (except aggregates prior to being incorporated into HMA). For rejection of aggregate prior to its incorporation into HMA refer to Section 3-04.

5-04.3(11)A Reject Work – General

Work that is defective or does not conform to Contract requirements shall be rejected. The Contractor may propose, in writing, alternatives to removal and replacement of rejected material. Acceptability of such alternative proposals will be determined at the sole discretion of the Engineer.

5-04.3(11)B Rejection by Contractor

The Contractor may, prior to acceptance sampling and testing, elect to remove any defective material and replace it with new material. Any such new material will be sampled, tested, and evaluated for acceptance.

5-04.3(11)C Rejection Without Testing (Mixture or Compaction)

The Engineer may, without sampling, reject any batch, load, or section of Roadway that appears defective. Material rejected before placement shall not be incorporated into the pavement.

No payment will be made for the rejected materials or the removal of the materials unless the Contractor requests the rejected material to be tested. If the Contractor requests testing, acceptance will be by Statistical Evaluation, and a minimum of three samples will be obtained and tested. When uncompacted material is required for testing but not available, the Engineer will determine random sample locations on the roadway in accordance with WSDOT Test Method T 716, take cores in accordance with WSDOT SOP 734, and test the cores in accordance with WSDOT SOP 737.

If the CPF for the rejected material is less than 0.75, no payment will be made for the rejected material; in addition, the cost of sampling and testing shall be borne by the Contractor. If the CPF is greater than or equal to 0.75, the cost of sampling and testing will be borne by the Contracting Agency. If the material is rejected before placement and the CPF is greater than or equal to 0.75, compensation for the rejected material will be at a CPF of 0.75. If rejection occurs after placement and the CPF is greater than or equal to 0.75, compensation for the rejected material will be at the calculated CPF with an addition of 25 percent of the unit Contract price added for the cost of removal and disposal.

5-04.3(11)D Rejection – A Partial Sublot (Mixture or Compaction)

In addition to the random acceptance sampling and testing, the Engineer may also isolate from a mixture or compaction sublot any material that is suspected of being defective in relative density, gradation or asphalt binder content. Such isolated material will not include an original sample location. The Contracting Agency will obtain a minimum of three random samples of the suspect material and perform the testing. When uncompacted material is required for testing but is not available, the Engineer will select random sample locations on the roadway in accordance with WSDOT Test Method T 716, take cores samples in accordance with WSDOT SOP 734, and test the material in accordance with WSDOT SOP 737. The material will then be statistically evaluated as an independent lot in accordance with Section 1-06.2(2).

5-04.3(11)E Rejection – An Entire Sublot (Mixture or Compaction)

An entire mixture or compaction sublot that is suspected of being defective may be rejected. When this occurs, a minimum of two additional random samples from this sublot will be obtained. When uncompacted material is required for the additional samples but the material has been compacted, the Contracting Agency will take and test cores from the roadway as described in Section 5-04.3(11)D. The additional samples and the original sublot will be evaluated as an independent lot in accordance with Section 1-06.2(2).

5-04.3(11)F Rejection - A Lot in Progress (Mixture or Compaction)

The Contractor shall shut down operations and shall not resume HMA placement until such time as the Engineer is satisfied that material conforming to the Specifications can be produced when:

1. the Composite Pay Factor (CPF) of a mixture or compaction lot in progress drops below 1.00 and the Contractor is taking no corrective action, or
2. the Pay Factor (PF_i) for any constituent of a mixture or compaction lot in progress drops below 0.95 and the Contractor is taking no corrective action, or
3. either the PF_i for any constituent (or the CPF) of a mixture or compaction lot in progress is less than 0.75.

5-04.3(11)G Rejection – An Entire Lot (Mixture or Compaction)

An entire lot with a CPF of less than 0.75 will be rejected.

5-04.3(12) Joints

5-04.3(12)A HMA Joints

5-04.3(12)A1 Transverse Joints

Conduct operations such that the placement of the top or wearing course is a continuous operation or as close to continuous as possible. Unscheduled transverse joints will be allowed, but the roller may pass over the unprotected end of the freshly laid HMA only when the placement of the course is discontinued for such a length of time that the HMA will cool below compaction temperature. When the Work is resumed, cut back the previously compacted HMA to produce a slightly beveled edge for the full thickness of the course.

Construct a temporary wedge of HMA on a 50H:1V where a transverse joint as a result of paving or planing is open to traffic. Separate the HMA in the temporary wedge from the permanent HMA upon which it is placed by strips of heavy wrapping paper or other methods approved by the Engineer. Remove the wrapping paper and trim the joint to a slightly beveled edge for the full thickness of the course prior to resumption of paving.

Waste the material that is cut away and place new HMA against the cut. Use rollers or tamping irons to seal the joint.

5-04.3(12)A2 Longitudinal Joints

Offset the longitudinal joint in any one course from the course immediately below by not more than 6 inches nor less than 2 inches. Locate all longitudinal joints constructed in the wearing course at a lane line or an edge line of the Traveled Way. Construct a notched wedge joint along all longitudinal joints in the wearing surface of new HMA unless otherwise approved by the Engineer. The notched wedge joint shall have a vertical edge of not less than the maximum aggregate size nor more than ½ of the compacted lift thickness, and then taper down on a slope not steeper than 4H:1V. Uniformly compact the sloped portion of the HMA notched wedge joint.

On one-lane ramps a longitudinal joint may be constructed at the center of the traffic lane, subject to approval by the Engineer, if:

1. The ramp must remain open to traffic, or
2. The ramp is closed to traffic and a hot-lap joint is constructed.
   a. Two paving machines shall be used to construct the hot-lap joint.
   b. The pavement within 6 inches of the hot-lap joint will not be excluded from random location selection for compaction testing.
   c. Construction equipment other than rollers shall not operate on any uncompacted HMA.

When HMA is placed adjacent to cement concrete pavement comply with Section 5-03.

5-04.3(12)B Bridge Paving Joint Seals

Bridge Paving Joint Seals shall be in accordance with Section 5-03.

5-04.3(13) Surface Smoothness

The completed surface of all courses shall be of uniform texture, smooth, uniform as to crown and grade, and free from defects of all kinds. The completed surface of the wearing course shall not vary more than ⅛ inch from the lower edge of a 10-foot straightedge placed on the surface parallel to the centerline. The transverse slope of the completed surface of the wearing course shall vary not more than ¼ inch in 10 feet from the rate of transverse slope shown in the Plans.

When deviations in excess of the above tolerances are found that result from a high place in the HMA, correct the pavement surface by one of the following methods:

1. Remove material from high places by grinding with an approved grinding machine, or
2. Remove and replace the wearing course of HMA, or
3. By other method approved by the Engineer.

Correct defects until there are no deviations anywhere greater than the allowable tolerances.

Deviations in excess of the above tolerances that result from a low place in the HMA and deviations resulting from a high place where corrective action, in the opinion of the Engineer, will not produce satisfactory results will be accepted with a price adjustment. The Engineer shall deduct from monies due or that may become due to the Contractor the sum of $500.00 for each and every section of single traffic lane 100 feet in length in which any excessive deviations described above are found.

When concrete pavement is to be placed on HMA, the surface tolerance of the HMA shall be such that no surface elevation lies above the Plan grade minus the specified Plan depth of concrete pavement. Prior to placing the concrete pavement, bring any such irregularities to the required tolerance by grinding or other means allowed by the Engineer.

When utility appurtenances such as manhole covers and valve boxes are located in the Traveled Way, pave the Roadway before the utility appurtenances are adjusted to the finished grade.

5-04.3(14) Planing Bituminous Pavement

Plane in such a manner that the underlying pavement is not torn, broken, or otherwise damaged by the planing operation. Delamination or raveling of the underlying pavement will not be construed as damage due to the Contractor's operations. Pavement outside the limits shown in the Plans or designated by the Engineer that is damaged by the Contractor's operations shall be repaired to the satisfaction of the Engineer at no additional cost to the Contracting Agency.

For mainline planing operations, use equipment with automatic controls and with sensors for either or both sides of the equipment. The controls shall be capable of sensing the grade from an outside reference line, or a mat-referencing device. The automatic controls shall have a transverse slope controller capable of maintaining the mandrel at the desired transverse slope (expressed as a percentage) within plus or minus 0.1 percent.

Remove all loose debris from the planed surface before opening the planed surface to traffic. The planings and other debris resulting from the planing operation shall become the property of the Contractor and be disposed of in accordance with Section 2-03.3(7)C, or as otherwise allowed by the Contract.

5-04.3(15) Sealing Pavement Surfaces

Apply a fog seal where shown in the Plans. Construct the fog seal in accordance with Section 5-02.3. Unless otherwise approved by the Engineer, apply the fog seal prior to opening to traffic.

5-04.3(16) HMA Road Approaches

Construct HMA approaches at the locations shown in the Plans or where staked by the Engineer, in accordance with Section 5-04.

5-04.4 Measurement

HMA Cl. ___ PG ___, HMA for ___ Cl. ___ PG ___, and Commercial HMA will be measured by the ton in accordance with Section 1-09.2, with no deduction being made for the weight of asphalt binder, mineral filler, or any other component of the HMA. If the Contractor elects to remove and replace HMA as allowed by Section 5-04.3(11), the material removed will not be measured.

Roadway cores will be measured per each for the number of cores taken.

Soil residual herbicide will be measured by the mile for the stated width to the nearest 0.01 mile or by the square yard, whichever is designated in the Proposal.

Pavement repair excavation will be measured by the square yard of surface marked prior to excavation.

Asphalt for fog seal will be measured by the ton, as provided in Section 5-02.4.

Planing bituminous pavement will be measured by the square yard.

Temporary pavement marking will be measured by the linear foot as provided in Section 8-23.4.

Water will be measured by the M gallon as provided in Section 2-07.4.

5-04.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"HMA Cl. ___ PG ___", per ton.

"HMA for Approach Cl. ___ PG ___", per ton.

"HMA for Preleveling Cl. ___ PG ___", per ton.

"HMA for Pavement Repair Cl. ___ PG ___", per ton.

"Commercial HMA", per ton.

The unit Contract price per ton for "HMA Cl. ___ PG ___", "HMA for Approach Cl. ___ PG ___", "HMA for Preleveling Cl. ___ PG ___", "HMA for Pavement Repair Cl. ___ PG ___", and "Commercial HMA" shall be full compensation for all costs, including anti-stripping additive, incurred to carry out the requirements of Section 5-04 except for those costs included in other items which are included in this Subsection and which are included in the Proposal.

"Soil Residual Herbicide ____ ft. Wide", per mile, or

"Soil Residual Herbicide", per square yard.

The unit Contract price per mile or per square yard for "Soil Residual Herbicide" shall be full payment for all costs incurred to obtain, provide and install herbicide in accordance with Section 5-04.3(4)B.

"Pavement Repair Excavation Incl. Haul", per square yard.

The unit Contract price per square yard for "Pavement Repair Excavation Incl. Haul" shall be full payment for all costs incurred to perform the Work described in Section 5-04.3(4)C with the exception, however, that all costs involved in the placement of HMA shall be included in the unit Contract price per ton for "HMA for Pavement Repair Cl. ___ PG ___", per ton.

"Asphalt for Fog Seal", per ton.

Payment for "Asphalt for Fog Seal" is described in Section 5-02.5.

"Planing Bituminous Pavement", per square yard.

The unit Contract price per square yard for "Planing Bituminous Pavement" shall be full payment for all costs incurred to perform the Work described in Section 5-04.3(14).

"Temporary Pavement Marking", per linear foot.

Payment for "Temporary Pavement Marking" is described in Section 8-23.5.

"Water", per M gallon.

Payment for "Water" is described in Section 2-07.5.

"Job Mix Compliance Price Adjustment", by calculation.

"Job Mix Compliance Price Adjustment" will be calculated and paid for as described in Section 5-04.3(9)B6 and 5-04.3(9)D1.

"Compaction Price Adjustment", by calculation.

"Compaction Price Adjustment" will be calculated and paid for as described in Section 5-04.3(10)C3.

"HMA Core – Bridge", per each.

The unit Contract price per each for "HMA Core – Bridge" shall be full payment for all costs, including traffic control, associated with taking HMA density cores in pavement that is on a bridge deck.

"HMA Core – Roadway", per each.

The unit Contract price per each for "HMA Core – Roadway" shall be full payment for all costs, including traffic control, associated with taking HMA density cores in pavement that is not on a bridge deck.

"Cyclic Density Price Adjustment", by calculation.

"Cyclic Density Price Adjustment" will be calculated and paid for as described in Section 5-04.3(10)B.

5-05 Cement Concrete Pavement

5-05.1 Description

This Work shall consist of constructing a pavement composed of cement concrete on a prepared Subgrade or base in accordance with these Specifications and in conformity with the lines, grades, thicknesses, and typical cross-sections shown in the Plans or established by the Engineer.

5-05.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Fine Aggregate	9-03
Coarse Aggregate	9-03
Combined Aggregate	9-03
Joint Filler	9-04.1
Joint Sealants	9-04.2
Corrosion Resistant Dowel Bars	9-07.5(2)
Tie Bars	9-07.6
Concrete Patching Material	9-20.1
Curing Materials and Admixtures	9-23
Water	9-25
Epoxy Resins	9-26

Cementitious materials are considered to be the following: portland cement, blended hydraulic cement, fly ash, ground granulated blast furnace slag, and microsilica fume.

5-05.3 Construction Requirements

5-05.3(1) Concrete Mix Design for Paving

The Contractor shall provide a concrete mix design for each design of concrete specified in the Contract. The Contractor shall use ACI 211.1 as a guide to determine proportions. Concrete strength, placement, and workability shall be the responsibility of the Contractor. Following approval of the Contractor's proposal, all other requirements of Section 5-05 shall apply.

1. **Materials** – Materials shall conform to Section 5-05.2. Fine aggregate shall conform to Section 9-03.1(2), Class 1. Coarse aggregate shall conform to Section 9-03.1(4), AASHTO grading No. 467. An alternate combined gradation conforming to Section 9-03.1(5) may be proposed, that has a nominal maximum aggregate size equal to or greater than a 1½-inch sieve.

   Fly ash, if used, shall not exceed 35 percent by weight of the total cementitious material, shall conform to Section 9-23.9 and shall be limited to Class F with a maximum CaO content of 15 percent by weight.

Ground granulated blast furnace slag, if used, shall not exceed 30 percent by weight of the total cementitious material and shall conform to Section 9-23.10. When both ground granulated blast furnace slag and fly ash are included in the concrete mix, the total weight of both these materials is limited to 35 percent by weight of the total cementitious material. As an alternative to the use of fly ash, ground granulated blast furnace slag and cement as separate components, a blended hydraulic cement that meets the requirements of Section 9-01.2(1)B Blended Hydraulic Cements may be used.

The water/cement ratio shall be calculated on the total weight of cementitious material. Cementitious materials are those listed in Section 5-05.2. The minimum cementitious material for any mix design shall be 564 pounds per cubic yard.

2. **Submittals** – The Contractor's submittal shall include the mix proportions per cubic yard, test results from beams and cylinders, and the proposed sources for all ingredients including the fly ash. The mix shall be capable of providing a minimum flexural strength of 650 psi at 14 days. Evaluation of strength shall be based on statistically analyzed results of five beam specimens made according to WSDOT T 808 and tested according to WSDOT T 802 that demonstrate a quality level of not less than 80 percent analyzed in accordance with Section 1-06.2(2)D. In addition the Contractor shall fabricate, cure, and test five sets of cylinders, for evaluation of 28-day strengths, according to FOP for AASHTO T 22 and FOP for AASHTO T 23 using the same mix design as used in fabrication of the beams.

   Mix designs submitted by the Contractor shall provide a unique identification for each proposal and shall include test data confirming that concrete made in accordance with the proposed design will meet the requirements of these Specifications and the 28-day compressive strength result. Test data shall be from an independent testing lab or from a commercial concrete producer's lab. If the test data is developed at a producer's lab, the Engineer or a representative may witness all testing.

3. **Mix Design Modifications** – The Contractor may initiate adjustments to the aggregate proportions of the approved mix design. An adjustment in both the fine and coarse aggregate batch target weights of plus or minus 200 pounds per cubic yard will be allowed without resubmittal of the mix design. The adjusted aggregate weights shall become the new batch target weights for the mix design.

4. **Conformance to Mix Design** – Cement and coarse and fine aggregate weights shall be within the following tolerances of the batch target weights of the mix design:

Concrete Batch Weights		
Cement	+5%	-1%
Coarse Aggregate	+ 2%	- 2%
Fine Aggregate	+ 2%	- 2%

If the total cementitious material weight is made up of different components, these component weights shall be within the following tolerances:

a. Cement weight plus 5 percent or minus 1 percent of that specified in the mix design.

b. Fly ash and ground granulated blast furnace slag weight plus or minus 5 percent of that specified in the mix design.

c. Microsilica weight plus or minus 10 percent of that specified in the mix design.

Water shall not exceed the maximum water specified in the mix design.

The Contractor may initiate minor adjustments to the approved mix proportions within the tolerances noted above without resubmitting the mix design.

The Contractor shall notify the Engineer in writing of any proposed modification. A new mix design will designate a new lot.

5-05.3(2) Consistency

The materials shall be mixed with sufficient water to produce a stiff concrete which will hold its shape when deposited upon the Subgrade. Concrete placed during wet weather must be mixed with sufficient water to produce a very stiff mixture. The consistency shall be such that separation of the mortar from the coarse aggregate will not occur in handling.

The water/cementitious material ratio, by weight, shall not exceed 0.44. When slip-form paving equipment is used, the Contractor shall further control concrete consistency to ensure that edge slump conforms to the requirements of Section 5-05.3(11).

5-05.3(3) Equipment

Equipment necessary for handling materials and performing all parts of the Work shall conform to the following requirements:

5-05.3(3)A Batching Plant and Equipment

1. **General** – The batching plant shall include bins, weighing hoppers, and scales for the fine aggregate and for each size of coarse aggregate. If cement is used in bulk, a bin, hopper, and separate scale for cement shall be included. The weighing hoppers shall be properly sealed and vented to preclude dusting during operation. The batching plant shall be equipped with a suitable batch counter that cannot be reset, which will correctly indicate the number of batches proportioned.

2. **Bins and Hoppers** – Bins with adequate separate compartments for fine aggregate and for each size of the coarse aggregate shall be provided in the batching plant.

5-05.3(3)B Mixing Equipment

1. **General** – Concrete may be mixed at a batching plant or wholly or in part in truck mixers. Each mixer shall have attached in a prominent place a manufacturer's plate showing the capacity of the drum in terms of volume of mixed concrete and the speed of rotation of the mixing drum or blades.

2. **Batching Plant** – Mixing shall be in an approved mixer capable of combining the aggregates, cement, and water into a thoroughly mixed and uniform weight within the specified mixing period.

   Mixers shall be cleaned at suitable intervals. The pickup and throw-over blades in the drum shall be repaired or replaced when they are worn down ¾ inch or more. The Contractor shall have available at the jobsite a copy of the manufacturer's design, showing dimensions and arrangements of the blades in reference to original height and depth, or provide permanent marks on blades to show points of ¾ inch wear from new conditions. Drilled holes ¼ inch in diameter near each end and at midpoint of each blade are recommended.

3. **Truck Mixers and Truck Agitators** – Truck mixers used for mixing and hauling concrete, and truck agitators used for hauling plant-mixed concrete, shall conform to the requirements of Section 6-02.3(4)A.

4. **Nonagitator Trucks** – Bodies of nonagitating hauling equipment for concrete shall be smooth, mortar-tight, metal containers and shall be capable of discharging the concrete at a satisfactory controlled rate without segregation. Covers shall be provided when needed for protection. Plant-mixed concrete may be transported in nonagitated vehicles provided that concrete is in a workable condition when placed and:

   a. discharge is completed within 45 minutes after the introduction of mixing water to the cement and aggregates, or

   b. discharge is completed within 60 minutes after the introduction of mixing water to the cement and aggregates, provided the concrete mix temperature is 70°F or below during placement, or

   c. discharge is completed within 60 minutes after the introduction of mixing water to the cement and aggregates, provided the mix contains an approved set retarder at the manufacturer's minimum dosage rate.

5-05.3(3)C Finishing Equipment

The standard method of constructing concrete pavement on State Highways shall be with approved slip-form paving equipment designed to spread, consolidate, screed, and float-finish the freshly placed concrete in one complete pass of the machine so a dense and homogeneous pavement is achieved with a minimum of hand finishing. On other roads and on WSDOT projects requiring less than 1,000 square yards of cement concrete pavement or requiring individual placement areas of less than 1,000 square yards, irregular areas, intersections, and at locations inaccessible to slip-form paving equipment, cement concrete pavement may be placed with approved placement and finishing equipment utilizing stationary side forms. Hand screeding and float finishing of cement concrete pavement may only be utilized on small irregular areas as allowed by the Engineer.

5-05.3(3)D Joint Sawing Equipment

The Contractor shall provide approved power driven concrete saws for sawing joints, adequate in number of units and power to complete the sawing at the required rate. The Contractor shall provide at least one standby saw in good working order. An ample supply of saw blades shall be maintained at the site of the Work at all times during sawing operations. The Contractor shall provide adequate artificial lighting facilities for night sawing. All of this equipment shall be on the job both before and continuously during concrete placement. Sawing equipment shall be available immediately and continuously upon call by the Engineer on a 24-hour basis, including Saturdays, Sundays, and holidays.

5-05.3(3)E Smoothness Testing Equipment

Inertial profilers shall meet all requirements of AASHTO M 328 and be certified in accordance with AASHTO R 56 within the preceding 12 months.

The inertial profiler operator shall be certified as required by AASHTO R 56 within three years preceding profile measurement.

Equipment or operator certification by other states or a profiler certification facility will be accepted provided the certification meets the requirements of AASHTO R 56. Documentation verifying certification by another state shall be submitted to the Engineer a minimum of 14 calendar days prior to profile measurement. Equipment certification documentation shall include the information required by part 8.5 and 8.6 of AASHTO R 56. Operator documentation shall include a statement from the certifying state that indicates the operator is certified to operate the inertial profiler to be used on the project. The decision whether another state's certification meets the requirements of AASHTO R 56 shall be vested entirely in the Engineer.

5-05.3(4) Measuring and Batching Materials

The batch plant site, layout, equipment, and provisions for transporting material shall ensure a continuous supply of material to the Work.

1. **Measuring Materials**

   a. **Aggregates** – The fine aggregate and each size of coarse aggregate shall be measured by weighing, the weight for the particular aggregates used being proportional to their respective bulk specific gravities. The weighing of each size of material shall be a separate and distinct operation.

      Corrections shall be made for variations in weight of materials due to the moisture content.

      The equipment for weighing aggregates shall conform to the requirements of Section 1-09.2.

   b. **Cement** – Cement shall be weighed on scales meeting the requirements of Section 1-09.2. Adequate provision shall be made to prevent loss of cement between the batch box and the mixer.

   c. **Water** – Water may be measured either by volume or by weight. The accuracy of measuring the water shall be within a range of error of not over 1 percent.

2. **Batching Materials** – On all projects requiring more than 2,500 cubic yards of concrete for paving, the batching plant shall be equipped to proportion aggregates and cement by weight by means of automatic and interlocked proportioning devices of accepted type.

5-05.3(4)A Acceptance of Portland Cement or Blended Hydraulic Cement Concrete Pavement

Acceptance of portland cement or blended hydraulic cement concrete pavement shall be as provided under statistical or nonstatistical acceptance. Determination of statistical or nonstatistical shall be based on Proposal quantities and shall consider the total of all Bid items involving of a specific class.

Statistical acceptance will apply only to Contracts advertised, Awarded and administered by WSDOT, unless specifically provided otherwise in the Special Provisions. Contracting agencies other than WSDOT must specifically invoke statistical acceptance in their Special Provisions if it is desired.

Statistical Acceptance, (1) applies only to WSDOT projects, (2) is administered under the provisions of Section 5-05.5, and (3) will be used for a class of mix when the Proposal quantities for that class of mix is 1,500 cubic yards or greater.

Nonstatistical Acceptance will be used (1) for a class of mix when the Proposal quantities for that class of mix is less than 1,500 cubic yards and (2) all contracts advertised, Awarded and administered by agencies other than WSDOT.

The point of acceptance will be in accordance with FOP for WAQTC TM 2 or at the point of discharge when a pump is used.

Acceptance of Concrete. The concrete producer shall provide a certificate of compliance for each truckload of concrete in accordance with Section 6-02.3(5)B.

For the purpose of acceptance sampling and testing, a lot is defined as having a maximum of 15 sublots that was produced for the same class of mix. The final lot may be increased to 25 sublots. All of the test results obtained from the same lot shall be evaluated collectively. The quantity represented by each sample will constitute a sublot. Sampling and testing shall be performed on a random basis at the frequency of one sample per sublot. Sublot size shall be determined to the nearest 10 cubic yards to provide not less than three uniform sized sublots with a maximum sublot size of 500 cubic yards.

Acceptance testing for compliance of air content and 28-day compressive strength shall be conducted from samples prepared according to FOP for WAQTC TM 2. Air content shall be determined by conducting FOP for AASHTO T 152. Compressive strength shall be determined by FOP for AASHTO T 23 and FOP for AASHTO T 22.

The Contractor shall provide cure boxes in accordance with Section 6-02.3(5)H, and protect concrete cylinders in cure boxes from excessive vibration and shock waves during the curing period in accordance with Section 6-02.3(6)D. Payment for cure boxes shall be in accordance with Section 6-02.5.

Rejection of Concrete

1. **Rejection by the Contractor** – The Contractor may, prior to sampling, elect to remove any defective material and replace it with new material at no expense to the Contracting Agency. Any such new material will be sampled, tested, and evaluated for acceptance.
2. **Rejection Without Testing** – The Engineer may reject any load that appears defective prior to placement. Material rejected before placement shall not be incorporated into the pavement. No payment will be made for the rejected materials unless the Contractor requests that the rejected material be tested. If the Contractor elects to have the rejected materials tested, a sample will be taken and both the air content and strength shall be tested by WSDOT.

Payment for rejected material will be based on the results of the one sample, which was taken and tested. If the rejected material fails either test, no payment will be made for the rejected material; in addition, the cost of sampling and testing at the rate of $250.00 per sample shall be borne by the Contractor. If the rejected material passes both tests, the mix will be compensated at a CPF of 1.00 and the cost of the sampling and testing will borne by the Contracting Agency.

Statistical Acceptance

The results of all acceptance testing performed in the field and the Composite Pay Factor (CPF) of the lot after three sublots have been tested will be available to the contractor through WSDOT's website.

The Specification limits as defined in Section 1-06.2(2)D shall be as follows. The lower Specification limit for Air Content shall be 3 percent, and the upper Specification limit for Air Content shall be 7 percent. The lower Specification limit for compressive strength shall be 4,000 psi.

The price adjustment factor (f_i) defined in Section 1-06.2(2)D shall be six for compressive strength and four for air content.

If either the air content or compressive strength is not measured in accordance with this section its individual pay factor will be considered to be 1.00 in calculating the Composite Pay Factor.

For each lot of cement concrete pavement a Cement Concrete Compliance Adjustment will be determined and applied, as follows:

$$CCCA = (CPF - 1.00) \times Q \times UP$$

Where

CCCA	=	Cement Concrete Compliance Adjustment for a given lot of mixture ($)
CPF	=	Composite Pay Factor for a given lot of cement concrete pavement (maximum is 1.05)
Q	=	Quantity in a given lot cement concrete pavement (cubic yards) as calculated in accordance with Section 5-04.
UP	=	Unit price of the cement concrete pavement in a given lot ($/cubic yard)

Non-Statistical Acceptance

Concrete will be accepted based on conformance to the requirement for air content and the compressive strength at 28 days for sublots as tested and determined by the Contracting Agency. The lower Specification limit for air content shall be 3 percent, and the upper Specification limit for air content shall be 7 percent. The lower Specification limit for compressive strength shall be 4,000 psi.

Each sublot will be deemed to have met the specified compressive strength requirement when both of the following conditions are met:

1. Individual strength tests do not fall below the lower specification limit for strength by more than 12½ percent, or 500 psi, whichever is least.
2. An individual strength test averaged with the two preceding individual strength tests meets or exceeds the lower specification limit for strength.

When compressive strengths fail to satisfy one or both of the above requirements, the Contractor may request acceptance of in-place concrete strength based on core results. This method will not be used if the Engineer determines coring would be harmful to the integrity of the Structure. Cores, if allowed, will be obtained by the Contractor in

accordance with FOP for AASHTO T 24 and delivered to the Contracting Agency for testing in accordance with AASHTO T 22. If the concrete in the Structure will be dry under service conditions, the core will be air-dried at a temperature of between 60°F and 80°F and at a relative humidity of less than 60 percent for 7 days before testing, and will be tested air dry.

Acceptance for each sublot by the core method requires that the average compressive strength of three cores be at least 85 percent of the specified strength with no one core less than 75 percent of the specified strength. When the Contractor requests strength analysis by coring, the results obtained will be accepted by both parties as conclusive and supersede all other strength data for the concrete sublot.

If the Contractor elects to core, cores shall be obtained no later than 50 days after initial concrete placement. The Engineer will concur in the locations to be cored. Repair of cored areas shall be the responsibility of the Contractor. The cost incurred in coring and testing these cores, including repair of core locations, shall be borne by the Contractor.

5-05.3(5) Mixing Concrete

The concrete may be mixed in a batching plant or in truck mixers. The mixer shall be of an approved type and capacity. Mixing time shall be measured from the time all materials are in the drum. Ready-mixed concrete shall be mixed and delivered in accordance with the requirements of Sections 6-02.3(4), 6-02.3(4)A, and 6-02.3(4)B.

When mixed in a batching plant, the mixing time shall not be less than 50 seconds nor more than 90 seconds.

The mixer shall be operated at a drum speed as shown on the manufacturer's nameplate on the mixer. Any concrete mixed less than the specified time shall be discarded and disposed of by the Contractor at no expense to the Contracting Agency. The volume of concrete mixed per batch shall not exceed the mixer's rated capacity, as shown on the manufacturer's standard rating plate on the mixer.

Each concrete mixing machine shall be equipped with a device for counting automatically the number of batches mixed during the day's operation.

Retempering concrete by adding water or by other means will not be permitted.

5-05.3(5)A Limitations of Mixing

Concrete shall not be mixed, placed, or finished when the natural light is inadequate, as determined by the Engineer, unless an adequate and approved artificial lighting system is operated.

Mixing and placing concrete shall be discontinued when a descending air temperature in the shade away from artificial heat reaches 40°F and shall not be resumed until an ascending air temperature in the shade and away from artificial heat reaches 35°F unless authorized in writing by the Engineer.

When mixing and placing is authorized during cold weather, the aggregates may be heated by either steam or dry heat prior to being placed in the mixer. The apparatus used

shall heat the mass uniformly and shall be arranged to preclude the possible occurrence of overheated areas which might injure the materials. Unless otherwise authorized, the temperature of the mixed concrete shall be not less than 50°F and not more than 90°F at the time of discharge into the hauling conveyance. No concrete shall be mixed with frozen aggregates.

5-05.3(6) Surface Preparation

The Subgrade surface shall be prepared and compacted a minimum of 3 feet beyond each edge of the area which is to receive concrete pavement in order to accommodate the slip-form equipment.

Concrete shall not be placed during a heavy rainfall. Prior to placing concrete:

1. The surface shall be moist;
2. Excess water (e.g., standing, pooling or flowing) shall be removed from the surface.
3. The surface shall be clean and free of any deleterious materials.
4. The surface temperature shall not exceed 120°F or be frozen.

5-05.3(7) Placing, Spreading, and Compacting Concrete

5-05.3(7)A Slip-Form Construction

The concrete shall be distributed uniformly into final position by a self-propelled slip-form paver without delay. The alignment and elevation of the paver shall be regulated from outside reference lines established for this purpose, or by an electronic control system capable of controlling the line and grade within required tolerances. The paver shall vibrate the concrete for the full width and depth of the strip of pavement being placed and the vibration shall be adequate to provide a consistency of concrete that will stand normal to the surface with sharp well-defined edges. The sliding forms shall be rigidly held together laterally to prevent spreading of the forms.

The plastic concrete shall be effectively consolidated by internal vibration with transverse vibrating units for the full width of pavement and/or a series of equally spaced longitudinal vibrating units. The space from the outer edge of the pavement to the outer longitudinal unit shall not exceed 9 inches. The spacing of internal units shall be uniform and not exceed 18 inches.

The term internal vibration means vibration by vibrating units located within the specified thickness of pavement section.

The rate of vibration of each vibrating unit shall be not less than 7,500 cycles per minute, and the amplitude of vibration shall be sufficient to be perceptible on the surface of the concrete along the entire length of the vibrating unit and for a distance of at least 1 foot. The frequency of vibration or amplitude shall be varied proportionately with the rate of travel to result in a uniform density and air content. The paving machine shall be equipped with a tachometer or other suitable device for measuring and indicating the actual frequency of vibrations.

The concrete shall be held at a uniform consistency. The slip-form paver shall be operated with as nearly a continuous forward movement as possible and all operations of mixing, delivering, and spreading concrete shall be coordinated to provide uniform progress with stopping and starting of the paver held to a minimum. If, for any reason, it is necessary to stop the forward movement of the paver, the vibratory and tamping elements shall also be stopped immediately. No tractive force shall be applied to the machine, except that which is controlled from the machine.

When concrete is being placed adjacent to an existing pavement, that part of the equipment which is supported on the existing pavement shall be equipped with protective pads on crawler tracks or rubber-tired wheels on which the bearing surface is offset to run a sufficient distance from the edge of the pavement to avoid breaking the pavement edge.

5-05.3(7)B Stationary Side Form Construction

Side form sections shall be straight, free from warps, bends, indentations, or other defects. Defective forms shall be removed from the Work. Metal side forms shall be used unless other forms are approved by the Engineer.

Side forms may be built up by rigidly attaching a section to either top or bottom of forms. If such buildup is attached to the top of metal forms, the buildup shall be of metal.

Side forms shall be of sufficient rigidity, both in the form and in the interlocking connection with adjoining forms, that springing will not occur under the weight of grading and paving equipment or from the pressure of concrete. The Contractor shall provide sufficient forms so that there will be no delay in placing the concrete due to lack of forms.

Before placing side forms, the underlying material shall be at the proper grade. Side forms shall be placed to the required grade and alignment of the edge of the finished pavement. Wood wedges may be used to adjust the form elevation provided they do not extend into the concrete. The forms shall be firmly supported during the entire operation of placing, compacting, and finishing the pavement.

Forms shall be drilled in advance of being placed to line and grade to accommodate tie bars where these are specified.

Immediately in advance of placing concrete and after all Subgrade operations are completed, side forms shall be trued and maintained to the required line and grade for a distance sufficient to prevent delay in placing concrete.

Side forms shall remain in place at least 12 hours after the concrete has been placed, and in all cases until the edge of the pavement no longer requires the protection of the forms. Curing compound shall be applied to the concrete immediately after the forms are removed.

Side forms shall be thoroughly cleaned and oiled each time they are used and before concrete is placed against them.

Concrete shall be spread, screeded, shaped, and consolidated by one or more self-propelled machines. These machines shall uniformly distribute and consolidate concrete without segregation so that completed pavement will conform to required cross section with a minimum of handwork.

The number and capacity of machines furnished shall be adequate to perform the Work required at a rate equal to that of concrete delivery.

Concrete for the full paving width shall be effectively consolidated by means of surface vibrators, in combination with internal vibrators, or by some other method of consolidation that produces equivalent results without segregation.

When vibrators are used to consolidate concrete, the rate of vibration shall be not less than 3,500 cycles per minute for surface vibrators and shall be not less than 7,000 cycles per minute for internal vibrators. Amplitude of vibration shall be sufficient to be perceptible on the surface of the concrete more than 1 foot from the vibrating element. The Contractor shall furnish a tachometer or other suitable device for measuring and indicating frequency of vibration.

Power to vibrators shall be connected so that vibration ceases when forward or backward motion of the machine is stopped.

5-05.3(8) Joints

Joints in cement concrete pavement will be designated as longitudinal and transverse contraction joints, longitudinal and transverse construction joints, or isolation joints, and shall be constructed as shown in the Plans and in accordance with the following provisions:

All contraction joints shall be constructed at the locations, intervals, and depths shown in the *Standard Plans*. The faces of all joints shall be constructed perpendicular to the surface of the cement concrete pavement.

5-05.3(8)A Contraction Joints

All transverse and longitudinal contraction joints shall be formed with suitable power-driven concrete saws. The Contractor shall provide sufficient sawing equipment capable of completing the sawing to the required dimensions and at the required rate to control cracking. The Contractor shall provide adequate artificial lighting facilities for night sawing. Joints shall not vary from the specified or indicated line by more than ¾ inch.

Commencement of sawing transverse contraction joints will be dependent upon the setting time of the concrete and shall be done at the earliest possible time following placement of the concrete without tearing or raveling the adjacent concrete excessively.

Longitudinal contraction joints shall be sawed as required to control cracking and as soon as practical after the initial control transverse contraction joints are completed.

Any damage to the curing material during the sawing operations shall be repaired immediately after the sawing is completed.

When cement concrete pavement is placed adjacent to existing cement concrete pavement, the vertical face of all existing working joints shall be covered with a bond-breaking material such as polyethylene film, roofing paper, or other material as approved by the Engineer.

5-05.3(8)B Sealing Sawed Contraction Joints

Sealing sawed contraction joints shall be in accordance with Section 5-03.

5-05.3(8)C Construction Joints

When placing of concrete is discontinued for more than 45 minutes, a transverse construction joint shall be installed. Construction joints shall be as shown in the *Standard Plans*.

Transverse construction joints shall be constructed between cement concrete pavement and reinforced concrete bridge approach slabs.

All transverse and longitudinal construction joints, including the joint between new and existing pavement when widened, shall be sawed and sealed in accordance with Section 5-03.3(3)C.

5-05.3(8)D Isolation Joints

Premolded joint filler in accordance with Section 9-04.1(2) shall be placed as detailed in the Plans through the full depth of concrete pavement when drainage features are placed within the concrete pavement.

5-05.3(9) Vacant

5-05.3(10) Tie Bars and Corrosion Resistant Dowel Bars

Tie bars shall be placed at all longitudinal contraction and construction joints, in accordance with the requirements shown in the *Standard Plans*. In addition, tie bars shall be installed when concrete Shoulders are placed as a separate operation or when widening existing pavement.

Tie bars shall be placed at longitudinal construction joints between lanes in a manner that the individual bars are located at the required elevation and spaced as shown in the *Standard Plans* and in a manner that the vertical edge of the concrete is not deformed or otherwise damaged during placement of the bars.

Placement tolerances for tie bars shall be within 1 inch of the middle of the concrete slab, within 1 inch of being centered over the joint and placed parallel or perpendicular to centerline within 1 inch of the vertical and horizontal plane.

Corrosion resistant dowel bars will be required for the construction joint at the end of paving operations each day and they shall be placed in accordance with the *Standard Plans*. Corrosion resistant dowel bars shall be placed at all transverse contraction joints as shown in the Contract or in accordance with the *Standard Plans*. All dowel bars shall have a parting compound, such as curing compound, grease or other Engineer approved

equal applied to them prior to placement. Any dowel bar delivered to the project that displays rust/oxidation, pinholes, questionable blemishes, or deviates from the round shall be rejected.

The Contractor shall furnish a Manufacturer's Certificate of Compliance in accordance with Section 1-06.3, including mill test report verifying conformance to the requirements of Section 9-07.5(2) as well as written certification identifying the patching material, when applicable, used at cut dowel bar ends.

Only one type of corrosion resistant dowel bars will be allowed per contract; intermixing of different corrosion resistant dowel bar types will not be allowed.

Placement tolerances for dowel bars shall be within 1 inch of the middle of the concrete slab, within 1 inch of being centered over the transverse joint and parallel to centerline within ½ inch of the vertical and the horizontal plane.

Cutting of stiffeners within the dowel bar cage is not allowed.

When fresh concrete pavement is to be placed against pre-project existing cement concrete pavement, tie bars shall be drilled and set into the existing pavement with an epoxy bonding agent in accordance with the *Standard Plans* and specified tolerances for placement of tie bars. The epoxy-bonding agent shall be either Type I or IV epoxy resin as specified in Section 9-26. The Contractor may use any method for drilling the holes, provided the method selected does not damage the existing concrete. Any damage caused by the Contractor's operations shall be repaired by the Contractor at no cost to the Contracting Agency in accordance with Section 1-07.13.

The tie bar holes shall be clean before grouting. The bar shall be centered in the hole for the full length of embedment before grouting. The grout shall then be pumped into the hole around the bar in a manner that the back of the hole will be filled first. Blocking or shimming shall not impede the flow of the grout into the hole. Dams, if needed, shall be placed at the front of the holes to confine the grout. The dams shall permit the escape of air without leaking grout and shall not be removed until grout has cured in the hole.

5-05.3(11) Finishing

After the concrete has been given a preliminary finish by means of finishing devices incorporated in the slip-form paving equipment, the surface of the fresh concrete shall be checked by the Contractor with a straightedge device not less than 10 feet in length. High areas indicated by the straightedge device shall be removed by the hand-float method. Each successive check with the straightedge device shall lap the previous check path by at least ½ of the length of the straightedge. The requirements of this paragraph may be waived if it is successfully demonstrated that other means will consistently produce a surface with a satisfactory profile index and meeting the 10-foot straightedge requirement specified in Section 5-05.3(12).

Any edge slump of the pavement, exclusive of specified edging, in excess of ¼ inch shall be corrected before the concrete has hardened. If edge slump on any 1 foot or greater length of hardened concrete exceeds 1 inch, the concrete shall be repaired as provided in Section 5-05.3(22).

The standard method of surface finish shall be longitudinal tining. In advance of curing operations, where longitudinal tining is required, the pavement shall be given an initial and a final texturing. Initial texturing shall be performed with a burlap drag or broom device that will produce striations parallel with the centerline. Final texturing shall be performed with a wire comb tine device that will produce grooves parallel with the centerline. The wire comb tine device shall be operated within 5 inches, but not closer than 3 inches, of pavement edges.

Burlap drags, brooms, and tine devices shall be installed on self-propelled equipment having external alignment control. The installation shall be such that, when texturing, the area of burlap in contact with the pavement surface shall be maintained constant at all times. Broom and tine devices shall be provided with positive elevation control. Downward pressure on pavement surface shall be maintained at all times during texturing so as to achieve uniform texturing without measurable variations in pavement profile. Self-propelled texturing machines shall be operated so that travel speed when texturing is maintained constant. Failure of equipment to conform to all provisions in this paragraph shall constitute cause for stopping placement of concrete until the equipment deficiency or malfunction is corrected. The wire comb of the final texturing device shall be rectangular in cross section, 3/32 to 1/8 inch wide, on 3/4-inch centers, ± 1/8-inch, and of sufficient length, thickness, and resilience to form grooves approximately 1/8 inch deep in the fresh concrete surface. Final texture shall be uniform in appearance with substantially all of the grooves having a depth between 1/16 and 3/16 inch.

On projects requiring less than 1,000 square yards of cement concrete pavement, for irregular areas or areas not accessible to slip-form pavers, the surface finish may be either longitudinal tined or transverse tined.

Transverse tining shall be done by texturing with a wire comb perpendicular to the centerline of the pavement. The wire comb tines shall be rectangular in cross section, 3/32 to 1/8 inch wide, on 1/2-inch centers ± 1/8 inch, and of sufficient length, thickness, and resilience to form grooves approximately 1/8 inch deep in the fresh concrete surface. Final texture shall be uniform in appearance with substantially all of the grooves having a depth between 1/16 to 3/16 inch. Finishing shall take place with the elements of the wire comb as nearly perpendicular to the concrete surface as is practical, to eliminate dragging the mortar.

If the tining equipment has not been previously approved, a test section shall be constructed prior to approval of the equipment.

Regardless of the surface finish, if the pavement has a raised curb without a formed concrete gutter, the texturing shall end 2 feet from the curb line.

At the beginning and end of paving each day, the Contractor shall, with an approved stamp, indent the concrete surface near the right hand edge of the panel to indicate the date, month, and year of placement.

At approximate 500-foot intervals where designated by the Engineer the Contractor shall, with an approved stamp, indent the concrete surface near the right hand edge of the pavement with the stationing of the Roadway.

5-05.3(12) Surface Smoothness

Pavement surface smoothness for this project will include International Roughness Index (IRI) testing. The Contractor shall perform IRI testing on each through lane, climbing lane, and passing lane, greater than 0.25 mile in length and these lanes will be subject to incentive/disincentive adjustments. Ride quality will be evaluated using the Mean Roughness Index (MRI) calculated by averaging the IRI data for the left and right wheel path within the section.

Ramps, shoulders and tapers will not be included in MRI testing for pavement smoothness and will not be subject to incentive adjustments. All Work is subject to parallel and transverse 10-foot straightedge requirements, corrective work and disincentive adjustments.

Operate the inertial profiler in accordance with AASHTO R 57. Collect two longitudinal traces, one in each wheel path. Collect profile data after completion of all concrete paving on the project in a continuous pass including areas excluded from pay adjustments. Provide notice to the Engineer a minimum of seven calendar days prior to testing.

Within 30 calendar days after the Contractor's testing, the Engineer may perform verification testing. If the verification testing shows a difference in MRI greater than the percentages shown in Table 2 of AASHTO R 54 the following resolution process will be followed:

1. The profiles, equipment and procedures will be evaluated to determine the cause of the difference.
2. If the cause of the discrepancy cannot be resolved the pavement shall be retested with both profilers at a mutually agreed time. The two profilers will test the section within 30 minutes of each other. If the retest shows a difference in MRI equal or greater than the percentages shown in Table 2 of AASHTO R 54 the Engineer's test results will be used to establish pay adjustments.

Surface smoothness of travel lanes not subject to MRI testing will be measured with a 10-foot straightedge no later than 5:00 p.m. of the day following the placing of the concrete. The completed surface of the wearing course shall not vary more than ⅛ inch from the lower edge of a 10-foot straightedge placed on the surface parallel to the centerline.

Smoothness perpendicular to the centerline will be measured with a 10-foot straightedge across all lanes with the same cross slope, including shoulders when composed of cement concrete pavement. The overlapping 10-foot straightedge measurement shall be discontinued at a point 6 inches from the most extreme outside edge of the finished cement concrete pavement. The completed surface of the wearing course shall not vary more than ¼ inch from the lower edge of a 10-foot straightedge placed on the surface perpendicular to the centerline. Any deviations in excess of the above tolerances shall be corrected.

The Contractor shall evaluate profiles for acceptance, incentive payments, disincentive payments, or corrective action using the current version of ProVAL and provide the results including the profile data in unfiltered electronic Engineering Research Division (ERD) file format to the Engineer within 2 calendar days of completing testing each section of pavement. If the profile data files are created using an export option in the manufacturer's software where filter settings can be specified, use the filter settings that were used to create data files for certification. Analyze the entire profile. Exclude any areas specifically identified in the Contract. Exclude from the analysis the first 100 feet after the start of the paving operations and last 100 feet prior to the end of the paving operation, the first 100 feet on either side of bridge Structures and bridge approach slab. Report the MRI results in inches per mile for each 52.8 foot section and horizontal distance measurements in project stationing to the nearest foot. Include pay adjustments in the results. The Engineer will verify the analysis.

Corrective work for pavement smoothness may be taken by the Contractor prior to MRI testing. After completion of the MRI testing the Contractor shall measure the smoothness of each 52.8-foot section with an MRI greater than 125 inches per mile with a 10-foot straightedge within 14 calendar days or as allowed by the Engineer. The Contractor shall identify all locations that require corrective work and provide the straight edge measurements at each location that exceeds the allowable limit to the Engineer. If all measurements in a 52.8-foot section comply with smoothness requirements, the Contractor shall provide the maximum measurement to the Engineer and a statement that corrective work is not required. Unless allowed by the Engineer, corrective work shall be taken by the Contractor for pavement identified by the Contractor or Engineer that does not meet the following requirements:

1. The completed surface shall be of uniform texture, smooth, uniform as to crown and grade, and free from defects of all kinds.
2. The completed surface shall not vary more than ⅛ inch from the lower edge of a 10-foot straightedge placed on the surface parallel to the centerline.
3. The completed surface shall vary not more than ¼ inch in 10 feet from the rate of transverse slope shown in the Plans.

All corrective work shall be completed at no additional expense, including traffic control, to the Contracting Agency. Corrective work shall not begin until the concrete has reached its design strength unless allowed by the Engineer. Pavement shall be repaired by one or more of the following methods:

1. Diamond grinding; repairs shall not reduce pavement thickness by more than ¼ inch less than the thickness shown in the Plans. When required by the Engineer, the Contractor shall verify the thickness of the concrete pavement by coring. Thickness reduction due to corrective work will not be included in thickness measurements for calculating the Thickness Deficiency in Section 5-05.5(1)A.
2. Removal and replacement of the cement concrete pavement.
3. By other method allowed by the Engineer.

For repairs following MRI testing the repaired area shall be checked by the Contractor with a 10-foot straightedge to ensure it no longer requires corrective work. With concurrence of the Engineer an inertial profiler may be used in place of the 10-foot straight edge.

If correction of the roadway as listed above either will not or does not produce satisfactory results as to smoothness or serviceability the Engineer may accept the completed pavement and a credit will be calculated in accordance with Section 5-05.5. The credit will be in addition to the price adjustment for MRI. Under these circumstances, the decision whether to accept the completed pavement or to require corrective work as described above shall be vested entirely in the Engineer.

5-05.3(13) Curing

Immediately after the finishing operations have been completed and as soon as marring of the concrete will not occur, the entire surface of the newly placed concrete shall be cured in accordance with one of the following methods the Contractor may elect.

5-05.3(13)A Curing Compound

Liquid membrane-forming concrete curing compound Type 2 meeting the requirements of Section 9-23.2 shall be applied to the entire area of the exposed surface of the concrete with an approved mechanical spray machine. The spray fog shall be protected from the wind with an adequate shield. It shall be applied uniformly at the rate of one gallon to not more than 150-square feet.

The compound shall be applied with equipment of the pressure tank or pump type equipped with a feed tank agitator which ensures continuous agitation of the compound during spraying operations. The nozzle shall be of the two-line type with sufficient air to properly atomize the compound.

The curing compound shall not be applied during or immediately after rainfall. If it becomes necessary to leave the pavement uncoated overnight, it shall be covered with polyethylene sheeting, which shall remain in place until weather conditions are favorable for the application of the curing compound.

In the event that rain falls on the newly coated pavement before the film has dried sufficiently to resist damage, or in the event of damage to the film from any cause, the Contractor shall apply a new coat of curing compound in one or two applications to the affected area at the rate which, in the opinion of the Engineer, will result in a film of curing value equal to that specified in the original coat.

Before placing the curing compound in the spray tank, it shall be thoroughly agitated as recommended by the Manufacturer. The compound shall not be diluted by the addition of solvents nor be altered in any manner. If the compound has become chilled to the extent that it is too viscous for proper stirring or application or if portions of the vehicle have been precipitated from solution, it shall be heated to restore proper fluidity but it shall not be heated above 100°F. All curing compound shall have approval prior to placing in the spray tanks.

The curing compound shall be applied immediately after the concrete has been finished and after any bleed water that has collected on the surface has disappeared, or at a time designated by the Engineer. If hair checking develops in the pavement before finishing is completed, the Engineer may order the application of the curing compound at an earlier stage, in which event any concrete cut from the surface in finishing operations shall be removed entirely from the pavement. If additional mortar is then needed to fill torn areas, it shall be obtained ahead of the spraying operations. All areas cut by finishing tools subsequent to the application of the curing compound shall immediately be given new applications at the rate specified above.

The curing compound, after application, shall be protected by the Contractor from injury until the pavement has reached a minimum compressive strength of 2,500 psi. All traffic, either by foot or otherwise, shall be considered as injurious to the film of the applied compound.

The Contractor shall provide on the job a sufficient quantity of white polyethylene sheeting to cover all the pavement laid in 3 hours of maximum operation. This sheeting shall be reserved exclusively for the protection of the pavement in case of rain or breakdown of the spray equipment used for applying the curing compound. The protective sheeting shall be placed over the pavement when ordered, and in the manner specified by the Engineer.

Areas from which it is impossible to exclude traffic shall be protected by a covering of sand or earth not less than 1 foot in thickness or by other suitable and effective means. The protective covering shall be placed no earlier than 24 hours after application of the compound.

The Contractor shall assume all liabilities for and protect the Contracting Agency from any damages or claims arising from the use of materials or processes described herein.

5-05.3(13)B White Polyethylene Sheeting

The sheeting shall be placed over the pavement immediately after finishing operations are completed, or at a time designated by the Engineer.

The sheeting shall be laid so that individual sheets overlap at least 2 feet, and the lapped areas shall be held in close contact with the pavement by weighting with earth or boards to prevent movement by the wind. The sheeting shall extend downward to cover the edges of the pavement and shall be secured to the Subgrade with a continuous bank of earth or surfacing material. Any holes occurring in the sheeting shall be patched immediately to the satisfaction of the Engineer. The sheeting shall be maintained against injury and remain in place until the pavement has reached a minimum compressive strength of 2,500 psi.

5-05.3(13)C Wet Curing

Wet curing shall be accomplished by applying a continuous fog or mist spray to the entire pavement surface until it has reached a minimum compressive strength of 2,500 psi. If water runoff is not a concern, continuous sprinkling is acceptable. Sprinkling shall not begin until the concrete has achieved initial set as determined by AASHTO T 197 or other approved method.

5-05.3(14) Cold Weather Work

When the air temperature is expected to reach the freezing point during the day or night and the pavement has not reached 50 percent of its design strength or 2,500 psi which ever is greater the concrete shall be protected from freezing. The Contractor shall, at no expense to the Contracting Agency, provide a sufficient supply of straw, hay, grass, earth, blankets, or other suitable blanketing material and spread it over the pavement to a sufficient depth to prevent freezing of the concrete. The Contractor shall be responsible for the quality and strength of the concrete thus cured. Any concrete injured by frost action or freezing shall be removed and replaced at the Contractor's expense in accordance with these Specifications.

5-05.3(15) Concrete Pavement Construction in Adjacent Lanes

Unless otherwise shown in the Plans or in the Special Provisions, the pavement shall be constructed in multiple lanes; that is, two or more adjacent lanes paved in a single operation. Longitudinal contraction joints shall be used between adjacent lanes that are paved concurrently, and construction joints shall be used when lanes are paved separately. Tie bars shall be installed during initial lane construction.

The Contractor shall replace, at no expense to the Contracting Agency, any panels on the new pavement that are cracked or broken as a result of the Contractor's operations.

5-05.3(16) Protection of Pavement

The Contractor shall protect the pavement and its appurtenances from any damage. Protection shall include personnel to direct traffic and the erection and maintenance of warning signs, lights, barricades, temporary take-down bridges across the pavement with adequate approaches, and whatever other means may be necessary to accommodate local traffic and to protect the pavement during the curing period or until opened to traffic as determined by the Engineer.

The operation of construction equipment on the new pavement will not be allowed until the pavement has developed a compressive strength of 2,500 psi as determined from cylinders, made at the time of placement, cured under comparable conditions, and tested in accordance with FOP for AASHTO T 22. Exceptions would be one track from a slip-form paving machine when paving adjacent lanes or light vehicles required for sawing operations or taking cores.

Placement of Shoulder material may commence when the pavement has developed a compressive strength of 1,800 psi as determined from cylinders made at the time of placement, cured under comparable conditions, and tested in accordance with AASHTO T22 as long as construction equipment is not operated on the new pavement.

A continuous barrier of the design shown in the Plans shall be constructed and maintained along the edge of the pavement being constructed and adjacent to the portion of the Roadway used for traffic. The barriers shall be left in place until the new pavement is ready to be opened to traffic and shall then be removed by the Contractor.

Any damage to the pavement occurring prior to final acceptance shall be replaced or repaired in accordance with Section 5-05.3(22).

5-05.3(17) Opening to Traffic

The pavement may be opened to traffic when the concrete has developed a compressive strength of 2,500 psi as determined from cylinders, made at the time of placement, cured under comparable conditions, and tested in accordance with FOP for AASHTO T 22.

Fabrication, curing, and testing of cylinders to measure early strength shall be the responsibility of the Contractor. The Contractor shall obtain the services of an independent Laboratory to perform these activities and these laboratories shall be approved by the Engineer. At the Contractor's option, the time for opening pavement may be determined through the use of the maturity test in accordance with ASTM C1074. The Contractor shall develop the maturity-strength relationship and provide maturity curves along with supporting data for approval by the Engineer. The Contractor shall furnish all equipment, including thermal or maturity meter, thermocouples, wire, and qualified personnel to monitor maturity and provide information to the Engineer. Field procedures to monitor maturity shall be submitted to the Engineer for approval prior to use. The pavement shall not be opened to traffic until the maturity-strength relationship shows the pavement has a compressive strength of 2,500 psi and approved by the Engineer.

The pavement shall be cleaned prior to opening to traffic.

All costs associated with early-strength cylinders shall be at the Contractor's expense.

5-05.3(18) Vacant

5-05.3(19) Vacant

5-05.3(20) Vacant

5-05.3(21) Vacant

5-05.3(22) Repair of Defective Pavement Slabs

Broken slabs, slabs with random cracks, nonworking contraction joints near cracks, edge slumping and spalls along joints and cracks shall be replaced or repaired as specified at no expense to the Contracting Agency, and shall be accomplished prior to completion of joint sealing.

Pavement slabs containing more than one crack shall be entirely removed and replaced. Pavement slabs containing a single crack shall be removed and replaced such that the minimum dimension of the removed slab is 6 feet long and full panel width. The portion of the panel to remain in place shall have a minimum dimension of 6 feet in length and full panel width, otherwise entire removal and replacement of the slab is required. There shall be no new joints closer than 3 feet to an existing transverse joints. Saw cutting full pavement depth is required along all longitudinal joints and at transverse locations. Tie bars and dowel bars shall be used in accordance Section 5-05.3(10).

Spalls and edge slumping shall be repaired by making vertical saw cuts at least 3 inches outside the affected area and to a minimum depth of 2 inches. Spall repairs that encounter dowel bars or are within 6 inches of a dowel bar will not be permitted. These spall areas shall be repaired by replacing a half or full panel as permitted by the Engineer. Removal of the existing pavement shall not damage any pavement to be left in place. If jackhammers are used for removing pavement, they shall not weigh more than 30 pounds, and chipping hammers shall not weigh more than 15 pounds. All power-driven hand tools used for the removal of pavement shall be operated at angles less than 45 degrees as measured from the surface of the pavement to the tool. The patch limits shall extend beyond the spalled area a minimum of 3 inches. Repair areas shall be kept square or rectangular. Repair areas that are within 12 inches of another repair area shall be combined.

The Contractor shall remove material within the perimeter of the saw cut to a depth of 2 inches, or to sound concrete as determined by the Engineer. The surface patch area shall be sandblasted and all loose material removed. All sandblasting residue shall be removed.

When a partial depth repair is placed directly against an adjacent longitudinal joint, a bond-breaking material such as polyethylene film, roofing paper, or other material as approved by the Engineer shall be placed between the existing concrete and the area to be patched.

Patches that abut working transverse joints or cracks require placement of a compressible insert. The new joint or crack shall be formed to the same width as the existing joint or crack. The compressible joint material shall be placed into the existing joint 1 inch below the depth of repair. The compressible insert shall extend at least 3 inches beyond each end of the patch boundaries.

Patches that abut the lane/shoulder joint require placement of a formed edge, along the slab edge, even with the surface.

The patching material shall be mixed, placed, consolidated, finished, and cured according to manufacturer's recommendations. Slab/patch interfaces that will not receive pavement grinding shall be sealed (painted) with a 1:1 cement-water grout along the patch perimeter.

The Contractor shall reseal all joints in accordance with Section 5-03.3(3)C.

Opening to traffic shall meet the requirements of Section 5-05.3(17).

Low areas which grinding cannot feasibly remedy, shall be sandblasted, filled with epoxy bonded mortar, and textured by grinding. The epoxy bonding agent shall meet the requirements of Section 9-26.1(1)B for Type II epoxy.

5-05.4 Measurement

Cement concrete pavement will be measured by the cubic yard for the completed pavement. The volume will be determined from measurements taken as listed below.

1. The width measurement will be the width of the pavement shown on the typical cross-section in the Plans, additional widening where called for, or as otherwise specified in writing by the Engineer.
2. The length will be measured along the center of each Roadway or ramp.
3. The depth shall be determined in accordance with Section 5-05.5(1). The depth utilized to calculate the volume shall not exceed the Plan depth plus 0.04 feet.

The volume of cement concrete pavement in each thickness lot shall equal the measured length × width × thickness measurement.

Corrosion resistant dowel bar will be measured per each for the actual number of bars used in the completed Work.

Tie bar with drill hole will be measured per each for the actual number of bars used in the completed Work. Tie bars with drill holes in cement concrete pavement placed under the Contract will not be measured.

5-05.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Cement Conc. Pavement", per cubic yard.

The unit Contract price per cubic yard for "Cement Conc. Pavement" shall be full compensation for all costs incurred to carry out the requirements of Section 5-05, except for those costs included in other items, which are included in this Subsection and are included in the Proposal. All costs associated with performing the magnetic pulse induction thickness testing shall be included in the unit Contract price per cubic yard for "Cement Conc. Pavement".

"Corrosion Resistant Dowel Bar", per each.

The unit Contract price per each for "Corrosion Resistant Dowel Bar" shall be full payment for furnishing, and installing corrosion resistant dowel bars and any costs for drilling holes, placing dowel bars with baskets, furnishing and installing parting compound and all other costs associated with completing the installation of corrosion resistant dowel bars.

"Tie Bar with Drill Hole", per each.

The unit Contract price per each, "Tie Bar with Drill Hole" shall be full payment for furnishing, and installing tie bars and any costs for drilling holes, and all other costs associated with installation of tie bars. All costs for tie bars with drill holes in cement concrete pavement placed under the Contract shall be included in the unit Contract price per cubic yard for "Cement Conc. Pavement".

"Ride Smoothness Compliance Adjustment", by calculation.

Smoothness Compliance Adjustments will be based on the requirements in Section 5-05.3(12) and the following calculations:

1. Final MRI acceptance and incentive/disincentive payments for pavement smoothness will be calculated as the average of the ten 52.8-foot sections in each 528 feet in accordance with the price adjustment schedule.
    a. For sections of a lane that are a minimum of 52.8 feet and less than 528 feet, the price adjustment will be calculated using the average of the 52.8 foot MRI values and the price adjustment prorated for the length of the section.
    b. MRI values per 52.8-feet that were measured prior to corrective work will be included in the 528 foot price adjustment for sections with corrective work.
2. In addition to the price adjustment for MRI a smoothness compliance adjustment will be calculated in the sum of minus $1000.00 for each and every section of single traffic lane 52.8 feet in length in that does not meet the 10-foot straight edge requirements in Section 5-05.3(12) after corrective Work.

Price Adjustment Schedule	
MRI for each 528 ft. section in. / mi.	Pay Adjustment Schedule $ / 0.10 mi.
< 30	2400
30	2400
31	2320
32	2240
33	2160
34	2080
35	2000
36	1920
37	1840
38	1760
39	1680
40	1600
41	1520
42	1440
43	1360
44	1280
45	1200
46	1120
47	1040
48	960
49	880
50	800
51	720
52	640
53	560
54	480
55	400
56	320
57	240
58	160
59	80
60	0
61	0
62	0
63	0
64	0
65	0
66	0
67	0
68	0
69	0
70	0
71	0
72	0
73	0
74	0
75	0
76	-80
77	-160

Price Adjustment Schedule	
MRI for each 528 ft. section in. / mi.	Pay Adjustment Schedule $ / 0.10 mi.
78	-240
79	-320
80	-400
81	-480
82	-560
83	-640
84	-720
85	-800
86	-880
87	-960
88	-1040
89	-1120
90	-1200
91	-1280
92	-1360
93	-1440
94	-1520
95	-1600
96	-1680
97	-1760
98	-1840
99	-1920
100	-2000
101	-2080
102	-2160
103	-2240
104	-2320
105	-2400
106	-2480
107	-2560
108	-2640
109	-2720
110	-2800
111	-2880
112	-2960
113	-3040
114	-3120
115	-3200
116	-3280
117	-3360
118	-3440
119	-3520
120	-3600
121	-3680
122	-3760
123	-3840
124	-3920
≥125	-4000

"Cement Concrete Compliance Adjustment", by calculation.

Payment for "Cement Concrete Compliance Adjustment" will be calculated and paid as described in Section 5-05.3(4)A and the Pavement Thickness Deficiency as described in Section 5-05.5(1).

5-05.5(1) Pavement Thickness

Cement concrete pavement shall be constructed in accordance with the thickness requirements in the Plans and Specifications. Tolerances allowed for Subgrade construction and other provisions, which may affect thickness, shall not be construed to modify such thickness requirements.

Thickness measurements in each lane shall comply with the following:

Thickness Testing of Cement Concrete Pavement	
Thickness Lot Size	15 panels maximum
Thickness test location determined by	Engineer will select testing locations in accordance with WSDOT TM 716 method B.
Sample method	AASHTO T 359
Sample preparation performed by	Contractor provides, places, and secures disks in the presence of the Engineer[1]
Measurement method	AASHTO T 359
Thickness measurement performed by	Contractor, in the presence of the Engineer[2]

[1]Reflectors shall be located at within 0.5 feet of the center of the panel. The Contractor shall supply a sufficient number of 300 mm-diameter round reflectors meeting the requirements of AASHTO T 359 to accomplish the required testing.

[2]The Contractor shall provide all equipment and materials needed to perform the testing.

Thickness measurements shall be rounded to the nearest 0.01 foot.

Each thickness test location where the pavement thickness is deficient by more than 0.04 foot, shall be subject to price reduction or corrective action shall be in accordance with the following.

Thickness Deficiency	Price Reduction or Corrective Action
0.04' < Thickness Deficiency ≤ 0.06'	10% Price Reduction
0.06' < Thickness deficiency ≤ 0.08'	25% Price Reduction
Thickness deficiency > 0.08'	Remove and replace the panels or the panels may be accepted with no payment at the discretion of the Engineer.

The price reduction shall be computed by multiplying the percent price reduction in the table above by the unit Contract price by the volume of pavement represented by the thickness test lot.

Additional cores may be taken by the Contractor to determine the limits of an area that has a thickness deficiency greater than 0.04 feet. Cores shall be taken at the approximate center of the panel. Only the panels within the limits of the deficiency area as determined by the cores will be subject to a price reduction or corrective action. The cores shall be taken in the presence of the Engineer in accordance with AASHTO T 24 and delivered to the Engineer for measurement in accordance with AASHTO T 148. All costs for the additional cores including filling the core holes with patching material meeting the requirements of Section 9-20 will be the responsibility of the Contractor.

5-05.5(1)A Vacant

5-05.5(1)B Vacant

Division 6 Structures

6-01 General Requirements for Structures

6-01.1 Description

This section relates to structural and incidental items used in any or all types of existing or proposed Structures. These provisions supplement the detailed Specifications supplied for any given Structure. These provisions apply only when relevant and when they do not conflict with the Plans or Special Provisions.

6-01.2 Foundation Data

Foundation data in the Plans (from test borings, test pits, or other sources) were obtained only to guide the Department in planning and designing the project. These data reasonably represent the best information available to the Department concerning conditions and materials at the test sites at the time the investigations were made.

6-01.3 Clearing the Site

The Contractor shall clear the entire site of the proposed Structure to the limits staked by the Engineer.

6-01.4 Appearance of Structures

To achieve a more pleasing appearance, the Engineer may require the Contractor to adjust the height and alignment of bridge railings, traffic barrier, and structural curbs.

6-01.5 Vacant

6-01.6 Load Restrictions on Bridges Under Construction

Bridges under construction shall remain closed to all traffic, construction equipment and material storage until the Substructure and the Superstructure, through the bridge deck, are complete for the entire Structure, except as provided herein. Completion includes release of all falsework, removal of all forms, and attainment of the minimum design concrete strength and specified age of the concrete in accordance with these Specifications. Once the Structure is complete, Section 1-07.7 shall govern all traffic loading, including vehicle traffic and construction equipment.

The Contractor may only store material on a bridge span under construction that will become part of that bridge span. The material shall not be stored within the middle third of the span. At the request of the Engineer, the Contractor shall provide supporting documentation of all material loads.

If necessary and safe to do so, and if the Contractor requests it through a Type 2E Working Drawing, the Engineer may allow traffic, construction equipment and material loads (in addition to those defined above) on a bridge prior to completion for loads and reaction locations not identified in the Plans. The written request shall:

1. Describe the extent of the Structure completion at time of the proposed equipment loading;
2. Describe the loading distribution, magnitude, arrangement, movement, and position of all traffic, construction equipment, and materials on the bridge, including but not limited to the following:
    a. Locations of all construction equipment, including outriggers, spreader beams and supports for each, relative to the bridge framing plan (bridge girder layout);
    b. Mechanism of all load transfer (load path) to the bridge;
3. Provide calculations under the design criteria specified in the current AASHTO *LRFD Bridge Design Specifications*, including interims, and the current WSDOT Bridge Design Manual LRFD M 23-50, including at a minimum the following calculations due to traffic or construction loads:
    a. Factored demands and capacities using the Strength I Limit State in the main load carrying members and bridge deck for all construction loading on the bridge;
    b. Factored demands and capacities at the Strength IV Limit State in the main load carrying members and bridge deck for all material loads stored on the bridge;
    c. Stresses in prestressed concrete members at the Service I, II and III Limit States as applicable, including the allowable stress limits specified in Section 6-02.3(25)L3;
    d. Construction deflections at the Service I Limit State, where required by the Engineer.
4. Provide supporting material properties, catalogue cuts, and other information describing the construction equipment and all associated outriggers, spreader beams, and supports; and
5. State that the Contractor assumes all risk for damage.

6-01.7 Navigable Streams

The Contractor shall keep navigable streams clear so that water traffic may pass safely, providing and maintaining all lights and signals required by the U.S. Coast Guard. The Contractor shall also comply with all channel depth and clearance line requirements of the U.S. Corps of Engineers. This may require removing material deposited in the channel during construction.

6-01.8 Approaches to Movable Spans

No bridge deck or sidewalk slab on the approach span at either end of a movable span may be placed until after the movable span has been completed, adjusted and closed.

6-01.9 Working Drawings

All Working Drawings required for bridges and other Structures shall conform to Section 1-05.3.

6-01.10 Utilities Supported by or Attached to Bridges

Installation of utility pipes and conduit systems shall conform to the details shown in the Plans and as specified in the utility agreement between the utility company and the Contracting Agency.

All utility pipes and conduit systems supported by or attached to bridges shall be labeled with Type I reflective sheeting conforming to Section 9-28.12, and the following:

Content	Label Background Color	Lettering Utility Color
Electrical Power	Red	Black
Gas, Oil, Steam, Petroleum, and other gaseous materials	Yellow	Black
CATV, Telecommunication, Alarm, and Signal	Orange	Black
Potable Water	Blue	White
Reclaimed Water, Irrigation, Slurry	Purple	White
Sewer and Storm Drain	Green	White

The purple color background for the label for reclaimed water, irrigation, and slurry, shall be generated by placing transparent film over white reflective material. The purple tint of the transparent film shall match SAE AMS Standard 595, Color No. 37100.

The label text shall identify the utility contents and include the One-Number Locator Service phone number 1-800-424-5555.

The minimum length of the label color field shall be the longer of either 1 letter width beyond each end of the label text, or the length specified below:

Minimum Pipe O.D. (inches)	Maximum Pipe O.D. (inches)	Minimum Length of Label Color Field (inches)	Letter Height (inches)
¾	1¼	8	½
1½	2	8	¾
2½	6	12	1¼
8	10	24	2½
12		32	3½

Utility pipes and conduit systems shall be labeled on both sides of each bridge pier, and adjacent to each entrance hatch into a box girder cell. For utility pipes and conduit systems within bridge spans exceeding 300 feet, labels shall also be applied to the utility pipes and conduit systems between the piers at a maximum spacing of 300 feet. The label shall be visible at a normal eye height.

6-01.11 Name Plates

The Contractor shall install no permanent plates or markers on a Structure unless the Plans show it.

6-01.12 Final Cleanup

When the Structure is completed, the Contractor shall leave it and the entire site in a clean and orderly condition. Structure decks shall be clean. Temporary buildings, falsework, piling, lumber, equipment, and debris shall be removed. The Contractor shall level and fine grade all excavated material not used for backfill, and shall fine grade all slopes and around all piers, bents, and abutments.

6-01.13 Vacant

6-01.14 Premolded Joint Filler

When the Plans call for premolded joint filler, the Contractor shall fasten it with galvanized wire nails to 1 side of the joint. The nails must be no more than 6 inches apart and shall be 1½ inches from the edges over the entire joint area. The nails shall be at least 1½ inches longer than the thickness of the filler.

The Contractor may substitute for the nails any adhesive acceptable to the Engineer. This adhesive, however, shall be compatible with the material specified in Section 9-04.1(2) and capable of bonding the filler to portland cement concrete.

6-01.15 Normal Temperature

Bridge Plans state dimensions at a normal temperature of 64°F. Unless otherwise noted, these dimensions are horizontal or vertical.

6-01.16 Repair of Defective Work

6-01.16(1) General

When using repair procedures that are described elsewhere in the Contract Documents, the Working Drawing submittal requirements of this section shall not apply to those repairs unless noted otherwise.

Repair procedures for defective Work shall be submitted as Type 2 Working Drawings. Type 2E Working Drawings shall be submitted when required by the Engineer. As an alternative to submitting Type 2 or 2E Working Drawings, defective Work within the limits of applicability of a pre-approved repair procedure may be repaired using that procedure. Repairs using a pre-approved repair procedure shall be submitted as a Type 1 Working Drawing.

Pre-approved repair procedures shall consist of the following:

- The procedures listed in Section 6-01.16(2)
- For precast concrete, repair procedures in the annual plant approval process documents that have been approved for use by the Contracting Agency.

All Working Drawings for repair procedures shall include:

- A description of the defective Work including location, extent and pictures
- Materials to be used in the repair. Repairs using manufactured products shall include written manufacturer recommendations for intended uses of the product, surface preparation, mixing, aggregate extension (if applicable), ambient and surface temperature limits, placement methods, finishing and curing.
- Construction procedures
- Plan details of the area to be repaired
- Calculations for Type 2E Working Drawings

Material manufacturer's instructions and recommendations shall supersede any conflicting requirements in pre-approved repair procedures.

The Engineer shall be notified prior to performing any repair procedure and shall be given an opportunity to inspect the repair work being performed.

6-01.16(2) Pre-Approved Repair Procedures

6-01.16(2)A Concrete Spalls and Poor Consolidation (Rock Pockets, Honeycombs, Voids, Etc.)

This repair shall be limited to the following areas:

- Areas that are not on top Roadway surfaces (with or without an overlay) including but not limited to concrete bridge decks, bridge approach slabs or cement concrete pavement
- Areas that are not underwater
- Areas that are not on precast barrier, except for the bottom 4 inches (but not to exceed 1 inch above blockouts)
- Areas that do not affect structural adequacy as determined by the Engineer.

The repair procedure is as follows:

1. Remove all loose and unsound concrete. Impact breakers shall not exceed 15 pounds in weight when removing concrete adjacent to reinforcement or other embedments and shall not exceed 30 pounds in weight otherwise. Operate impact breakers at angles less than 45 degrees as measured from the surface of the concrete to the tool and moving away from the edge of the defective Work. Concrete shall be completely removed from exposed surfaces of existing steel reinforcing bars. If half or more of the circumference of any steel reinforcing bar is exposed, if the reinforcing bar is loose or if the bond to existing concrete is poor then concrete shall be removed at least ¾ inch behind the reinforcing bar. Do not damage any existing reinforcement. Stop work and allow the Engineer to inspect the repair area after removing all loose and unsound concrete. Submit a modified repair procedure when required by the Engineer.
2. Square the edges of the repair area by cutting an edge perpendicular to the concrete surface around the repair area. The geometry of the repair perimeter shall minimize the edge length and shall be rectangular with perpendicular edges, avoiding reentrant corners. The depth of the cut shall be a minimum of ¾ inch, but shall be reduced if necessary to avoid damaging any reinforcement. For repairs on vertical surfaces, the top edge shall slope up toward the front at a 1-vertical-to-3-horizontal slope.
3. Remove concrete within the repair area to a depth at least matching the cut depth at the edges. Large variations in the depth of removal within short distances shall be avoided. Roughen the concrete surface. The concrete surface should be roughened to at least Concrete Surface Profile (CSP) 5 in accordance with ICRI Guideline No. 310.2R, unless a different CSP is recommended by the patching material manufacturer.

4. Inspect the concrete repair surface for delaminations, debonding, microcracking and voids using hammer tapping or a chain drag. Remove any additional loose or unsound concrete in accordance with steps 1 through 3.
5. Select a patching material in accordance with Section 9-20.2 that is appropriate for the repair location and thickness. The concrete patching material shall be pumpable or self-consolidating as required for the type of placement that suits the repair. The patching material shall have a minimum compressive strength at least equal to the specified compressive strength of the concrete.
6. Prepare the concrete surface and reinforcing steel in accordance with the patching material manufacturer's recommendations. At a minimum, clean the concrete surfaces (including perimeter edges) and reinforcing steel using oil-free abrasive blasting or high-pressure (minimum 5,000 psi) water blasting. All dirt, dust, loose particles, rust, laitance, oil, film, microcracked/bruised concrete or foreign material of any sort shall be removed. Damage to the epoxy coating on steel reinforcing bars shall be repaired in accordance with Section 6-02.3(24)H.
7. Construct forms if necessary, such as for patching vertical or overhead surfaces or where patching extends to the edge or corner of a placement.
8. When recommended by the patching material manufacturer, saturate the concrete in the repair area and remove any free water at the concrete surface to obtain a saturated surface dry (SSD) substrate. When recommended by the patching material manufacturer, apply a primer, scrub coat or bonding agent to the existing surfaces. Epoxy bonding agents, if used, shall be Type II or Type V in accordance with Section 9-26.1.
9. Place and consolidate the patching material in accordance with the manufacturer's recommendations. Work the material firmly into all surfaces of the repair area with sufficient pressure to achieve proper bond to the concrete.
10. The patching material shall be textured, cured and finished in accordance with the patching material manufacturer's recommendations and/or the requirements for the repaired component. Protect the newly placed patch from vibration in accordance with Section 6-02.3(6)D.
11. When the completed repair does not match the existing concrete color and will be visible to the public, a sand and cement mixture that is color matched to the existing concrete shall be rubbed, brushed, or applied to the surface of the patching material and the concrete.

6-02 Concrete Structures

6-02.1 Description

This Work consists of the construction of all Structures (and their parts) made of portland cement or blended hydraulic cement concrete with or without reinforcement, including bridge approach slabs. Any part of a Structure to be made of other materials shall be built as these Specifications require elsewhere.

6-02.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Gravel Backfill	9-03.12
Joint and Crack Sealing Materials	9-04
Strip Seal Expansion Joint Components	9-06.19(1)
Modular Expansion Joint Components	9-06.19(2)
Reinforcing Steel	9-07
Epoxy-Coated Reinforcing Steel	9-07
Pigmented Sealer Materials	9-08.3(1)
Exposed Aggregate Concrete Coatings and Sealers	9-08.3(2)
Permeon Treatment	9-08.3(3)
Grout	9-20.3
Mortar	9-20.4
Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Ground Granulated Blast Furnace Slag	9-23.10
Microsilica Fume	9-23.11
Plastic Waterstop	9-24
Water	9-25
Fabricated Bridge Bearing Assemblies	9-31

6-02.3 Construction Requirements

6-02.3(1) Classification of Structural Concrete

The class of concrete to be used shall be as noted in the Plans and these Specifications. The class includes the specified minimum compressive strength in psi at 28 days (numerical class) and may include a letter suffix to denote structural concrete for a specific use. Letter suffixes include A for bridge approach slabs, D for bridge decks, P for piling and shafts, and W for underwater. The numerical class without a letter suffix denotes structural concrete for general purposes.

Concrete of a numerical class greater than 4000 shall conform to the requirements specified for either Class 4000 (if general-purpose) or for the appropriate Class 4000 with a letter suffix, as follows:

1. Mix design and proportioning specified in Sections 6-02.3(2), 6-02.3(2)A and 6-02.3(2)A1.
2. Consistency requirements specified in Section 6-02.3(4)C.
3. Temperature and time for placement requirements specified in Section 6-02.3(4)D.
4. Curing requirements specified in Section 6-02.3(11).

The Contractor may request, in writing, permission to use a different class of concrete with either the same or a higher compressive strength than specified. The substitute concrete shall be evaluated for acceptance based on the specified class of concrete. The Engineer will respond in writing. The Contractor shall bear any added costs that result from the change.

6-02.3(2) Proportioning Materials

The soluble chloride ion content shall be determined by the concrete supplier and included with the mix design. The soluble chloride ion content shall be determined by (1) testing mixed concrete cured at least 28 days or (2) totaled from tests of individual concrete ingredients (cement, aggregate, admixtures, water, fly ash, ground granulated blast furnace slag, and other supplementary cementing materials). Chloride ion limits for admixtures and water are provided in Sections 9-23 and 9-25. Soluble chloride ion limits for mixed concrete shall not exceed the following percent by mass of cement when tested in accordance with AASHTO T260:

Category	Acid-Soluble	Water-Soluble
Prestressed concrete	0.08	0.06
Reinforced concrete	0.10	0.08

Unless otherwise specified, the Contractor shall use Type I or II portland cement or blended hydraulic cement in all concrete as defined in Section 9-01.2(1).

The use of fly ash is required for Class 4000P concrete, except that ground granulated blast furnace slag may be substituted for fly ash at a 1:1 ratio. The use of fly ash and ground granulated blast furnace slag is optional for all other classes of concrete and may be substituted for portland cement at a 1:1 ratio as noted in the table below.

Cementitious Requirement for Concrete

Class of Concrete	Minimum Cementitious Content (Pounds)	Minimum percent Replacement of Fly Ash or Ground Granulated Blast Furnace Slag for Portland Cement	Maximum percent Replacement of Fly Ash for Portland Cement	Maximum percent Replacement of Ground Granulated Blast Furnace Slag for Portland Cement
4000	564	*	35	50
4000A	564	*	25	30
4000P	600	15	35	50
4000W	564	*	35	50
3000	564	*	35	50
Commercial Concrete	**564	*	35	50
Pumpable Lean Concrete	*	*	***	***
Lean Concrete	****145	*	35	50

*No minimum specified.

**For Commercial Concrete, the minimum cementitious content is only required for sidewalks, curbs, and gutters.

***No maximum specified.

****Maximum of 200 pounds

When both ground granulated blast furnace slag and fly ash are included in the concrete mix, the total weight of both these materials is limited to 40 percent by weight of the total cementitious material for concrete class 4000A, and 50 percent by weight of the total cementitious material for all other classes of concrete.

The water/cement ratio shall be calculated on the total weight of cementitious material. Cementitious materials are those listed in Section 5-05.2. With the Engineer's written concurrence, microsilica fume may be used in all classifications of Class 4000, Class 3000, and commercial concrete and is limited to a maximum of 10 percent of the cementitious material.

As an alternative to the use of fly ash, ground granulated blast furnace slag and cement as separate components, a blended hydraulic cement that meets the requirements of Section 9-01.2(1)B Blended Hydraulic Cements may be used.

6-02.3(2)A Contractor Mix Design

The Contractor shall provide a mix design in writing to the Engineer for all classes of concrete specified in the Plans except for lean concrete, commercial concrete and concrete class EA. No concrete shall be placed until the Engineer has reviewed the mix design. The required average 28-day compressive strength shall be selected in accordance with ACI 301, Chapter 4, Section 4.2.3.3. ACI 211.1 shall be used to determine proportions. All proposed concrete mixes except Class 4000D shall meet the requirements in Cementitious Requirement for Concrete in Section 6-02.3(2).

The Contractor's submittal of a mix design shall be on WSDOT Form 350-040 and shall provide a unique identification for each mix design and shall include the mix proportions per cubic yard, the proposed sources, the average 28-day compressive strength for which the mix is designed, the fineness modulus, and the water cement ratio. The mix design submittal shall also include test results no older than one year showing that the Aggregates do not contain Deleterious Substances in accordance with Section 9-03. Concrete placeability, workability, and strength shall be the responsibility of the Contractor. The Contractor shall notify the Engineer in writing of any mix design modifications.

Fine aggregate shall conform to Section 9-03.1(2) Class 1 or Class 2.

Coarse aggregate shall conform to Section 9-03. An alternate combined aggregate gradation conforming to Section 9-03.1(5) may also be used. The nominal maximum size aggregate for Class 4000P shall be ⅜ inch. The nominal maximum size aggregate for Class 4000A shall be 1 inch.

Nominal maximum size for concrete aggregate is defined as the smallest standard sieve opening through which the entire amount of the aggregate is permitted to pass.

A retarding admixture is required in concrete Class 4000P.

Air content for concrete Class 4000D shall conform to Section 6-02.3(2)A1. For all other concrete, air content shall be a minimum of 4.5 percent and a maximum of 7.5 percent for all concrete placed above the finished ground line unless noted otherwise.

6-02.3(2)A1 Contractor Mix Design for Concrete Class 4000D

All Class 4000D concrete shall conform to the following requirements:

1. Aggregate shall use combined gradation in accordance with Section 9-03.1(5) with a nominal maximum aggregate size of 1½ inches.
2. Permeability shall be less than 2,000 coulombs at 56 days in accordance with AASHTO T277.
3. Freeze-thaw durability shall be provided by one of the following methods:
   a. The concrete shall maintain an air content between 4.5 and 7.5 percent.
   b. The concrete shall maintain a minimum air content that achieves a durability factor of 90 percent, minimum, after 300 cycles in accordance with AASHTO T 161, Procedure A. This air content shall not be less than 3.0 percent. Test samples shall be obtained from concrete batches of a minimum of 3.0 cubic yards.
4. Shrinkage at 28 days shall be less than 0.032 percent in accordance with AASHTO T 160.
5. Density shall be measured in accordance with ASTM C138.

The Contractor shall submit the mix design in accordance with Section 6-02.3(2)A. The submittal shall include test reports for all tests listed above that follow the reporting requirements of the AASHTO/ASTM procedures. Mix designs using shrinkage reducing admixture shall state the specific quantity required. Samples for testing may be obtained from either laboratory or concrete plant batches. If concrete plant batches are used, the minimum batch size shall be 3.0 cubic yards. Testing samples of mixes using shrinkage reducing admixture shall use the admixture amount specified in the mix design submittal. The Contractor shall submit the mix design to the Engineer at least 30 calendar days prior to the placement of concrete in the bridge deck.

6-02.3(2)A2 Contractor Mix Design for Self-Consolidating Concrete

Self-consolidating concrete (SCC) is concrete that is able to flow under its own weight and completely fill the formwork without the need for vibration while maintaining homogeneity, even in the presence of dense reinforcement. SCC shall be capable of being pumped, and of flowing through the steel reinforcing bar cage without segregation or buildup of differential head inside or outside of the steel reinforcing bar cage.

Type III cement may be used in SCC.

SCC may be used for the following concrete Structure elements:

1. All cast-in-place concrete elements except bridge decks, bridge approach slabs, and any cast-in-place concrete element excluded by the Special Provisions.
2. Prestressed concrete girders in accordance with Sections 6-02.3(25).
3. The following precast concrete elements:
    a. Precast roof, wall, and floor panels and retaining wall panels in accordance with Section 6-02.3(9).
    b. Precast reinforced concrete three-sided structures, box culverts and split box culverts in accordance with Section 6-20.
    c. Precast concrete barrier in accordance with Section 6-10.3(1).
    d. Precast concrete wall stem panels in accordance with Section 6-11.3(3).
    e. Precast concrete noise wall panels in accordance with Section 6-12.3(6).
    f. Structural earth wall precast facing panels in accordance with Section 6-13.3(4).
    g. Precast drainage structure elements in accordance with Section 9-05.50.
    h. Precast junction boxes, cable vaults, and pull boxes in accordance with Section 9-29.2.

The mix design submittal shall include items specified in Section 6-02.3(2)A and results of the following tests conducted on concrete that has slump flow within the slump flow range defined below:

1. Slump Flow.
    a. The mix design shall specify the target slump flow in inches, in accordance with WSDOT FOP for ASTM C1611. The slump flow range is defined as the target slump flow plus or minus 2-inches.
    b. The visual stability index (VSI) shall be less than or equal to 1, in accordance with ASTM C1611, Appendix X1, using Filling Procedure B.
    c. The T50 flow rate results shall be less than 6-seconds in accordance with ASTM C1611, Appendix X1, using Filling Procedure B.
2. Column Segregation.
    a. The maximum static segregation shall be 10-percent in accordance with ASTM C1610.
    b. The Maximum Hardened Visual Stability Index (HVSI) shall be 1 in accordance with AASHTO PP 58.
3. J ring test results for passing ability shall be less than or equal to 1.5-inches in accordance with the WSDOT FOP for ASTM C1621.
4. Rapid assessment of static segregation resistance of self-consolidating concrete using penetration test in accordance with ASTM C1712 shall be less than or equal to 15 mm.
5. Air content shall be tested in accordance with WSDOT Test Method T 818, and shall conform to Section 6-02.3(2)A.
6. Concrete unit weight results in pounds per cubic foot shall be recorded in accordance with AASHTO T 121, except that the concrete shall not be consolidated in the test mold.
7. The temperature of all concrete laboratory test samples shall be tested in accordance with AASHTO T 309 and shall conform to the placement limits specified in Section 6-02.3(4)D.

In lieu of a Contractor-Provided mix design for SCC for precast concrete barrier, precast drainage structures, and precast junction boxes, cable vaults, and pull boxes, a representative full-size example Structure element shall be cast for inspection by the Contracting Agency. The Contractor shall have the structure sawn in half for examination by the Contracting Agency to determine that segregation has not occurred. The Contracting Agency's acceptance of the sawn structure will constitute acceptance of the manufacturing facility's use of SCC, and a concrete mix design submittal will not be required. Precast units cast at a manufacturing facility shall provide this sample as a component of the precast fabricating facility's annual plant approval process. Precast units cast on site shall provide this sample prior to casting any additional units.

6-02.3(2)B Commercial Concrete

Commercial concrete shall have a minimum compressive strength at 28 days of 3,000 psi in accordance with AASHTO T 22. Commercial concrete placed above the finished ground line shall be air entrained and have an air content from 4.5 percent to 7.5 percent in accordance with FOP for AASHTO T 152. Commercial concrete does not require mix design or source approvals for cement, aggregate, and other admixtures.

Where concrete Class 3000 is specified for items such as, culvert headwalls, plugging culverts, concrete pipe collars, pipe anchors, monument cases, Type PPB, PS, I, FB and RM signal standards, pedestals, cabinet bases, guardrail anchors, fence post footings, sidewalks, concrete curbs, curbs and gutters, and gutters, the Contractor may use commercial concrete. If commercial concrete is used for sidewalks, concrete curbs, curbs and gutters, and gutters, it shall have a minimum cementitious material content of 564 pounds per cubic yard of concrete, shall be air entrained, and the tolerances of Section 6-02.3(5)C shall apply.

6-02.3(2)C Concrete Class EA

Concrete for members and surfaces specified to receive an exposed aggregate finish shall be Class EA. Concrete Class EA shall conform to the following requirements:

28 day compressive strength	3,600 psi (minimum)
Cement	610 pounds per cubic yard
Fine Aggregate Class 1	880 pounds per cubic yard
Coarse Aggregate Grading No. 67	2,160 pounds per cubic yard
Water (maximum)	270 pounds per cubic yard
Water/Cement Ratio (maximum)	0.44

A Type A water reducing admixture conforming to Section 9-23.6 shall be used in accordance with Section 6-02.3(3). Air content shall conform to Section 6-02.3(2)A.

Mixing water shall be the minimum required for satisfactory placement and shall not exceed the specified amount.

Aggregate weights are based on a specific gravity of 2.67. Adjustments in the mix design will be made by the Engineer as necessary to correct for actual bulk specific gravity of the aggregates, moisture content of the aggregates, and to ensure proper consistency, workability, and correct cement content per cubic yard of concrete.

6-02.3(2)D Lean Concrete

Lean concrete shall meet the cementitious requirements of Section 6-02.3(2) and have a maximum water/cement ratio of 2.

6-02.3(3) Admixtures

Concrete admixtures shall be added to the concrete mix at the time of batching the concrete or in accordance with the manufacturer's written procedure and as accepted by the Engineer. A copy of the manufacturer's written procedure shall be furnished to the Engineer prior to use of any admixture. Any deviations from the manufacturer's written procedures shall be submitted as a Type 2 Working Drawing. Admixtures shall not be added to the concrete with the modified procedures until the Engineer has concurred in writing.

When the Contractor is proposing to use admixtures from different admixture manufacturers they shall provide evidence to the Engineer that the admixture will be compatible and not adversely affect the air void system of the hardened concrete. Test results complying with ASTM C457 shall be provided as the evidence to satisfy this requirement. Admixture combinations which have been previously tested and which are in compliance with ASTM C457 shall be listed in the Qualified Products List (QPL). Proposed combinations not found in the QPL shall meet this requirement.

Accelerators shall not be used.

Accelerating admixtures conforming to Sections 9-23.6(4) or 9-23.6(6) and used in accordance with the manufacturer's recommendations may be used in cast-in-place concrete, except as required here. Accelerating admixtures shall not be used in bridge decks, all concrete superstructures, crossbeams, columns, mass concrete, or new bridge approach slabs and expansion joints that are not part of a repair. Concrete placements with the least dimension greater than 6 feet shall be considered mass concrete. Concrete placement with the least dimension greater than 3 feet, but less than or equal than 6 feet, shall require the approval of the Engineer for the use of accelerating admixtures. Shafts shall not be considered mass concrete. Chloride based accelerating admixtures shall not be used.

Air entrained cement shall not be used to air entrain concrete.

6-02.3(4) Ready-Mix Concrete

All concrete, except lean concrete shall be batched in a prequalified manual, semi-automatic, or automatic plant as described in Section 6-02.3(4)A. The Engineer is not responsible for any delays to the Contractor due to problems in getting the plant certified.

6-02.3(4)A Qualification of Concrete Suppliers

Batch Plant Prequalification requires a certification by the National Ready Mix Concrete Association (NRMCA). Information concerning NRMCA certification may be obtained from the NRMCA at 900 Spring Street, Silver Springs, MD 20910 or online at www.nrmca.org. The NRMCA certification shall be valid for a 2-year period from the date of certificate. The following documentation shall be submitted to the Engineer; a copy of the current NRMCA Certificate of Conformance, the concrete mix design(s) (WSDOT Form 350-040), along with copies of the truck list, batch plant scale certification,

admixture dispensing certification, and volumetric water batching devices (including water meters) verification.

For central-mixed concrete, the mixer shall be equipped with a timer that prevents the batch from discharging until the batch has been mixed for the prescribed mixing time. A mixing time of 1 minute will be required after all materials and water have been introduced into the drum. Shorter mixing time may be allowed if the mixer performance is tested in accordance with (AASHTO M157 Annex A1 Concrete Uniformity Requirements). Tests shall be conducted by an independent testing lab or by a commercial concrete producer's lab. If the tests are performed by a producer's lab, the Engineer or a representative will witness all testing.

For shrink-mixed concrete, the mixing time in the stationary mixer shall not be less than 30 seconds or until the ingredients have been thoroughly blended.

For transit-mixed or shrink-mixed concrete, the mixing time in the transit mixer shall be a minimum of 70 revolutions at the mixing speed designated by the manufacturer of the mixer. Following mixing, the concrete in the transit mixer may be agitated at the manufacturer's designated agitation speed. A maximum of 320 revolutions (total of mixing and agitation) will be permitted prior to discharge.

All transit-mixers shall be equipped with an operational revolution counter and a functional device for measurement of water added. All mixing drums shall be free of concrete buildup and the mixing blades shall meet the minimum Specifications of the drum manufacturer. A copy of the manufacturer's blade dimensions and configuration shall be on file at the concrete producer's office. A clearly visible metal data plate (or plates) attached to each mixer and agitator shall display: (1) the maximum concrete capacity of the drum or container for mixing and agitating, and (2) the rotation speed of the drum or blades for both the agitation and mixing speeds. Mixers and agitators shall always operate within the capacity and speed-of-rotation limits set by the manufacturer. Any mixer, when fully loaded, shall keep the concrete uniformly mixed. All mixers and agitators shall be capable of discharging the concrete at a steady rate. Only those transit-mixers which meet the above requirements will be allowed to deliver concrete to any Contracting Agency project covered by these Specifications.

In transit-mixing, mixing shall begin within 30 seconds after the cement is added to the aggregates.

Central-mixed concrete, transported by truck mixer/agitator, shall not undergo more than 250 revolutions of the drum or blades before beginning discharging. To remain below this limit, the suppler may agitate the concrete intermittently within the prescribed time limit. When water or admixtures are added after the load is initially mixed, an additional 30 revolutions will be required at the recommended mixing speed.

For each project, at least biannually, or as required, the Plant Manager will examine mixers and agitators to check for any buildup of hardened concrete or worn blades. If this examination reveals a problem, or if the Engineer wishes to test the quality of the concrete, slump tests may be performed with samples taken at approximately the ¼ and

¾ points as the batch is discharged. The maximum allowable slump difference shall be as follows:

If the average of the two slump tests is < 4 inches, the difference shall be < 1 inch or if the average of the two slump tests is >4 inches, the difference shall be < 1½ inches.

If the slump difference exceeds these limits, the equipment shall not be used until the faulty condition is corrected. However, the equipment may continue in use if longer mixing times or smaller loads produce batches that pass the slump uniformity tests.

All concrete production facilities will be subject to verification inspections at the discretion of the Engineer. Verification inspections are a check for: current scale certifications; accuracy of water metering devices; accuracy of the batching process; and verification of coarse aggregate quality.

If the concrete producer fails to pass the verification inspection, the following actions will be taken:

1. For the first violation, a written warning will be provided.
2. For the second violation, the Engineer will give written notification and the Contracting Agency will assess a price reduction equal to 15 percent of the invoice cost of the concrete that is supplied from the time of the infraction until the deficient condition is corrected.
3. For the third violation, the concrete supplier is suspended from providing concrete until all such deficiencies causing the violation have been permanently corrected and the plant and equipment have been reinspected and meets all the prequalification requirements.
4. For the fourth violation, the concrete supplier shall be disqualified from supplying concrete for 1 year from the date of disqualification. At the end of the suspension period the concrete supplier may request that the facilities be inspected for prequalification.

6-02.3(4)B Jobsite Mixing

For small quantities of concrete, the Contractor may mix concrete on the job site provided the Contractor has requested in writing and received written permission from the Engineer. The Contractor's written request shall include a mix design, batching and mixing procedures, and a list of the equipment performing the job-site mixing. All job site mixed concrete shall be mixed in a mechanical mixer.

If the Engineer permits, hand mixing of concrete will be permitted for pipe collars, pipe plugs, fence posts, or other items receiving the concurrence of the Engineer, provided the hand mixing is done on a watertight platform in a way that distributes materials evenly throughout the mass. Mixing shall continue long enough to produce a uniform mixture. No hand mixed batch shall exceed ½ cubic yard.

Concrete mixed at the jobsite is never permitted for placement in water.

6-02.3(4)C Consistency

The maximum slump for concrete shall be:

1. 3½ inches for vibrated concrete placed in all bridge decks, bridge approach slabs, and flat slab bridge Superstructures.
2. 4½ inches for all other vibrated concrete.
3. 7 inches for non-vibrated concrete. (Includes Class 4000P)
4. 9 inches for shafts when using Class 4000P, provided the water cement ratio does not exceed 0.44 and a water reducer is used meeting the requirements of Section 9-23.6.
5. 5½ inches for all concrete placed in curbs, gutters, and sidewalks.

When a high range water reducer is used, the maximum slump listed in 1, 2, 3, and 5 above, may be increased an additional 2 inches.

For self-consolidating concrete (SCC), the slump requirements specified above do not apply, and are instead replaced by the target slump flow and slump flow range specified as part of the SCC mix design.

6-02.3(4)D Temperature and Time For Placement

Concrete temperatures shall remain between 55°F and 90°F while it is being placed, except that Class 4000D concrete temperatures shall remain between 55°F and 75°F during placement. The upper limit for placement for Class 4000D concrete may be increased to a maximum of 80°F if allowed by the Engineer. Precast concrete that is heat cured in accordance with Section 6-02.3(25)D shall remain between 50°F and 90°F while being placed. The batch of concrete shall be discharged at the project site no more than 1½ hours after the cement is added to the concrete mixture. The time to discharge may be extended to 1¾ hours if the temperature of the concrete being placed is less than 75°F. With the concurrence of the Engineer and as long as the temperature of the concrete being placed is below 75°F, the maximum time to discharge may be extended to 2 hours. When conditions are such that the concrete may experience an accelerated initial set, the Engineer may require a shorter time to discharge. The time to discharge may be extended upon written request from the Contractor. This time extension will be considered on a case by case basis and requires the use of specific retardation admixtures and the concurrence of the Engineer.

6-02.3(5) Acceptance of Concrete

6-02.3(5)A General

Concrete for the following applications will be accepted based on a Certificate of Compliance to be provided by the supplier as described in Section 6-02.3(5)B:

1. Lean concrete.
2. Commercial concrete.
3. Class 4000P concrete for Roadside Steel Sign Support Foundations.
4. Class 4000P concrete for Type II, III, and CCTV Signal Standard Foundations that are 12'-0" or less in depth.
5. Class 4000P concrete for Type IV and V Strain Pole Foundations that are 12'-0" or less in depth.
6. Class 4000P concrete for Steel Light Standard Foundations Types A & B.

Concrete Class EA will be accepted based on conformance to the requirements specified in Section 6-02.3(2)C for proportioning, temperature, and 28 day compressive strength.

Slip-form barrier concrete will be accepted based on conformance to the requirements for temperature, air content and compressive strength at 28 days for sublots as tested and determined by the Contracting Agency. All other concrete will be accepted based on conformance to the requirement for temperature, slump, air content for concrete placed above finished ground line, and the specified compressive strength at 28 days for sublots as tested and determined by the Contracting Agency.

A sublot is defined as the material represented by an individual strength test. An individual strength test is the average compressive strength of cylinders from the same sample of material.

Each sublot will be deemed to have met the specified compressive strength requirement when both of the following conditions are met:

1. Individual strength tests do not fall below the specified strength by more than 12½ percent or 500 psi, whichever is least.
2. An individual strength test averaged with the two preceding individual strength tests meets or exceeds specified strength (for the same class and exact mix I.D. of concrete on the same Contract).

When compressive strengths fail to satisfy one or both of the above requirements, the Contractor may:

1. Request acceptance based on the Contractor/Suppliers strength test data for cylinders made from the same truckload of concrete as the Contracting Agency cylinders; provided:

    a. The Contractor's test results are obtained from testing cylinders fabricated, handled, and stored for 28 days in accordance with FOP for AASHTO T 23 and tested in accordance with AASHTO T 22. The test cylinders shall be the same size cylinders as those cast by the Contracting Agency.

    b. The technician fabricating the cylinders is qualified by either ACI, Grade 1 or WAQTC to perform this Work.

    c. The Laboratory performing the tests in accordance with AASHTO T 22 has an equipment calibration/certification system, and a technician training and evaluation process in accordance with AASHTO R-18.

    d. Both the Contractor and Contracting Agency have at least 15 test results from the same mix to compare. The Contractor's results could be used if the Contractor's computed average of all their test results is within one standard deviation of the Contracting Agency's average test result. The computed standard deviation of the Contractor's results must also be within plus or minus 200 psi of the Contracting Agency's standard deviation.

2. Request acceptance of in-place concrete strength based on core results. This method will not be used if the Engineer determines coring would be harmful to the integrity of the Structure. Cores, if allowed, will be obtained by the Contractor in accordance with AASHTO T 24 and delivered to the Contracting Agency for testing in accordance with AASHTO T 22. If the concrete in the Structure will be dry under service conditions, the core will be air dried at a temperature of between 60°F and 80°F and at a relative humidity of less than 60 percent for 7 days before testing, and will be tested air dry.

Acceptance for each sublot by the core method requires that the average compressive strength of three cores be at least 85 percent of the specified strength with no one core less than 75 percent of the specified strength. When the Contractor requests strength analysis by coring, the results obtained will be accepted by both parties as conclusive and supersede all other strength data for the concrete sublot.

If the Contractor elects to core, cores shall be obtained no later than 50 days after initial concrete placement. The Engineer will concur in the locations to be cored. Repair of cored areas shall be the responsibility of the Contractor. The cost incurred in coring and testing these cores, including repair of core locations, shall be borne by the Contractor.

6-02.3(5)B Certification of Compliance

The concrete producer shall provide a Certificate of Compliance for each truckload of concrete. The Certificate of Compliance shall verify that the delivered concrete is in compliance with the mix design and shall include:

Manufacturer plant (batching facility)
Contracting Agency Contract number
Date
Time batched
Truck No.
Initial revolution counter reading
Quantity (quantity batched this load)
Type of concrete by class and producer design mix number

Cement producer, type, and Mill Certification No. (The mill test number as required by Section 9-01.3 is the basis for acceptance of cement.)

Fly ash (if used) brand and Class
Accepted aggregate gradation designation

Mix design weight per cubic yard and actual batched weights for:

Cement
Fly ash (if used)
Coarse concrete aggregate and moisture content (each size)
Fine concrete aggregate and moisture content
Water (including free moisture in aggregates)
Admixtures brand and total quantity batched

Air-entraining admixture
Water-reducing admixture
Other admixture

For concretes that use combined aggregate gradation, the Certificate of Compliance shall include the aggregate components and moisture contents for each size in lieu of the aggregate information described above.

In lieu of providing a machine produced record containing all of the above information, the concrete producer may use the Contracting Agency-provided printed forms, which shall be completed for each load of concrete delivered to the project.

For commercial concrete, the Certificate of Compliance shall include, as a minimum, the batching facility, date, and quantity batched per load.

6-02.3(5)C Conformance to Mix Design

Cement, coarse and fine aggregate weights shall be within the following tolerances of the mix design:

Batch Volumes less than or equal to 4 cubic yards		
Cement	+5%	-1%
Aggregate	+10%	-2%

Batch Volumes more than 4 cubic yards		
Cement	+5%	-1%
Aggregate	+2%	-2%

If the total cementitious material weight is made up of different components, these component weights shall be within the following tolerances:

1. Cement weight plus 5 percent or minus 1 percent of that specified in the mix design.
2. Fly ash and ground granulated blast furnace slag weight plus or minus 5 percent of that specified in the mix design.
3. Microsilica weight plus or minus 10 percent of that specified in the mix design.

Water shall not exceed the maximum water specified in the mix design.

6-02.3(5)D Test Methods

Acceptance testing will be performed by the Contracting Agency in accordance with the WSDOT *Materials Manual* M 46-01. The test methods to be used with this Specification are:

AASHTO T 22	Compressive Strength of Cylindrical Concrete Specimens
FOP for AASHTO T 23	Making and Curing Concrete Test Specimens in the Field
FOP for AASHTO T 119	Slump of Hydraulic Cement Concrete
FOP for WAQTC TM 2	Sampling Freshly Mixed Concrete
FOP for AASHTO T 152	Air Content of Freshly Mixed Concrete by the Pressure Method
FOP for AASHTO T 231	Capping Cylindrical Concrete Specimens
FOP for AASHTO T 309	Temperature of Freshly Mixed Portland Cement Concrete
ASTM C1611	Standard Test Method for Slump Flow of Self-Consolidating Concrete (Inverted Mold Method only)
ASTM C1621	Standard Test Method for Passing Ability of Self-Consolidating Concrete by J-Ring (Inverted Mold Method only)

6-02.3(5)E Point of Acceptance

Determination of concrete properties for acceptance will be made based on samples taken as follows:

Bridge decks, overlays, bridge approach slabs, and barriers at the discharge of the placement system. All other placements at the truck discharge.

It shall be the Contractor's responsibility to provide adequate and representative samples of the fresh concrete to a location designated by the Engineer for the testing of concrete properties and making of cylinder specimens. Samples shall be provided as directed in Sections 1-06.1 and 1-06.2. Once the Contractor has turned over the concrete for acceptance testing, no more mix adjustment will be allowed. The concrete will either be accepted or rejected.

6-02.3(5)F Water/Cement Ratio Conformance

The actual water cement ratio shall be determined from the certified proportions of the mix, adjusting for on the job additions. No water may be added after acceptance testing or after placement has begun, except for concrete used in slip forming. For slip-formed concrete, water may be added during placement but shall not exceed the maximum water cement ratio in the mix design, and shall meet the requirements for consistency as described in Section 6-02.3(4)C. If water is added, an air and temperature test shall be taken prior to resuming placement to ensure that Specification conformance has been maintained.

6-02.3(5)G Sampling and Testing for Temperature, Consistency, and Air Content

Concrete properties shall be determined from concrete as delivered to the project and as accepted by the Contractor for placement. The Contracting Agency will perform acceptance testing on all concrete for temperature and air content, if applicable. Concrete that is not self-consolidating concrete will be tested for slump. The following additional acceptance tests will be performed on self-consolidating concrete:

1. Slump flow within the target slump flow range.
2. J ring passing ability less than or equal to 1.5 inches.
3. VSI less than or equal to 1.

Sampling and testing will be performed before concrete placement from the first load. Concrete shall not be placed until all tests have been completed by the Engineer, and the results indicate that the concrete is within acceptable limits. If the concrete is not within acceptable limits, sampling and testing will continue before concrete placement for each load until one load meets all of the applicable acceptance requirements. After one test indicates that the concrete is within specified limits, the concrete may be placed and the sampling and testing frequency may decrease to one for every 100 cubic yards. Sampling shall be performed in accordance with FOP for WAQTC TM 2 and random samples shall be selected in accordance with WSDOT T 716. After the first acceptable load of concrete,

up to ½ cubic yard may be placed from subsequent loads to be tested prior to testing for acceptance.

When the results for any subsequent acceptance test indicates that the concrete as delivered and approved by the Contractor for placement does not conform to the specified limits, the sampling and testing frequency will be resumed for each load. Whenever one subsequent test indicates that the concrete is within the specified limits, the random sampling and testing frequency of one for every 100 cubic yards may resume.

Sampling and testing for a placement of one class of concrete consisting of 50 cubic yards or less will be as listed above, except that after one set of tests indicate that the concrete is within specified limits, the remaining concrete to be placed may be accepted by visual inspection.

6-02.3(5)H Sampling and Testing for Compressive Strength and Initial Curing

Acceptance testing for compressive strength shall be conducted at the same frequency as the acceptance tests for temperature, consistency, and air content.

The Contractor shall provide and maintain a sufficient number of cure boxes in accordance with FOP for AASHTO T 23 for curing concrete cylinders. The cure boxes shall be readily accessible and no more than 500 feet from the point of acceptance testing, unless otherwise allowed by the Engineer. The Contractor shall also provide, maintain and operate all necessary power sources and connections needed to operate the cure boxes. The cure boxes shall be in-place and functioning at the specified temperature for curing cylinders prior to concrete placement. Concrete cylinders shall be cured in the cure boxes in accordance with FOP for AASHTO T 23. The cure boxes shall have working locks and the Contractor shall provide the Engineer with one key to each of the locks. Once concrete cylinders are placed in the cure box, the cure box shall not be disturbed until the cylinders have been removed. The Contractor shall retain the cure box Temperature Measuring Device log and provide it to the Engineer upon request.

The Contractor shall protect concrete cylinders in cure boxes from excessive vibration and shock waves during the curing period in accordance with Section 6-02.3(6)D.

All cure box costs shall be incidental to the associated item of work.

6-02.3(5)I Test Section for Cast-In-Place SCC

Unless otherwise approved by the Engineer, the Contractor shall construct a test section of the element being constructed of cast-in-place SCC. The Contractor shall confirm, through the SCC placement operation in the test section, the SCC flows the distance required, completely filling the forms and encapsulating the reinforcement as required without leaving voids and pockets and causing segregation of the SCC mix. The test section forms, reinforcing steel and concrete placing operations shall be identical to those to be used in the production elements.

For horizontal elements, the test section shall simulate the flow of concrete for the maximum distance anticipated during production concrete placement. The depth and width of the test section for horizontal element may be smaller than the actual depth and

width of the element to be cast. For vertical elements, the test section shall be a minimum of 33-percent of the height of the tallest element to be constructed. The Contractor shall submit Type 2 Working Drawings consisting of formwork and reinforcement details of the test section and SCC placement procedures.

After removing the forms, the test section will be inspected for signs of honeycombs, cracks, aggregate segregation, sedimentation, cold joints, and other surface and concrete placement defects. If such defects are present, the Contractor shall revise the formwork and SCC placement procedures as necessary to eliminate such defects.

Acceptance of the test section and the SCC mix design is contingent on acceptable visual inspection, and a minimum of two 4-inch minimum diameter core samples taken from the placement location and the furthest-most limits of the concrete as identified by the Engineer. The number of core locations will be specified by the Engineer. The difference in average unit weight of the locations represented by the core samples shall be less than 5-percent.

The Contractor shall use the same SCC placement procedures confirmed by the Engineer accepted test section for casting the production members.

6-02.3(5)J SCC in Precast Units

SCC for concrete barrier will be accepted in accordance with temperature, air, and compressive strength testing listed in Section 6-02.3(9).

SCC for precast junction boxes, cable vaults, and pull boxes will be accepted in accordance with the temperature and compressive strength testing listed in Section 6-02.3(9).

SCC for precast drainage structure elements will be accepted in accordance with the requirements of AASHTO M199.

6-02.3(5)K Rejecting Concrete

Rejection Without Testing – The Engineer, prior to sampling, may reject any batch or load of concrete that appears defective in composition; such as cement content or aggregate proportions. Rejected material shall not be incorporated in the Structure.

6-02.3(5)L Concrete With Non-Conforming Strength

Concrete with cylinder compressive strengths (fc) that fail to meet acceptance level requirements shall be evaluated for structural adequacy. If the material is found to be adequate, payment shall be adjusted in accordance with the following formula:

$$\text{Pay adjustment} = \frac{2(f'c - fc)(UP)(Q)}{f'c}$$

Where:

f'c	=	Specified minimum compressive strength at 28 days.
fc	=	Compressive strength at 28 days as determined by AASHTO Test Methods.
UP	=	Unit Contract price per cubic yard for the class of concrete involved.
Q	=	Quantity of concrete represented by an acceptance test based on the required frequency of testing.

Concrete that fails to meet minimum acceptance levels using the coring method will be evaluated for structural adequacy. If the material is found to be adequate, payment shall be adjusted in accordance with the following formula:

$$\text{Pay adjustment} = \frac{3.56(.85f'c - f\ cores)(UP)(Q)}{f'c}$$

Where:

f'c = Specified minimum compressive strength at 28 days.
f cores = Compressive strength of the cores as determined by AASHTO T 22.
UP = Unit Contract price per cubic yard for the class of concrete involved.
Q = Quantity of concrete represented by an acceptance test based on the required frequency of testing.

Where these Specifications designate payment for the concrete on other than a per cubic yard basis, the unit Contract price of concrete shall be taken as $300 per cubic yard for concrete Class 4000, 5000, and 6000. For concrete Class 3000, the unit contract price for Concrete shall be $160 per cubic yard.

6-02.3(6) Placing Concrete

The Contractor shall not place concrete:

1. On frozen or ice-coated ground or Subgrade;
2. Against or on ice-coated forms, reinforcing steel, structural steel, conduits, precast members, or construction joints;
3. Under rainy conditions; placing of concrete shall be stopped before the quantity of surface water is sufficient to affect or damage surface mortar quality or cause a flow or wash the concrete surface;
4. In any foundation until the Engineer has accepted its depth and character;
5. In any form until the Engineer has accepted it and the placement of any reinforcing in it; or
6. In any Work area when vibrations from nearby Work may harm the concrete's initial set or strength.

When a foundation excavation contains water, the Contractor shall pump it dry before placing concrete. If this is impossible, an underwater concrete seal shall be placed that complies with Section 6-02.3(6)B. This seal shall be thick enough to resist any uplift.

All foundations, forms, and contacting concrete surfaces shall be moistened with water just before the concrete is placed. Any standing water on the foundation, on the concrete surface, or in the form shall be removed.

The Contractor shall place concrete in the forms as soon as possible after mixing. The concrete shall always be plastic and workable. For this reason, the Engineer may reduce the time to discharge even further. Concrete placement shall be continuous, with no interruption longer than 30 minutes between adjoining layers unless the Engineer allows a longer time. The Type 2 Working Drawing submittal shall include justification that the concrete mix design will remain fluid for interruptions longer than 30 minutes between placements. Each layer shall be placed and consolidated before the preceding layer takes

initial set. After initial set, the forms shall not be jarred, and projecting ends of reinforcing bars shall not be disturbed.

In girders or walls, concrete shall be placed in continuous, horizontal layers 1½ to 2½ feet deep. Compaction shall leave no line of separation between layers. In each part of a form, the concrete shall be deposited as near its final position as possible.

Any method for placing and consolidating shall not segregate aggregates or displace reinforcing steel. Any method shall leave a compact, dense, and impervious concrete with smooth faces on exposed surfaces. Plastering is not permitted. Any section of defective concrete shall be removed at the Contractor's expense.

To prevent aggregates from separating, the length of any conveyor belt used to transport concrete shall not exceed 300 feet. If the mix needs protection from sun or rain, the Contractor shall cover the belt. When concrete pumps are used for placement, a Contractor's representative shall, prior to use on the first placement of each day, visually inspect the pumps water chamber for water leakage. No pump shall be used that allows free water to flow past the piston.

If a concrete pump is used as the placing system, the pump priming slurry shall be discarded before placement. Initial acceptance testing may be delayed until the pump priming slurry has been eliminated from the concrete being pumped. Eliminating the priming slurry from the concrete may require that several cubic yards of concrete are discharged through the pumping system and discarded. Use of a concrete pump requires a reserve pump (or other backup equipment) at the site.

If the concrete will drop more than 5 feet, it shall be deposited through a sheet metal (or other accepted) conduit. If the form slopes, the concrete shall be lowered through accepted conduit to keep it from sliding down one side of the form. No aluminum conduits or tremies shall be used to pump or place concrete. If aluminum concrete truck end chutes are used, concrete shall be continuously discharged in a manner that minimizes contact time between the concrete and the chute.

Before placing bridge deck concrete on steel spans, the Contractor shall release the falsework under the bridge and let the span swing free on its supports. Concrete in flat slab bridges shall be placed in one continuous operation for each span or series of continuous spans.

Concrete for bridge decks and the stems of T-beams or box-girders shall be placed in separate operations if the stem of the beam or girder is more than 3 feet deep. First the beam or girder stem shall be filled to the bottom of the slab fillets. Bridge deck concrete shall not be placed until enough time has passed to permit the earlier concrete to shrink (at least 12 hours). If stem depth is 3 feet or less, the Contractor may place concrete in 1 continuous operation if the Engineer concurs.

Between expansion or construction joints, concrete in beams, girders, bridge decks, piers, columns, walls, and traffic and pedestrian barriers, etc., shall be placed in a continuous operation.

No traffic or pedestrian barrier shall be placed until after the bridge deck is complete for the entire Structure. No concrete barriers shall be placed until the falsework has been released and the span supports itself. The Contractor may choose not to release the deck overhang falsework prior to the barrier placement. The Contractor shall submit Type 2E Working Drawings consisting of calculations indicating the loads induced into the girder webs due to the barrier weight and any live load placed on the Structure do not exceed the design capacity of the girder component. This analysis is not required for bridges with concrete Superstructures. No barrier, curb, or sidewalk shall be placed on steel or prestressed concrete girder bridges until the bridge deck reaches a compressive strength of at least 3,000 psi.

The Contractor may construct traffic and pedestrian barriers by the slipform method. However, the barrier may not deviate more than ¼ inch when measured by a 10-foot straightedge held longitudinally on the front face, back face, and top surface. Electrical conduit within the barrier shall be constructed in accordance with the requirements of Section 8-20.3(5).

When placing concrete in arch rings, the Contractor shall ensure that the load on the falsework remains symmetrical and uniform.

Unless otherwise allowed by the Engineer, arch ribs in open spandrel arches shall be placed in sections. Small key sections between large sections shall be filled after the large sections have shrunk.

6-02.3(6)A Weather and Temperature Limits to Protect Concrete

6-02.3(6)A1 Hot Weather Protection

The Contractor shall provide concrete within the specified temperature limits. Cooling of the coarse aggregate piles by sprinkling with water is permitted provided the moisture content is monitored, the mixing water is adjusted for the free water in the aggregate and the coarse aggregate is removed from at least 1 foot above the bottom of the pile. Sprinkling of fine aggregate piles with water is not allowed. Refrigerating mixing water, or replacing all or part of the mixing water with crushed ice is permitted, provided the ice is completely melted by placing time.

If air temperature exceeds 90°F, the Contractor shall use water spray or other accepted methods to cool all concrete-contact surfaces to less than 90°F. These surfaces include forms, reinforcing steel, steel beam flanges, and any others that touch the concrete.

6-02.3(6)A2 Cold Weather Protection

Concrete shall be maintained at or above a temperature of 40°F during the first seven days of the Cold Weather Protection Period and at or above a temperature of 35°F during the remainder of the Cold Weather Protection Period. Cold weather protection requirements do not apply to concrete in shafts and piles placed below the ground line.

Prior to placing concrete in cold weather, the Contractor shall submit a Type 2 Working Drawing with a written procedure for cold weather concreting. The procedure shall detail how the Contractor will adequately cure the concrete and prevent the concrete temperature from falling below the minimum temperature. Extra protection shall be provided for areas especially vulnerable to freezing (such as exposed top surfaces, corners and edges, thin sections, and concrete placed into steel forms). Concrete placement will only be allowed if the Contractor's cold weather protection plan has been accepted by the Engineer.

Prior to concrete placement, the Contractor shall review the 7-day temperature predictions for the job site from the Western Region Headquarters of the National Weather Service (www.wrh.noaa.gov). When temperatures below 35°F are predicted, the Contractor shall:

1. Install temperature sensors in each concrete placement. One sensor shall be installed for every 100 cubic yards of concrete placed. Sensors shall be installed at locations directed by the Engineer, and shall be placed 1.5 inches from the face of concrete.
2. Immediately after concrete placement, temperature sensors shall be installed on the concrete surface at locations directed by the Engineer. One sensor shall be installed for every 100 cubic yards of concrete placed.

Temperatures shall be measured and recorded a minimum of every hour for the duration of the Cold Weather Protection Period. Temperature data shall be submitted to the Engineer as a Type 1 Working Drawing within three days following the end of the Cold Weather Protection Period.

For each day that the concrete temperature falls below 40°F during the first seven days of the Cold Weather Protection Period, no curing time is awarded for that day and the Cold Weather Protection Period is extended for one additional day. If the concrete temperature falls below 35°F during the Cold Weather Protection Period, the concrete may be rejected by the Engineer.

6-02.3(6)B Placing Concrete in Foundation Seals

If the Plans require a concrete seal, the Contractor shall place the concrete underwater inside a watertight cofferdam, tube, or caisson. Seal concrete shall be placed in a compact mass in still water. It shall remain undisturbed and in still water until fully set. While seal concrete is being deposited, the water elevation inside and outside the cofferdam shall remain equal to prevent any flow through the seal in either direction. The cofferdam shall be vented at the vent elevation shown in the Plans. The thickness of the seal is based upon this vent elevation.

The seal shall be at least 18 inches thick unless the Plans show otherwise. The Engineer may change the seal thickness during construction which may require redesign of the footing and the pier shaft or column. Although seal thickness changes may result in the use of more or less concrete, reinforcing steel, and excavation, payment will remain as originally defined in unit Contract prices.

To place seal concrete underwater, the Contractor shall use a concrete pump or tremie. The tremie shall have a hopper at the top that empties into a watertight tube at least 10 inches in diameter. The discharge end of the tube on the tremie or concrete pump shall include a device to seal out water while the tube is first filled with concrete. Tube supports shall permit the discharge end to move freely across the entire Work area and to drop rapidly to slow or stop the flow. One tremie may be used to concrete an area up to 18 feet per side. Each additional area of this size requires one additional tremie.

Throughout the underwater concrete placement operation, the discharge end of the tube shall remain submerged in the concrete and the tube shall always contain enough concrete to prevent water from entering. The concrete placement shall be continuous until the Work is completed, resulting in a seamless, uniform seal. If the concreting operation is interrupted, the Engineer may require the Contractor to prove by core drilling or other tests that the seal contains no voids or horizontal joints. If testing reveals voids or joints, the Contractor shall repair them or replace the seal at no expense to the Contracting Agency.

Concrete Class 4000W shall be used for seals, and it shall meet the consistency requirements of Section 6-02.3(4)C.

6-02.3(6)C Dewatering Concrete Seals and Foundations

After a concrete seal is constructed, the Contractor shall pump the water out of the cofferdam and place the rest of the concrete in the dry. This pumping shall not begin until the seal has set enough to withstand the hydrostatic pressure (3 days for gravity seals and 10 days for seals containing piling or shafts). The Engineer may extend these waiting periods to ensure structural safety or to meet a condition of the operating permit.

If weighted cribs are used to resist hydrostatic pressure at the bottom of the seal, the Contractor shall anchor them to the foundation seal. Any method used (such as dowels or keys) shall transfer the entire weight of the crib to the seal.

No pumping shall be done during or for 24 hours after concrete placement unless done from a suitable sump separated from the concrete Work by a watertight wall. Pumping shall be done in a way that rules out any chance of concrete being carried away.

6-02.3(6)D Protection Against Vibration

Freshly placed concrete shall not be subjected to excessive vibration and shock waves during the curing period until it has reached a 2,000 psi minimum compressive strength for structural concrete and lower-strength classes of concrete.

After the first 5 hours from the time the concrete has been placed and consolidated, the Contractor shall keep all vibration producing operations at a safe horizontal distance from the freshly placed concrete by following either the prescriptive safe distance method or the monitoring safe distance method. These requirements for the protection of freshly placed concrete against vibration shall not apply for plant cast concrete, nor shall they apply to the vibrations caused by the traveling public.

6-02.3(6)D1 Prescriptive Safe Distance Method

After the concrete has been placed and consolidated, the Contractor shall keep all vibration producing operations at a safe horizontal distance from the freshly placed concrete as follows:

Minimum Compressive Strength, f'c	Safe Horizontal Distance[1]	
	Equipment Class L[2]	Equipment Class H[3]
< 1,000 psi	75 feet	125 feet
1,000 to < 1,400 psi	30 feet	50 feet
1,400 to 2,000 psi	15 feet	25 feet

[1]The safe horizontal distance shall be reduced to 10 feet for small rubber tire construction equipment like backhoes under 50,000 pounds, concrete placing equipment, and legal Highway vehicles if such equipment travels at speeds of:

- ≤ 5 mph on relatively smooth Roadway surfaces or
- ≤ 3 mph on rough Roadway surfaces (i.e., with potholes)

[2]Equipment Class L (Low Vibration) shall include tracked dozers under 85,000 pounds, track vehicles, trucks (unless excluded above), hand-operated jack hammers, cranes, auger drill rig, caisson drilling, vibratory roller compactors under 30,000 pounds, and grab-hammers.

[3]Equipment Class H (High Vibration) shall include pile drivers, vibratory hammers, machine-operated impact tools, pavement breakers, and other large pieces of equipment.

After the concrete has reached a minimum compressive strength specified above, the safe horizontal distance restrictions would no longer apply.

6-02.3(6)D2 Monitoring Safe Distance Method

The Contractor may monitor the vibration producing operations in order to decrease the safe horizontal distance requirements of the prescriptive safe distance method. If this method is chosen, all construction operations that produce vibration or shock waves in the vicinity of freshly placed concrete shall be monitored by the Contractor with monitoring equipment sensitive enough to detect a minimum peak particle velocity (PPV) of 0.10 inches per second. Monitoring devices shall be placed on or adjacent to the freshly placed concrete when the measurements are taken. During the time subsequent to the concrete placement, the Contractor shall cease all vibration or shock producing operations in the vicinity of the newly placed concrete when the monitoring equipment detects excessive vibration and shock waves defined as exceeding the following PPVs:

Minimum Compressive Strength, f'c	Maximum PPV
< 1,000 psi	0.10 in/sec
1,000 to < 1,400 psi	1.0 in/sec
1,400 to 2,000 psi	2.0 in/sec

After the concrete has reached a minimum compressive strength specified above, the safe horizontal distance restrictions would no longer apply.

6-02.3(7) Tolerances

Unless noted otherwise, concrete construction tolerances shall be in accordance with this section. Tolerances in this section do not apply to cement concrete pavement.

Horizontal deviation of roadway crown points, cross-slope break points, and curb, barrier or railing edges from alignment or work line: ±1.0 inch

Deviation from plane: ±0.5 inch in 10 feet

Deviation from plane for roadway surfaces: ±0.25 inch in 10 feet

Deviation from plumb or specified batter: ±0.5 inch in 10 feet, but not to exceed a total of ±1.5 inches

Vertical deviation from profile grade for roadway surfaces: ±1 inch

Vertical deviation of top surfaces (except roadway surfaces): ±0.75 inch

Thickness of bridge decks and other structural slabs not at grade: ±0.25 inch

Length, width and thickness of elements such as columns, beams, crossbeams, diaphragms, corbels, piers, abutments and walls, including dimensions to construction joints in initial placements: +0.5 inch, -0.25 inch

Length, width and thickness of spread footing foundations: +2 inches, -0.5 inch

Horizontal location of the as-placed edge of spread footing foundations: The greater of ±2% of the horizontal dimension of the foundation perpendicular to the edge and ±0.5 inch. However, the tolerance shall not exceed ±2 inches.

Location of opening, insert or embedded item at concrete surface: ±0.5 inch

Cross-sectional dimensions of opening: ±0.5 inch

Bridge deck, bridge approach slab, and bridge traffic barrier expansion joint gaps with a specified temperature range, measured at a stable temperature: ±0.25 inch

Horizontal deviation of centerline of bearing pad, oak block or other bearing assembly: ±0.125 inch

Horizontal deviation of centerline of supported element from centerline of bearing pad, oak block or other bearing assembly ±0.25 inch

Vertical deviation of top of bearing pad, oak block or other bearing assembly: ±0.125 inch

6-02.3(8) Vibration of Concrete

The Contractor shall supply enough vibrators to consolidate the concrete (except that placed underwater) according to the requirements of this section. Each vibrator shall:

1. Be designed to operate while submerged in the concrete,
2. Vibrate at a rate of at least 7,000 pulses per minute, and
3. Receive the Engineer's acceptance on its type and method of use.

Immediately after concrete is placed, vibration shall be applied in the fresh batch at the point of deposit. In doing so, the Contractor shall:

1. Space the vibrators evenly, no farther apart than twice the radius of the visible effects of the vibration;
2. Ensure that vibration intensity is great enough to visibly affect a weight of 1-inch slump concrete across a radius of at least 18 inches;
3. Insert the vibrators slowly to a depth that will effectively vibrate the full depth of each layer, penetrating into the previous layer on multilayer pours;
4. Protect partially hardened concrete (i.e., nonplastic, which prevents vibrator penetration when only its own weight is applied) by preventing the vibrator from penetrating it or making direct contact with steel that extends into it;
5. Not allow vibration to continue in one place long enough to form pools of grout;
6. Continue vibration long enough to consolidate the concrete thoroughly, but not so long as to segregate it;
7. Withdraw the vibrators slowly when the process is complete; and
8. Not use vibrators to move concrete from one point to another in the forms.

When vibrating and finishing top surfaces that will be exposed to weather or wear, the Contractor shall not draw water or laitance to the surface. In high lifts, the top layer shall be shallow and made up of a concrete mix as stiff as can be effectively vibrated and finished.

To produce a smooth, dense finish on outside surfaces, the Contractor shall hand tamp the concrete.

Vibration of SCC shall only be used as described below or as approved by the Engineer:

1. To prevent the formation of a cold joint in between placement of successive batches of SCC.
2. Near the end of an SCC placement to aid in leveling the SCC in the forms.

When vibration of SCC is allowed, the magnitude and duration of the applied vibration shall be kept as minimal as possible.

6-02.3(9) Precast Concrete Units

Precast concrete units may be cast at a manufacturing facility or cast on-site within the project limits unless otherwise stated in these Specifications. Pretensioned prestressed precast concrete units are prohibited from being cast on-site.

The manufacturing facility shall be certified by the Precast/Prestressed Concrete Institute's Plant Certification Program for the type of precast member to be produced, or the National Precast Concrete Association's Plant Certification Program or be an International Congress Building Officials or International Code Council Evaluation Services recognized fabricator of structural precast concrete products, and shall be approved by WSDOT as a Certified Precast Concrete Fabricator prior to the start of production. WSDOT Certification will be granted at, and renewed during, the annual precast plant review and approval process in accordance with WSDOT Materials Manual M 46-01 Standard Practice QC 7. Products that require annual plant approval include noise barrier panels, wall panels, floor and roof panels, marine pier deck panels, retaining walls, pier caps, and bridge deck panels. Precast concrete panels that are prestressed shall meet all the requirements of Section 6-02.3(25).

Precast units that are cast within the project limits shall be considered cast on-site and are exempt from the fabrication plant approval requirement for precast products. Cast on-site units shall meet all the same quality control standards as a manufacturing facility, and all the requirements in these Specifications. Additionally, the Contractor shall submit a Type 2E Working Drawing consisting of an On-site Pre-casting and Quality Control Plan for review prior to beginning any on-site precast work. This may be a Type 2 Working Drawing if item 6 does not apply. The On-site Pre-casting and Quality Control Plan shall include at a minimum the following items:

1. List of unit(s) to be cast on-site
2. Name of designated Quality Control Supervisor for all on-site casting operations
3. Location for on-site casting, curing, and storage
4. On-site casting quality control plan and procedures
5. Concrete mix design
6. Calculation of required compressive strength if unit is to be removed from the form prior to the concrete strength reaching 70% of the specified design strength, as specified in Section 6-02.3(9)B.

The Contractor shall be responsible for quality control inspection on all precast concrete units. Prior to the start of production of the precast concrete units, the Contractor shall advise the Engineer of the production schedule. The Contractor shall give the Inspector safe and free access to the Work. If the Inspector observes any non-specification Work or unacceptable quality control practices, the Inspector will advise the plant manager if cast at a manufacturing facility or the Contactor's Quality Control Supervisor if cast on-site. If the corrective action is not acceptable to the Engineer, the units will be subject to rejection.

Type III portland cement or blended hydraulic cement is permitted to be used in precast concrete units.

Self-consolidating concrete (SCC) may be used in accordance with Section 6-02.3(2)A.

Acceptance testing shall be performed by the Contractor and test results shall be submitted to the Engineer when cast at a manufacturing facility. When cast on site, acceptance testing shall be performed by WSDOT. Concrete shall conform to the requirements specified in Section 6-02.3(2)A and Section 6-02.3(5), unless otherwise noted. The test methods described in Section 6-02.3(5)D shall be followed, unless otherwise noted. Compressive strength testing shall be performed a minimum of once per day and once for every 20 cubic yards of concrete that is placed.

6-02.3(9)A Shop Drawings

Before casting the structural elements, the Contractor shall submit Type 2 Working Drawings of the precast unit shop drawings.

These shop drawings shall show complete details of the methods, materials, and equipment the Contractor proposes to use in prestressing/precasting Work. The shop drawings shall follow the design conditions shown in the Plans and accepted On-site Pre-casting Quality Control Plan, if applicable, unless the Engineer concurs with equally effective variations.

The shop drawings shall contain as a minimum:

1. Unit shapes (elevations and sections) and dimensions.
2. Finishes and method of constructing the finish (i.e., forming, rolling).
3. Reinforcing, joint, and connection details.
4. Location and type of lifting, bracing, and erection inserts including manufacturer's recommended safe working capacity.
5. Material specifications
6. Locations and details of hardware attached to the Structure.
7. Relationship to adjacent material.

Deviations from the approved shop drawings shall only be permitted after submitting a Type 2 Working Drawing that describes the proposed changes.

Before completion of the Contract, the Contractor shall provide the Engineer with reproducible originals of the shop drawings (which include any processed changes). These shall be clear and in a format that conforms with Section 6-01.9.

6-02.3(9)B Casting

Before casting precast concrete units, the Contractor and Fabrication Inspector or Engineer shall have possession of a processed set of shop drawings.

Concrete shall meet the requirements of Section 6-02.3(25)C for annual preapproval of the concrete mix design and slump. Concrete for cast on-site units shall be in accordance with the accepted On-site Pre-casting and Quality Control Plan. Precast units shall not be removed from forms until the concrete has attained a minimum compressive strength of 70 percent of the specified design strength. A minimum compressive strength less than 70 percent may be used for specific precast units if:

1. the fabricator requests and receives acceptance as part of the WSDOT plant certification process, or
2. the compressive strength is specified in the accepted On-site Pre-casting and Quality Control Plan, for cast on-site units. The compressive strength shall be calculated in accordance with the PCI Design Handbook and shall include the effects of stripping rigging configuration, stripping method, form suction and impact factors, and the recommended safety factor for the modulus of rupture.

Forms may be steel or plywood faced, providing they impart the required finish to the concrete.

6-02.3(9)C Curing

Concrete in the precast units shall be cured by either moist or accelerated curing methods. The curing methods to be used by a manufacturing facility shall be preapproved in the WSDOT plant certification process. The methods to be used when cast on-site shall be as accepted in the On-site Pre-casting and Quality Control Plan.

1. For moist curing, the surface of the concrete shall be kept covered or moist until such time as the compressive strength of the concrete reaches 70% of the specified design strength. Exposed surfaces shall be kept continually moist by fogging, spraying, or covering with moist burlap or cotton mats. Moist curing shall commence as soon as possible following completion of surface finishing.
2. For accelerated curing, heat shall be applied at a controlled rate following the initial set of concrete in combination with an effective method of supplying or retaining moisture. Moisture may be applied by a cover of moist burlap, cotton matting, or other effective means. Moisture may be retained by covering the unit with an impermeable sheet.

Heat may be radiant, convection, conducted steam or hot air. Heat the concrete to no more than 100°F during the first 2 hours after placing the concrete, and then increase no more than 25°F per hour to a maximum of 175°F. After curing is complete, cool the concrete no more than 25°F per hour to 100°F. Maintain the concrete temperature above 60°F until the unit reaches stripping strength.

Concrete temperature shall be monitored by means of a thermocouple embedded in the concrete (linked with a thermometer accurate to plus or minus 5°F). The recording sensor (accurate to plus or minus 5°F) shall be arranged and calibrated to continuously record, date, and identify concrete temperature throughout the heating cycle. This temperature record shall be made available to the Engineer for inspection and become a part of the documentation required.

The Contractor shall never allow dry heat to directly touch exposed unit surfaces at any point.

6-02.3(9)D Control Strength

The concrete strength at stripping and the verification of design strength shall be determined by testing cylinders made from the same concrete as the precast units. The cylinders shall be made, handled, and stored in accordance with WSDOT FOP for AASHTO T 23 and compression tested in accordance with AASHTO T 22 and AASHTO T 231.

For accelerated cured units, concrete strength shall be measured on test cylinders cast from the same concrete as that in the unit. These cylinders shall be cured under time-temperature relationships and conditions that simulate those of the unit. If the forms are heated by steam or hot air, test cylinders will remain in the coolest zone throughout curing. If forms are heated another way, the Contractor shall provide a record of the curing time- temperature relationship for the cylinders for each unit to the Engineer. When two or more units are cast in a continuous line and in a continuous operation, a single set of test cylinders may represent all units provided the Contractor demonstrates uniformity of casting and curing to the satisfaction of the Engineer.

The Contractor shall mold, cure, and test enough of these cylinders to satisfy Specification requirements for measuring concrete strength. The Contractor may use 4- by 8-inch or 6- by 12-inch cylinders. The Contractor shall let cylinders cool for at least ½ hour before testing for release strength.

Test cylinders may be cured in a moist room or water tank, unless otherwise specified in the Contract, in accordance with FOP for AASHTO T 23 after the unit concrete has obtained the required release strength. If, however, the Contractor intends to ship or transport the unit, when cast on-site, prior to standard 28-day strength test, the design strength for shipping shall be determined from cylinders placed with the unit and cured under the same conditions as the unit. These cylinders may be placed in a non-insulated, moisture-proof envelope.

To measure concrete strength in the precast unit, the Contractor shall randomly select two test cylinders and average their compressive strengths. The compressive strength in either cylinder shall not fall more than 5 percent below the specified strength. If these two cylinders do not pass the test, two other cylinders shall be selected and tested.

6-02.3(9)E Finishing

The Contractor shall provide a finish on all relevant concrete surfaces as defined in Section 6-02.3(14), unless the Plans or Special Provisions require otherwise.

6-02.3(9)F Tolerances

The precast units shall be fabricated as shown in the Plans, and shall meet the dimensional tolerances listed in the latest edition of PCI-MNL-116, unless otherwise required by the Specifications, Plans or Special Provisions.

6-02.3(9)G Handling and Storage

The Contractor shall lift all units only by adequate devices at locations designated on the shop drawings.

The precast units shall not be stored or handled in a manner such that the stresses imposed on the structure, as presented in the On-site Pre-casting and Quality management Plan, are exceeded or cause damage to the structure including cracking and spalling. The Contactor shall submit lifting calculations as a supplement to the On-Site Pre-Casting Quality Control Plan at the request of the Engineer.

Precast units shall be stored off the ground on foundations suitable to prevent differential settlement or twisting of the unit. Stacked units shall be separated and supported by dunnage of uniform thickness capable of supporting the unit. Dunnage shall be arranged in vertical planes. The upper units of a stacked tier shall not be used as storage areas for shorter units unless submitted as a Type 2E Working Drawing containing engineering analysis and accepted by the Engineer.

Precast units with hairline cracks visibly apparent, radiating from the lifting loops or support locations extending more than three inches along the structure, or with hairline cracks in other locations, will be subject to evaluation by the Engineer for possible rejection. Precast units whose lifting loops pull out will be subject to evaluation by the Engineer for possible rejection.

6-02.3(9)H Shipping

Precast units shall not be shipped or transported if cast on-site until the concrete has reached the specified design strength, and the Engineer has reviewed the fabrication documentation for Contract compliance. Units cast at a manufacturing facility shall be stamped “Approved for Shipment”. Units cast on site shall not be transported to their permanent location until approved by the Engineer. The units shall be supported in such a manner that they will not be damaged by anticipated impact on their dead load. Sufficient padding material shall be provided between tie chains and cables to prevent chipping or spalling of the concrete.

6-02.3(9)I Erection

Precast units shall not be erected until the concrete has reached the specified design strength, and the Engineer has reviewed the fabrication documentation for Contract compliance. When the precast units arrive on the project from the manufacturing facility, the Engineer will confirm that they are stamped "Approved for Shipment". The Engineer will evaluate the present units for damage before accepting them. Units cast on-site shall be inspected and approved by the Engineer prior to erection.

The Contractor shall lift all precast units by suitable devices at locations designated on the shop drawings. Temporary shoring or bracing shall be provided, if necessary. Precast units shall be properly aligned and leveled as required by the Plans. Variations between adjacent elements shall be leveled out by a method accepted by the Engineer.

6-02.3(10) Bridge Decks and Bridge Approach Slabs

6-02.3(10)A Pre-Deck Pour Meeting

A pre-deck pour meeting shall be held 5 to 10 working days before placing deck concrete to discuss construction procedures, personnel, equipment to be used, concrete sampling and testing and deck finishing and curing operations. Those attending shall include, at a minimum, the superintendent, foremen in charge of placing and finishing concrete, and representatives from the concrete supplier and the concrete pump truck supplier.

If the project includes more than one bridge deck, and if the Contractor's key personnel change between concreting operations, or at request of the Engineer, additional conferences shall be held before each deck placement.

6-02.3(10)B Screed Rail Supports

The Contractor shall place screed rails outside the finishing area. When screed rails cannot be placed outside the finishing area as determined by the Engineer, they shall rest on adjustable supports that can be removed with the least possible disturbance to the screeded concrete. The supports shall rest on structural members or on forms rigid enough to resist deflection. Supports shall be removable to at least 2 inches below the finished surface. For staged constructed bridge decks, the finishing machine screed rails shall not be supported on the completed portion of deck and shall deflect with the portion of structure under construction.

Screed rails (with their supports) shall be strong enough and stiff enough to permit the finishing machine to operate effectively on them. All screed rails shall be placed and secured for the full length of the deck/slab before the concreting begins. If the Engineer concurs in advance, the Contractor may move rails ahead onto previously set supports while concreting progresses. However, such movable rails and their supports shall not change the set elevation of the screed.

On steel truss and girder spans, screed rails and bulkheads may be placed directly on transverse steel floorbeams, with the strike-board moving at right angles to the centerline of the Roadway.

6-02.3(10)C Finishing Equipment

The finishing machine shall be self-propelled and be capable of forward and reverse movement under positive control. The finishing machine shall be equipped with augers and a rotating cylindrical single or double drum screed. The finishing machine shall have the necessary adjustments to produce the required cross section, line, and grade. The finishing machine shall be capable of raising the screeds, augers, and any other parts of the finishing mechanical operation to clear the screeded surface, and returning to the specified grade under positive control. Unless otherwise allowed by the Engineer, a finishing machine manufacturer technical representative shall be on site to assist the first use of the machine on the Contract.

For bridge deck widening of 20 feet or less, and for bridge approach slabs, or where jobsite conditions do not allow the use of the conventional configuration finishing machines, or modified conventional machines as described above, the Contractor may submit a Type 2 Working Drawing proposing the use of a hand-operated motorized power screed such as a “Texas” or “Bunyan” screed. This screed shall be capable of finishing the bridge deck and bridge approach slab to the same standards as the finishing machine.

On bridge decks, the Contractor may use hand-operated strike-boards only when the Engineer concurs for special conditions where self-propelled or motorized hand-operated screeds cannot be employed. These boards shall be sturdy and able to strike off the full placement width without intermediate supports. Strike-boards, screed rails, and any specially made auxiliary equipment shall receive the Engineer’s concurrence before use. All finishing requirements in these Specifications apply to hand-operated finishing equipment.

6-02.3(10)D Concrete Placement, Finishing, and Texturing

6-02.3(10)D1 Test Slab Using Bridge Deck Concrete

After the Contractor receives the Engineer’s acceptance of the Class 4000D concrete mix design, and a minimum of seven calendar days prior to the first placement of bridge deck concrete, the Contractor shall construct a test slab using concrete of the accepted mix design.

The test slab may be constructed on grade, shall have a minimum thickness of 8-inches, shall have minimum plan dimensions of 10-feet along all four edges, and shall be square or rectangular.

During construction of the test slab, the Contractor shall demonstrate concrete sampling and testing, use of the concrete temperature monitoring system, the concrete fogging system, concrete placement system, and the concrete finishing operation. The Contractor shall conduct the demonstration using the same type of equipment to be used for the production bridge decks, except that the Contractor may elect to finish the test slab with a hand-operated strike-board.

After the construction of the test slab and the demonstration of bridge deck construction operations is complete, the Contractor shall remove and dispose of the test slab in accordance with Sections 2-02.3 and 2-03.3(7)C.

6-02.3(10)D2 Preparation for Concrete Placement

Before placing bridge approach slab concrete, the subgrade shall be constructed in accordance with Sections 2-06 and 5-05.3(6).

Before any concrete is placed, the finishing machine shall be operated over the entire length of the deck/slab to check screed deflection. Concrete placement may begin only if the Engineer accepts after this test.

Immediately before placing concrete, the Contractor shall check (and adjust if necessary) all falsework and wedges to minimize settlement and deflection from the added mass of the concrete deck/slab. The Contractor shall also install devices, such as telltales, by which the Engineer can readily measure settlement and deflection.

6-02.3(10)D3 Concrete Placement

The placement operation shall cover the full width of the bridge deck or the full width between construction joints. The Contractor shall locate any construction joint over a beam or web that can support the deck/slab on either side of the joint. The joint shall not occur over a pier unless the Plans permit. Each joint shall be formed vertically and in true alignment. The Contractor shall not release falsework or wedges supporting bridge deck placement sections on either side of a joint until each side has aged as these Specifications require.

Placement of concrete for bridge decks and bridge approach slabs shall comply with Section 6-02.3(6). In placing the concrete, the Contractor shall:

1. Place it (without segregation) against concrete placed earlier, as near as possible to its final position, approximately to grade, and in shallow, closely spaced piles;
2. Consolidate it around reinforcing steel by using vibrators before strike-off by the finishing machine;
3. Not use vibrators to move concrete;
4. Not revibrate any concrete surface areas where workers have stopped prior to screeding;
5. Remove any concrete splashed onto reinforcing steel in adjacent segments before concreting them;
6. Maintain a slight excess of concrete in front of the screed across the entire width of the placement operation. The Contractor shall coordinate the rate of placement such that the concrete is placed, consolidated, and struck off within 30 minutes from the time of placement, unless otherwise accepted by the Engineer at the pre-deck pour meeting;
7. Operate the finishing machine to create a surface that is true and ready for final finish without overfinishing or bringing excessive amounts of mortar to the surface; and
8. Leave a thin, even film of mortar on the concrete surface after the last pass of the finishing machine pan.

Workers shall complete all post screeding operations without walking on the concrete. This may require work bridges spanning the full width of the deck/slab.

After removing the screed supports, the Contractor shall fill the voids with concrete (not mortar).

If the surface left by the finishing machine is porous, rough, or has minor irregularities, the Contractor shall float the surface of the concrete. Floating shall leave a smooth and even surface. Float finishing shall be kept to the minimum number of passes necessary to seal the surface. The floats shall be at least 4-feet long. Each transverse pass of the float shall overlap the previous pass by at least half the length of the float. The first floating shall be at right angles to the strike-off. The second floating shall be at right angles to the centerline of the span. A smooth riding surface shall be maintained across construction joints.

The edge of completed roadway slabs at expansion joints and compression seals shall have a ⅜-inch radius.

After floating, but while the concrete remains plastic, the Contractor shall test the entire deck/slab for flatness (allowing for crown, camber, and vertical curvature). The testing shall be done with a 10-foot straightedge held on the surface. The straightedge shall be advanced in successive positions parallel to the centerline, moving not more than one half the length of the straightedge each time it advances. This procedure shall be repeated with the straightedge held perpendicular to the centerline. An acceptable surface shall be one free from deviations of more than ⅛-inch under the 10-foot straightedge.

If the test reveals depressions, the Contractor shall fill them with freshly mixed concrete, strike off, consolidate, and refinish them. High areas shall be cut down and refinished. Retesting and refinishing shall continue until a surface conforming to the requirements specified above is produced.

6-02.3(10)D4 Vacant

6-02.3(10)D5 Bridge Deck Concrete Finishing and Texturing

Except as otherwise specified for portions of bridge decks receiving an overlay or sidewalk under the same Contract, the Contractor shall texture the surface of the bridge deck as follows:

The Contractor shall texture the bridge deck using diamond tipped saw blades mounted on a power driven, self-propelled machine that is designed to texture concrete surfaces. The grooving equipment shall provide grooves that are ⅛" ± 1⁄64" wide, 3⁄16" ± 1⁄16" deep, and spaced at ¾" ± ⅛". The bridge deck shall not be textured with a metal tined comb.

The Contractor shall submit a Type 2 Working Drawing consisting of the type of grooving equipment to be used. The Contractor shall demonstrate that the method and equipment for texturing the bridge deck will not chip, spall or otherwise damage the deck.

Unless otherwise allowed by the Engineer, the Contractor shall texture the concrete bridge deck surface either in a longitudinal direction, parallel with centerline or in a transverse direction, perpendicular with centerline. The Contractor shall texture the bridge deck surface to within 3-inches minimum and 24-inches maximum of the edge of concrete at expansion joints, within 1-foot minimum and 2-feet maximum of the curb line, and within 3-inches minimum and 9-inches maximum of the perimeter of bridge drain assemblies.

The Contractor shall contain and collect all concrete dust and debris generated by the bridge deck texturing process, and shall dispose of the collected concrete dust and debris in accordance with Section 2-03.3(7)C.

If the Plans call for placement of a sidewalk or an HMA or concrete overlay on the bridge deck, the Contractor shall produce the final finish of these areas by dragging a strip of damp, seamless burlap lengthwise over the bridge deck or by brooming it lightly. Approximately 3-feet of the drag shall contact the surface, with the least possible bow in its leading edge. It shall be kept wet and free of hardened lumps of concrete. When the burlap drag fails to produce the required finish, the Contractor shall replace it. When not in use, it shall be lifted clear of the bridge deck.

After the bridge deck has cured, the surface shall conform to the surface smoothness requirements specified in Section 6-02.3(10)D3.

The surface texture on any area repaired to address out-of-tolerance surface smoothness shall match closely that of the surrounding bridge deck area at the completion of the repair. Methods used to remove high spots shall cut through the mortar and aggregate without breaking or dislodging the aggregate or causing spalls.

6-02.3(10)D6 Bridge Approach Slab Finishing and Texturing

Bridge approach slabs that are being built as part of a bridge construction project shall be textured in accordance with Section 6-02.3(10)D5. All other bridge approach slabs shall be textured using metal tined combs in the transverse direction, except bridge approach slabs receiving an overlay in the same Contract shall be finished as specified in Section 6-02.3(10)D5 only.

The comb shall be made of a single row of metal tines. It shall leave striations in the fresh concrete approximately 3⁄16-inch deep by ⅛-inch wide and spaced approximately ½-inch apart. The Engineer will decide actual depths at the site. If the comb has not been accepted, the Contractor shall obtain the Engineer's acceptance by demonstrating it on a test section. The Contractor may operate the combs manually or mechanically, either singly or with several placed end to end. The timing and method used shall produce the required texture without displacing larger particles of aggregate.

Texturing shall end 2-feet from curb lines. This 2-foot untextured strip shall be hand finished with a steel trowel.

Surface smoothness, high spots, and low spots shall be addressed as specified in Section 6-02.3(10)D5. The surface texture on any area cut down or built up shall match closely

that of the surrounding bridge approach slab area. The entire bridge approach slab shall provide a smooth riding surface.

6-02.3(10)E Sidewalk

Concrete for sidewalk shall be well compacted, struck off with a strike-board, and floated with a wooden float to achieve a surface that does not vary more than ⅛ inch under a 10-foot straightedge. An edging tool shall be used to finish all sidewalk edges and expansion joints. The final surface shall have a granular texture that will not turn slick when wet.

6-02.3(10)F Bridge Approach Slab Orientation and Anchors

Bridge approach slabs shall be constructed full bridge deck width from outside usable Shoulder to outside usable Shoulder at an elevation to match the Structure. Unless otherwise shown in the Plans, the pavement end of the bridge approach slab shall be constructed normal to the Roadway centerline. The bridge approach slabs shall be modified as shown in the Plans to accommodate the grate inlets at the bridge ends if the grate inlets are required.

Bridge approach slab anchors shall be installed as detailed in the Plans, and the anchor rods, couplers, and nuts shall conform to Section 9-06.5(1). The steel plates shall conform to ASTM A36. All metal parts of the approach expansion anchor shall receive one coat of paint conforming to Section 9-08.1(2)F or be galvanized in accordance with AASHTO M232. The pipe shall be any nonperforated PE or PVC pipe of the diameter specified in the Plans. Polystyrene shall conform to Section 9-04.6. The anchors shall be installed parallel both to profile grade and centerline of Roadway. The Contractor shall secure the anchors to ensure that they will not be misaligned during concrete placement. For Method B anchor installations, the epoxy bonding agent used to install the anchors shall be Type IV conforming to Section 9-26.1. The compression seal shall be as noted in the Contract documents. Dowel bars shall be installed in the bridge approach slabs in accordance with the requirements of the *Standard Plans* and Section 5-05.3(10).

The compression seal shall be a 2½ inch wide gland and shall conform to Section 9-04.1(4).

6-02.3(11) Curing Concrete

After placement, concrete surfaces shall be cured as follows:

1. Bridge sidewalks, roofs of cut and cover tunnels – Two coats of curing compound covered by white, reflective type sheeting or continuous wet curing. Curing by either method shall be for at least 10 days.
2. Bridge decks — See Section 6-02.3(11)B.
3. Bridge approach slabs – Two coats of curing compound and continuous wet cure for at least 10 days.
4. Concrete barriers and rail bases – See Section 6-02.3(11)A.
5. All other concrete surfaces – Continuous wet curing for at least 3 days.

When continuous wet curing is specified, the Contractor shall keep all exposed concrete surfaces saturated with water. Formed concrete surfaces shall be kept in a continuous wet cure by leaving the forms in place. If forms are removed during the continuous wet curing period, the Contractor shall treat the concrete as an exposed concrete surface. Runoff water shall be collected and disposed of in accordance with all applicable regulations. In no case shall runoff water be allowed to enter any lakes, streams, or other surface waters.

When curing compound is specified, it shall conform to Section 9-23.2. The Contractor shall use white pigmented curing compound (Type 2), unless stated otherwise. If the surface will be covered with HMA, the curing compound shall be white (Type 2, Class B). For bridge sidewalks, the curing compound shall be clear (Type 1, Class B). The compound shall be applied immediately after finishing and shall be agitated thoroughly just before and during application. Application of the second coat shall run at right angles to that of the first, and the coverage shall total at least 1 gallon per 150 square feet. If any curing compound spills on construction joints or reinforcing steel, the Contractor shall remove it before the next concrete placement. If other materials are to be bonded to the surface (e.g., HMA, pigmented sealer), the Contractor shall remove the curing compound by sandblasting or acceptable high pressure water washing after the curing is completed.

The Contractor shall have on the site, back-up spray equipment, enough workers, and (if needed) a work bridge from which they will apply the curing compound. The Engineer may require the Contractor to demonstrate (at least 1 day before the scheduled concrete placement) that the crew and equipment can apply the compound acceptably.

When white, reflective type sheeting is specified, it shall conform to Section 9-23.1. The sheeting shall be kept in place by taping or weighting the edges where they overlap.

When curing bridge approach slabs, two coats of curing compound shall be applied immediately (not to exceed 15 min.) after floating and tining any portion of the bridge approach slab. The continuous wet curing shall be established as soon as the concrete has set enough to allow covering without damaging the finish.

When accelerating admixtures are used, the concrete shall be cured in accordance with these specifications or until the concrete has reached 70 percent of the mix design 28-day strength, but not less than 3 days.

6-02.3(11)A Curing and Finishing Concrete Barriers and Rail Bases

6-02.3(11)A1 Fixed-Form Barrier

The fixed-form wet curing period shall be at least 10 days.

The edge chamfers shall be formed by attaching chamfer strips to the barrier forms.

After troweling and edging a barrier (while the forms remain in place), the Contractor shall:

1. Brush the top surface with a fine bristle brush;
2. Cover the top surface with heavy, quilted blankets (not burlap); and

3. Spray water on the blankets and forms at intervals sufficient to keep them continuously wet for 3 days minimum. Alternatively, if forms are removed in accordance with Section 6-02.3(17)N, heavy, quilted blankets (not burlap) shall be placed to completely cover the barrier immediately after form removal and kept continuously wet.

After performing the above steps, the Contractor shall:

4. Remove all lips and edgings with sharp tools or chisels;
5. Fill all holes with mortar conforming to Section 9-20.4(2);
6. True up corners of openings;
7. Remove concrete projecting beyond the true surface by stoning or grinding;
8. Completely cover the barrier with heavy, quilted blankets (not burlap);
9. Keep the blankets continuously wet for the remainder of the curing period.

The Contractor may start the finishing Work described in steps 4 through 7 above after the third day of curing if the entire barrier is kept covered except the immediate Work area. Otherwise, no finishing Work may be done until the wet curing period has been completed.

After a minimum of 7 days of the wet curing period, the Contractor shall clean the barrier by removing all form-release agent, mud, dust, other foreign substances, blisters, and air voids just below the surface, to the satisfaction of the Engineer. This shall be accomplished in either of two ways: (1) by light sandblasting and washing with water, or (2) by spraying with a high-pressure water jet. The water jet equipment shall use clean fresh water and shall produce (at the nozzle) at least 1,500 psi with a discharge of at least 3 gpm. The water jet nozzle shall have a 25-degree tip and shall be held no more than 9 inches from the surface being washed.

After cleaning, the Contractor shall use brushes to rub mortar conforming to Section 9-20.4(2) at a ratio of 1:1 cement/aggregate ratio into air holes and small crevices on all surfaces except the brushed top. As soon as the mortar takes its initial set, the Contractor shall rub it off with a piece of sacking or carpet. The barrier shall then be completely covered with wet blankets for the greater of 48 hours or the remainder of the wet curing period.

If the above steps of cleaning and filling with mortar are performed during the 10-day wet curing period, the wet curing blankets shall only be removed in the immediate Work area while the Work is being performed and for no longer than 8 hours.

No curing compound shall be used on fixed-form concrete barrier. The completed surface of the concrete shall be even in color and texture.

6-02.3(11)A2 Slip-Form Barrier

The edge radius shall be formed by attaching radius strips to the barrier slip form.

The Contractor shall finish slip-form barrier by: (1) steel troweling to close all surface pockmarks and holes; and (2) for plain surface barrier, lightly brushing the front and back face with vertical strokes and the top surface with transverse strokes.

After finishing, the Contractor shall cure the slip-form barrier by using either Method A (curing compound) or B (wet blankets) described below.

Method A – Under the curing compound method, the Contractor shall:

1. Spray two coats of clear curing compound (Type 1) on the concrete surface after the free water has disappeared.
2. No later than the morning after applying the curing compound, cover the barrier with white, reflective sheeting for at least 10 days.
3. After the 10-day curing period, remove the curing compound as necessary by light sandblasting or by spraying with a high-pressure water jet to produce an even surface appearance. The water jet equipment shall use clean fresh water and shall produce (at the nozzle) at least 2,500 psi with a discharge of at least 4 gpm. The water jet nozzle shall have a 25-degree tip and shall be held no more than 9 inches from the surface being cleaned. The Contractor may propose to use a curing compound/concrete sealer. The Engineer will evaluate the proposal and if found acceptable, will accept the proposal in writing. As a minimum, the Contractor's proposal shall include:
   - Product identity
   - Manufacturer's recommended application rate
   - Method of application and necessary equipment
   - Material Safety Data Sheet (MSDS)
   - Sample of the material for testing

   Allow 14 working days for evaluating the proposal and testing the material.

Method B – Under the wet curing method, the Contractor shall:

1. Provide an initial curing period by continuous fogging or mist spraying for at least the first 24 hours.
2. After the initial curing period, cover the barrier with a heavy, quilted blanket.
3. Keep the blankets continuously wet for at least 10 days. No additional finishing is required at the end of the curing period.

6-02.3(11)B Curing Bridge Deck

6-02.3(11)B1 Equipment & Submittals

The fogging apparatus shall consist of pressure washers with a minimum nozzle output of 1,500 psi, or other means accepted by the Engineer.

The Contractor shall submit a Type 2 Working Drawing consisting of the bridge deck curing plan a minimum of 14 calendar days prior to the pre-deck pour meeting. The Contractor's plan shall describe the sequence and timing that will be used to fog the bridge deck, apply pre-soaked burlap, install soaker hoses and cover the deck with white, reflective sheeting.

6-02.3(11)B2 Curing

The fogging apparatus shall be in place and charged for fogging prior to beginning concrete placement for the bridge deck.

The Contractor shall presoak all burlap to be used to cover the deck during curing.

Immediately after the finishing machine passes over finished concrete, the Contractor shall implement the following tasks:

1. The Contractor shall fog the bridge deck as necessary to suppress evaporation and maintain a wet sheen without developing pooling or sheeting water.
2. The Contractor shall apply the presoaked burlap to the top surface to fully cover the deck within 1 hour after the finishing machine has passed, unless otherwise accepted in the cold weather protection Working Drawing or as accepted by the Engineer during deck casting. The burlap shall be placed flat from work bridges to minimize unnecessary damage to the concrete finish. The Contractor shall not apply curing compound.
3. The Contractor shall continue to keep the burlap wet by fogging as needed until the burlap is covered by soaker hoses and white, reflective sheeting. The Contractor shall place the soaker hoses and white, reflective sheeting after the concrete has achieved initial set. The Contractor shall charge the soaker hoses frequently so as to keep the burlap covering the entire deck wet during the course of curing.

As an alternative to tasks 2 and 3 above, the Contractor may propose a curing system using proprietary curing blankets specifically manufactured for bridge deck curing. The Contractor shall submit a Type 2 Working Drawing consisting of details of the proprietary curing blanket system, including product literature and details of how the system is to be installed and maintained.

The wet curing regime as described shall remain in place for at least 14 consecutive calendar days.

6-02.3(12) Construction Joints

6-02.3(12)A Construction Joints in New Construction

If the Engineer allows, the Contractor may add, delete, or relocate construction joints shown in the Plans. Any request for such changes shall be in writing, accompanied by a drawing that depicts them. The Contractor will bear any added costs that result from such changes.

All construction joints shall be formed neatly with grade strips or other accepted methods. The Contracting Agency will not accept irregular or wavy pour lines. All joints shall be horizontal, vertical, or perpendicular to the main reinforcement. The Contractor shall not use an edger on any construction joint, and shall remove any lip or edging before making the adjacent pour.

If the Plans require a roughened surface on the joint, the Contractor shall strike it off to leave grooves at right angles to the length of the member. Grooves shall be installed using one of the following options:

1. Grooves shall be ½ to 1 inch wide, ¼ to ½ inch deep, and spaced equally at twice the width of the groove. Grooves shall terminate approximately 1½-inches from the face of concrete.
2. Grooves shall be 1 to 2 inches wide, a minimum of ½-inch deep, and spaced a maximum of three times the width of the groove. Grooves shall terminate approximately 1½-inches from the face of concrete.

If the Engineer allows, the Contractor may use an alternate method to produce a roughened surface on the joint, provided that such an alternate method leaves a roughened surface of at least a ¼-inch amplitude.

If the first strike-off does not produce the required roughness, the Contractor shall repeat the process before the concrete reaches initial set. The final surface shall be clean and without laitance or loose material.

If the Plans do not require a roughened surface, the Contractor shall include shear keys at all construction joints. These keys shall provide a positive, mechanical bond. Shear keys shall be formed depressions and the forms shall not be removed until the concrete has been in place at least 12 hours. Forms shall be slightly beveled to ensure ready removal. Raised shear keys are not allowed.

Shear keys for the tops of beams, at tops and bottoms of boxed girder webs, in diaphragms, and in crossbeams shall:

1. Be formed with 2 by 8-inch wood blocks;
2. Measure 8 inches lengthwise along the beam or girder stem;
3. Measure 4 inches less than the width of the stem, beam, crossbeam, etc. (measured transverse of the stem); and
4. Be spaced at 16 inches center to center.

Unless the Plans show otherwise, in other locations (not named above), shear keys shall equal approximately ⅓ of the joint area and shall be approximately 1½ inches deep.

Before placing fresh concrete against cured concrete, the Contractor shall thoroughly clean and saturate the cured surface. All loose particles, dust, dirt, laitance, oil, or film of any sort shall be removed by method(s) as accepted by the Engineer. The cleaned surface shall be saturated with water for a minimum of four hours before the fresh concrete is placed.

Before placing the reinforcing mat for footings on seals, the Contractor shall: (1) remove all scum, laitance, and loose gravel and sediment; (2) clean the construction joint at the top of the seals; and (3) chip off any high spots on the seals that would prevent the footing steel from being placed in the position required by the Plans.

6-02.3(12)B Construction Joints Between Existing and New Construction

If the Plans or Special Provisions require a roughened surface on the joint, the Contractor shall thoroughly roughen the existing surface to a uniformly distributed ¼-inch minimum amplitude surface profile, with peaks spaced at a maximum of 1 inch.

If the Plans or Special Provisions do not require a roughened surface on the joint, the Contractor shall remove all loose particles, dust, dirt, laitance, oil, or film of any sort.

Before placing fresh concrete against existing concrete, the Contractor shall thoroughly clean and saturate the existing surface. All loose particles, dust, dirt, laitance, oil, or film of any sort shall be removed. The cleaned surface shall be saturated with water for a minimum of 4 hours before the fresh concrete is placed.

6-02.3(13) Expansion Joints

This section outlines the requirements of specific expansion joints shown in the Plans. The Plans may require other types of joints, seals, or materials than those described here.

Joints made of a vulcanized, elastomeric compound (with neoprene as the only polymer) shall be installed with a lubricant adhesive as recommended by the manufacturer. The length of a seal shall match that required in the Plans without splicing or stretching.

Open joints shall be formed with a template made of wood, metal, or other suitable material. Insertion and removal of the template shall be done without chipping or breaking the edges or otherwise damaging the concrete.

Any part of an expansion joint running parallel to the direction of expansion shall provide a clearance of at least ½ inch (produced by inserting and removing a spacer strip) between the two surfaces. The Contractor shall ensure that the surfaces are precisely parallel to prevent any wedging from expansion and contraction.

All poured rubber joint sealer (and any required primer) shall conform with Section 9-04.2(2).

6-02.3(13)A Strip Seal Expansion Joint System

The Contractor shall submit Type 2 Working Drawings consisting of the strip seal expansion joint shop drawings. These plans shall include, at a minimum, the following:

1. Plan, elevation, and sections of the joint system and all components, with dimensions and tolerances.
2. All material designations.
3. Manufacturer's written installation procedure. The installation procedure shall indicate how the extrusions set into the two sides of the joint will be allowed to move independently of one another.
4. Corrosion protection system used on the metal components.
5. Locations of welded shear studs, lifting mechanisms, temperature setting devices, and construction adjustment devices.
6. Method of sealing the system to prevent leakage of water through the joint.
7. Details of the temporary supports for the steel extrusions while the encapsulating concrete of the headers is placed and cured.
8. The gland installation procedure, including the means and methods used to install the gland and assure correct seating of the gland within the steel extrusions.

The strip seal shall be removable and replaceable.

The metal components shall conform to ASTM A36, ASTM A992, or ASTM A572, and shall be protected against corrosion by one of the following methods:

1. Zinc metallized in accordance with Section 6-07.3(14).
2. Hot-dip galvanized in accordance with AASHTO M111.
3. Paint in accordance with Section 6-07.3(9). The color of the top coat shall be SAE AMS Standard 595 Color No. 26357. The surfaces embedded in concrete shall be painted only with a shop primer coat of paint conforming to Section 9-08.1(2)C.

If the gland is installed in the field, the Contractor shall have the services of a strip seal expansion joint system manufacturer's technical representative physically present at the job site. The manufacturer's technical representative shall train the Contractor's personnel performing the field installation of the gland, provide technical assistance for installing the gland, and observe and inspect the installation of at least the first complete joint.

The strip seal gland shall be continuous for the full length of the joint with no splices permitted, unless otherwise shown in the Plans.

Other than items shown in the Plans, threaded studs used for construction adjustments are the only items that may be welded to the steel shapes provided they are removed by grinding after use, and the area repaired by application of an accepted corrosion protection system.

After the expansion joint system is installed, a watertightness test shall be performed as follows. The Contractor shall flood each completely installed expansion joint system with water to a minimum depth of three inches for a duration of at least one hour. If leakage is observed, the expansion joint system shall be repaired at no additional expense to the Contracting Agency, as recommended by the manufacturer. After repairs are completed, the expansion joint shall be retested for leakage.

6-02.3(13)B Compression Seal Expansion Joint System

Compression seal glands shall conform to Section 9-04.1(4) and be sized as shown in the Plans.

The compression seal expansion joint system shall be installed in accordance with the manufacturer's written recommendations. The Contractor shall submit a Type 1 Working Drawing consisting of the manufacturer's written installation procedure and repair procedures if leakage testing fails.

After the expansion joint system is installed, a watertightness test shall be performed as follows. The Contractor shall flood each completely installed expansion joint system with water to a minimum depth of three inches for a duration of at least one hour. If leakage is observed, the expansion joint system shall be repaired at no additional expense to the Contracting Agency, as recommended by the manufacturer. After repairs are completed, the expansion joint shall be retested for leakage.

6-02.3(13)C Modular Expansion Joint System

The Contractor shall design, fabricate, inspect, test, and install a modular, multiple seal expansion joint system in accordance with the geometry and movements shown and specified in the Plans. The modular expansion joint system shall extend continuously across the full width of the bridge deck and up into the traffic barriers as shown in the Plans.

6-02.3(13)C1 Acceptable Manufacturers

Only manufacturers whose modular expansion joint systems have met the requirements specified in Section 6-02.3(13)C9 will be permitted to supply modular expansion joint systems. Any testing required to establish the fatigue resistance of all details of a specific proprietary system shall be completed prior to the Contract award date. All fatigue testing shall be conducted in accordance with Sections 6-02.3(13)C11, 6-02.3(13)C23, and 6-02.3(13)C26. Testing shall be completed on any revised details or material substitutions of a previously prequalified system prior to the Contract award date.

Manufacturers known to have met the requirements of Section 6-02.3(13)C9 are specified in Section 6-02.3(13)C as supplemented in the Special Provisions.

6-02.3(13)C2 Submittals

The expansion joint manufacturer shall have at least three years of experience in designing and manufacturing modular expansion joint systems. The Contractor shall submit a Type 1 Working Drawing consisting of written certification of the manufacturer's experience, including the location of each bridge, installation date, governmental agency/owner, and the name, address, and telephone number of each owner's/ agency's representative.

The Contractor shall submit the name of the selected expansion joint system manufacturer to the Engineer within 10 days of Contract award. Once the name of the manufacturer has been submitted to the Engineer, the Contractor shall not select an alternative expansion joint system manufacturer unless the manufacturer demonstrates an inability to meet the requirements of Section 6-02.3(13)C.

The Contractor shall submit Type 3E Working Drawings consisting of shop drawings and design calculations delineating the expansion joint system in accordance with Sections 1-05.3 and 6-03.3(7) and as noted herein. The Professional Engineer responsible for preparing and stamping the submittal shall be an employee of the expansion joint system manufacturer, and shall hold a valid license in the branch of Civil or Structural Engineering, either in the State of Washington or another state. These submittals shall include, at a minimum, the following:

1. Plan, elevation, and section of the joint system for each movement rating and bridge deck width. All dimensions and tolerances shall be specified.
2. Sections showing all materials composing the expansion joint system with complete details of all individual components including all bolted and welded splices and connections.
3. All ASTM, AASHTO, or other material designations.
4. Installation plan including sequence, lifting mechanisms and locations, details of temporary anchorage during setting, temperature adjustment devices, opening dimensions relative to temperature, installation details at curbs, and seal installation details.
5. Plan for achieving watertightness including details related to performing the watertightness test required in Section 6-02.3(13)C32.
6. Details and material designations pertinent to the corrosion protection system.
7. Requirements and details related to the temporary support of the joint system for shipping, handling, and job site storage.
8. Design calculations for all structural elements including all springs and bearings. The design calculations shall include fatigue design for all structural elements, connections, and splices.
9. Welding procedures in compliance with the current AASHTO/AWS D1.5 Bridge Welding Code.

10. A written maintenance and part replacement plan to facilitate replacement of parts subject to wear. This plan shall include a list of parts, instructions for maintenance inspection, acceptable wear tolerances, methods for determining wear, procedures for replacing worn parts, and procedures for replacing seals.
11. Comprehensive integrated details of the expansion joint system, its support boxes, assembly supports, erection aids, and the bridge deck and expansion joint header steel reinforcing bars. The Contractor shall identify in the integrated details any modifications to the bridge deck steel reinforcing bars necessary to accommodate the expansion joint system. The Contractor shall show, in the integrated details, the specific means (moving, bending, cutting, bundling, supplementing or coupling steel reinforcing bars, or incorporating hooks or headed steel reinforcing bars) to address congestion and conflicts.
12. Means, methods, and concrete placement sequence for placing concrete and attaining full consolidation of concrete beneath and adjacent to the support boxes of the modular expansion joint assembly. The methods and sequence shall account for congestion surrounding the box sections due to bridge deck steel reinforcing bars, and expansion joint assembly supports and erection aids.

At the time of shop plan submittal as outlined above, the Contractor shall submit Type 1 Working Drawings consisting of the following documentation:

1. Documentation that the manufacturer is certified through the AISC Quality Certification Program under the category Bridge and Highway Metal Components.
2. Documentation that welding inspection personnel are qualified and certified as welding inspectors under AWS QC1, Standard for Qualification and Certification of Welding Inspectors.
3. Documentation that personnel performing nondestructive testing (NDT) are qualified and certified as NDT Level II under the American Society for Nondestructive Testing (ASNT) Recommended Practice SNT-TC-1a.

The Contractor shall submit Type 1 Working Drawings consisting of the following test reports and certificates of compliance:

1. Manufacturer's certificate of compliance for all polytetrafluorethylene (PTFE) sheeting, PTFE fabric, and elastomer.
2. Certified mill test reports for all steel and stainless steel in the expansion joint system assemblies.
3. Certified test reports confirming that the springs and bearings meet the design load requirements.

Upon completion of installation, the Contractor shall submit a Type 1 Working Drawing consisting of certification stating that each expansion joint system was installed in accordance with the shop plan installation procedure. This certification shall conform to the requirements specified in Section 6-02.3(13)C32.

The Contractor shall submit Type 2E Working Drawings consisting of a temporary bridging method for each expansion joint system over which construction traffic is anticipated to cross following its installation. This submittal shall conform to the requirements specified in Section 6-02.3(13)C32.

The Contractor shall submit Type 1 Working Drawings consisting of a Quality Assurance Inspection program performed by an independent inspection agency provided by the manufacturer. The name of the independent inspection agency, details of the proposed quality assurance inspection program including inspection frequency, and all applicable reporting forms shall be included in the Type 1 Working Drawing submittal.

Modular expansion joint assembly warranties and guarantees provided by the manufacturer in accordance with Section 1-05.10 shall be submitted as Type 1 Working Drawings.

6-02.3(13)C3 General Design Requirements

The expansion joint system shall be designed and detailed with adequate access to all internal components in order to assure the feasibility of inspection and maintenance activities.

The expansion joint system shall be designed and detailed to minimize concrete cracking above the support boxes. Measures taken shall include, but not be limited to, assuring adequate support box top plate thickness, specifying any additional bridge deck steel reinforcement required, and providing adequate concrete cover.

The expansion joint system and bridge deck steel reinforcement shall be detailed to assure that adequate concrete consolidation can be achieved underneath all support boxes.

The expansion joint seals shall not protrude above the top of the expansion joint system under any service condition. Split extrusions may be used at curb upturns.

The elastomeric or urethane springs and bearings shall be designed to be removable and replaceable. The removal and reinstallation of each strip seal shall be easily accomplished from above the joint with a 1-1/4 inch minimum gap width. These operations shall be viable with a one lane partial closure of the bridge deck.

The expansion joint system shall be designed and detailed to be watertight.

The expansion joint system shall be designed and detailed to accommodate all movements specified in the Plans.

The expansion joint shall be designed and detailed to mitigate the potential for fatigue damage wherever centerbeam field splices are required. Consideration shall be given to reducing support box spacing and optimizing splice location between adjacent support boxes in order to minimize fatigue stress range at field splices.

6-02.3(13)C4 Design Axle Loads and Impact Factors

The centerbeams, support bars, bearings, connections, and other structural components shall be designed for the simultaneous application of vertical and horizontal loads from a tandem axle. The tandem axle shall consist of a pair of axles spaced four feet apart with vertical and horizontal loads as specified in Section 6-02.3(13)C as supplemented in the Special Provisions. The transverse spacing of the wheels shall be six feet. The distribution of the wheel load among centerbeams shall be as specified in Section 6-02.3(13)C5.

6-02.3(13)C5 Distribution of Wheel Loads

The following table specifies the centerbeam distribution factor as a function of centerbeam top flange width. This factor is the percentage of the design vertical axle load and the design horizontal axle load which shall be applied to an individual centerbeam for the design of that centerbeam and its associated support bars. Distribution factors shall be interpolated for centerbeam top flange widths between those explicitly denoted in the table. In no case shall the distribution factor be taken as less than 50%. The remainder of the load shall be divided equally and applied to the two adjacent centerbeams or edge beams.

Width of Centerbeam Top Flange	Distribution Factor
2.5 inches	50%
3.0 inches	60%
4.0 inches	70%
4.75 inches	80%

6-02.3(13)C6 Fatigue Limit State Design Requirements

Modular expansion joint system structural members, bolted and welded splices and connections, and attachments shall be designed to resist the Fatigue Limit State load combination specified in Table 3.4.1-1 of the AASHTO LRFD Bridge Design Specifications. The vertical and horizontal load ranges specified in Section 6-02.3(13)C4 shall be applied simultaneously. These loads shall be distributed as specified in Section 6-02.3(13)C5.

The nominal stress ranges, Δf, at all fatigue critical details shall be obtained from a structural analysis of the expansion joint system applying the design vertical and horizontal load ranges specified in Section 6-02.3(13)C4 and distributed as specified in Section 6-02.3(13)C5. The expansion joint system shall be analyzed with a minimum gap opening corresponding to the midrange configuration (at least half of the maximum gap opening). The design axle load shall be applied as two wheel loads, each having a transverse width of 20 inches.

For each detail under consideration, the wheel loads shall be positioned transversely on a centerbeam to achieve the maximum nominal stress range at that detail. The vertical and horizontal wheel loads shall be applied as line loads to the top of the centerbeams at their centerlines. The design stress range in the centerbeam-to-support bar connection shall be calculated as specified below. The design nominal stress ranges, Δf, multiplied

by the appropriate load factors in Table 3.4.1-1 of the AASHTO LRFD Bridge Design Specifications, shall be used for fatigue design as specified at the end of this subsection.

6-02.3(13)C7 Welded or Bolted Single-Support-Bar Systems

The nominal stress range, Δf, in the centerbeam at a welded or bolted stirrup shall be the sum of the longitudinal bending stress ranges at the critical section resulting from vertical and horizontal loading. The effects of stresses in any load-bearing attachments such as the stirrup or yoke shall not be considered when calculating the longitudinal stress range in the centerbeam. For bolted single-support-bar systems, stress ranges shall be calculated using the net section.

The nominal stress range, Δf, in the stirrup or yoke shall be calculated without considering the effects of stresses in the centerbeam. The stress range shall be calculated by assuming a load range in the stirrup equal to 30% of the total vertical reaction force between the centerbeam and the support bar. The effects of horizontal loads may be neglected in the design of the stirrup.

6-02.3(13)C8 Welded Multiple-Support-Bar Systems

Three locations have been identified as initiation sites for fatigue cracking at a centerbeam-to-support bar welded connection. The types of cracking associated with these three locations are described below. The corresponding equations may be used to calculate the nominal stress range, Δf. For the support bar, either the reduced moment at the critical cross section or the moment at the centerline of the connection may be used in these equations.

Centerbeam weld toe cracking is driven by a combination of longitudinal bending stress range, S_{RB}, in the centerbeam, and vertical stress range, S_{RZ}, at the top of the connection weld.

The longitudinal bending stress range, S_{RB}, at the bottom of the centerbeam shall be calculated as:

$$S_{RB} \equiv M_{Vcb} / S_{Xcb} + M_{Hcb} / S_{Ycb}$$

The vertical stress range, S_{RZ}, at the top of the connection weld shall be calculated as:

$$S_{RZ} \equiv R_H \cdot d_{cb} / S_{Wtop} + R_V / A_{Wtop}$$

Support bar weld toe cracking is driven by a combination of longitudinal bending stress range, S_{RB}, in the support bar and vertical stress range, S_{RZ}, at the bottom of the connection weld.

The longitudinal bending stress range, S_{RB}, at the top of the support bar shall be calculated as:

$$S_{RB} \equiv M_{Vsb} / S_{Xsb} + 0.5 \cdot R_H \cdot (d_{cb} + h_W + 0.5 \cdot d_{sb}) / S_{Xsb}$$

The vertical stress range, S_{RZ}, at the bottom of the connection weld shall be calculated as:

$$S_{RZ} \equiv R_H \cdot (d_{cb} + h_W) / S_{wbot} + R_V / A_{Wbot}$$

Weld throat cracking is driven by a vertical stress range at the weld throat.

The vertical stress range, S_{RZ}, at mid-height of the connection weld shall be calculated as:

$$S_{RZ} \equiv R_V / A_{wmid} + R_H \cdot (d_{cb} + 0.5 \cdot h_W) / S_{Wmid}$$

In the above equations:

R_V	≡	vertical reaction at the connection weld
R_H	≡	horizontal reaction at the connection weld
M_{Vcb}	≡	bending moment in the centerbeam due to applied vertical forces
M_{Hcb}	≡	bending moment in the centerbeam due to applied horizontal forces
M_{Vsb}	≡	bending moment in the support bar due to applied vertical forces
S_{Xcb}	≡	section modulus at bottom of the centerbeam about horizontal axis
S_{Ycb}	≡	section modulus of the centerbeam about vertical axis
S_{Xsb}	≡	section modulus at top of the support bar about horizontal axis
A_{Wtop}	≡	area of the weld at the top of the connection
A_{Wmid}	≡	area of the weld at the middle of the connection
A_{Wbot}	≡	area of the weld at the bottom of the connection
S_{Wtop}	≡	section modulus of the weld at the top of the connection
S_{Wmid}	≡	section modulus of the weld at the middle of the connection
S_{Wbot}	≡	section modulus of the weld at the bottom of the connection
h_W	≡	height of the weld
d_{cb}	≡	depth of the centerbeam
d_{sb}	≡	depth of the support bar

The nominal stress range, Δf, at welded multiple-support-bar connection details shall be calculated for each case above as follows:

$$\Delta f \equiv (S^2_{RB} + S^2_{RZ})^{1/2}$$

Where:

S_{RB}	≡	longitudinal stress range in the centerbeam or support bar, as calculated for each specific case above.
S_{RZ}	≡	vertical stress range in the centerbeam-to-support bar connection weld, as calculated for each specific case above.

All modular expansion joint system structural members, connections (bolted and welded), splices, and attachments shall satisfy the following:

$$\gamma \Delta f \equiv (\Delta F)_{TH}$$

Where:

γ	≡	the load factor for the Fatigue I Limit State, as stipulated in Table 3.4.1-1 of the AASHTO LRFD Bridge Design Specifications.
Δf	≡	the nominal stress range as specified at the beginning of this subsection.
$(\Delta F)_{TH}$	≡	constant amplitude fatigue threshold (CAFL) as specified in Section 6-02.3(13)C9.

6-02.3(13)C9 Fatigue Resistance Characterization Requirements

The fatigue resistance of all details shall be characterized in terms of the detail categories specified in Table 6.6.1.2.5-1 of the AASHTO LRFD Bridge Design Specifications.

Many details composing modular expansion joint systems may clearly correspond to specific structural details depicted in Figure 6.6.1.2.3-1 of the AASHTO LRFD Bridge Design Specifications. In these cases, the applicable fatigue categories specified in Table 6.6.1.2.3-1 may be used for design.

In cases where the Engineer establishes that a detail does not clearly correspond to a structural detail depicted in Figure 6.6.1.2.3-1, fatigue testing of specimens exhibiting that detail shall be conducted, in accordance with Sections 6-02.3(13)C11, 6-02.3(13)C23, and 6-02.3(13)C26, to establish the appropriate constant amplitude fatigue limit (CAFL) for that detail.

6-02.3(13)C10 Strength I Limit State Design Requirements

Modular expansion joint system structural steel members, connections (bolted and welded), splices, and attachments shall be designed to resist the Strength I Limit State load combination specified in Table 3.4.1-1 of the AASHTO LRFD Bridge Design Specifications. The vertical and horizontal loads specified in Section 6-02.3(13)C4 shall be applied simultaneously. These loads shall be distributed as specified in Section 6-02.3(13)C5.

6-02.3(13)C11 Fatigue Testing of Metallic Structural Components and Connections

This test procedure is acceptable for, and specifically applicable to, establishing the fatigue resistance of the centerbeam-to-support bar connection in modular expansion joint systems. It is applicable to single-support-bar and multiple-support-bar systems having either welded or bolted centerbeam-to-support bar connections. The same methodology may be applied to establish the fatigue resistance of other modular expansion joint metallic structural component details, including centerbeam splices.

Each fatigue test generates a discrete datum. Each datum comprises an applied constant amplitude nominal stress range, S_r, and the corresponding number of cycles, N, associated with either a predetermined extent of crack propagation, defined as failure, or with termination of the test, defined as runout. Ten data shall be acquired for each connection detail. All data shall be in the very long life range, corresponding as closely to the constant amplitude fatigue limit (CAFL) as practical. Specifically, the number of cycles, N, associated with each datum, shall be no less than one order of magnitude less than Nmin corresponding to the detail category specific CAFL specified in Section 6-02.3(13)C19. For example, to characterize a detail as Detail Category C, the tested number of cycles, N, shall exceed 4.4 x 105 for each datum.

The constant amplitude nominal stress range shall be calculated at the anticipated initiation location of an incipient crack. Nominal stresses shall be calculated using conventional equations for analyzing bending and axial load. These equations are essentially the same as those used in strength design. The stress concentration effects of a weld, bolt hole, or other local features are not explicitly embodied in the conventional nominal stress equations.

The appropriate AASHTO detail category applicable to fatigue design shall be established by comparing acquired test data to fatigue resistance graphs representing the AASHTO detail categories. The constant amplitude fatigue limit (CAFL) applicable to fatigue design corresponds to the AASHTO detail category fatigue resistance graph representing a lower bound of the experimentally acquired data.

When testing is conducted exclusively in the infinite life regime and more stringent test data scatter requirements are satisfied, a unique CAFL (different from those CAFL corresponding to specific detail categories specified by AASHTO) may be established for fatigue design.

Specimens selected for testing shall be full-scale centerbeam and support bar assemblies or subassemblies representative of those installed in field applications. A subassembly is defined as a specimen having the same physical and geometric properties as an assembly but having a reduced number of centerbeams.

Each specimen shall consist of three continuous centerbeam spans over four equally spaced support bars. Centerbeam spans between adjacent support bar centerlines shall be a minimum of 3’-0” and a maximum of 4’-6”. Support bar spans shall be a minimum of 3’-0” and a maximum of 3’-8”. The centerbeam-to-support bar connection being tested shall be located at the midspan of each support bar.

Any welded or bolted attachments used to secure equidistant springs to a support bar, centerbeam, or stirrup shall be fabricated as an integral part of the specimen. A rigid load path to the test fixture shall be provided to resist any horizontal forces or displacements which would normally be resisted through these attachments in a field installation. Any miscellaneous welded or bolted attachments, including welded attachments used to secure the expansion joint strip seals to the centerbeams, shall also be fabricated as integral parts of the specimen.

Support bars of subassembly specimens that are components of single-support-bar swivel-joist type modular expansion joint systems shall be oriented perpendicular to the longitudinal axis of the centerbeam.

Prior to testing, each specimen shall be visually inspected for any defects, loose fasteners or other aberrations which could plausibly affect the tested fatigue resistance. Defects and flaws shall be defined in accordance with the appropriate governing specification (ASTM A6, AWS D1.5, etc.). Data acquired from specimens containing such anomalies shall not be excluded from consideration except as permitted in Section 6-02.3(13)C20. Any observed anomaly shall also be reported with its corresponding data in the tabular format stipulated in Section 6-02.3(13)C22.

Each specimen shall be sufficiently instrumented to measure the static nominal strain range within that specimen for a specific applied load range. Best results can generally be obtained when the applied load range for the static calibration tests does not pass through zero load. Strain measurements shall be made at locations sufficiently distant from local effects, such as weld toes or bolt holes, which could significantly influence acquired test data.

As a minimum, eight strain gages shall be installed on the centerbeam top flange in the vicinity of each centerbeam-to-support bar connection. These gages shall be installed in pairs on each side of the connection at distances of one and two times the depth of the centerbeam from the centerline of the connection. Each pair of strain gages shall be located symmetrically about the centerline of the centerbeam. As a minimum, two strain gages shall also be installed on the support bar bottom flange in the vicinity of each centerbeam-to-support bar connection. One of these strain gages shall be installed on each side of the connection at a distance equal to the depth of the support bar from the centerline of the connection. These strain gages shall be installed along the centerline of the support bar.

6-02.3(13)C12 Fatigue Testing Test Fixtures

Test fixtures shall have the capability to adequately support and secure the specimen throughout the duration of the test. The fixture shall be designed and fabricated to such tolerances as required to assure that additional stresses will not be generated in the specimen as a consequence of fixture misalignment. Mismatches resulting from specimen fabrication errors shall be accommodated by shimming or other such means precluding the application of force to the specimen.

Typical elastomeric bearings and springs used to transfer vertical loads from the support bars to the support boxes may be replaced with steel bearings in the test fixture. This modification will enable fatigue testing at higher load ranges and different frequencies than those encountered during normal service conditions.

Load shall be applied through two 10 inch long patches. Each patch shall typically comprise a steel plate and a hard rubber bearing pad placed in contact with the bottom flange of the centerbeam. Each patch shall be located at midspan of each outer span.

In order to assure adequate seating of the specimen to the test fixture, a minimum of 10 kips shall be applied at each patch location. This requirement is waived for tests of single support bar systems conducted using load reversal. Once this load has been applied, all strain measuring devices shall be rebalanced to zero strain while the preload is maintained. An additional load approximately equivalent to the calculated load range shall be applied. Strain ranges shall be measured for the load range from 10 kips to the peak load. Each static calibration test shall be repeated three times while still maintaining a minimum 10 kips load at each load patch. The measured strain ranges from each repetition should vary by no more than 25% from the mean value. If the stress ranges are not repeatable, appropriate modifications shall be made to the test fixture.

6-02.3(13)C13 Static Calibration Test

Prior to any fatigue resistance testing, a static calibration test shall be performed in order to validate the structural analysis model. The static calibration test shall be performed after attainment of stress range repeatability as described in Section 6-02.3(13)C12. The structural analysis model shall be considered validated when calculated strain ranges are within ±25% of the measured strain ranges at every strain gage location.

For the purpose of reporting nominal fatigue resistance stress ranges at specific details, stress ranges determined through structural analysis of the model shall be preferred over stress ranges acquired directly from test measurements.

6-02.3(13)C14 Fatigue Test Procedure

A minimum of ten data points shall be required to establish the fatigue resistance of each detail. The centerbeam-to-support bar connection shall be considered as a single detail.

Several data points may be obtained from a single specimen by repairing the cracked sections of that specimen and resuming testing. Such repairs shall have minimal effect on the stress ranges at unfailed details still being tested. Data points derived from tests in which a repaired detail cracks again shall be discarded.

All data shall be in the very long life range, corresponding as closely to the constant amplitude fatigue limit as practical, but in no case less than 200,000 cycles. Either finite life regime or infinite life regime testing may be conducted. For infinite life regime testing, the number of cycles, N, associated with each of the ten data shall be at least twice the number of cycles, N_{min}, designated in the table in Section 6-02.3(13)C19.

Loads shall be applied using hydraulic actuators or other similar loading devices. The magnitude of the vertical load range, ΔP_v, shall be maintained and continuously monitored throughout the duration of the test. Vertical and horizontal load ranges shall be applied to the specimen simultaneously. The horizontal load range shall always be equal to 20% of the vertical load range, ΔP_v. This horizontal-to-vertical load ratio may be maintained by inclining the specimen 11.3 degrees with respect to the horizontal plane and applying load through vertically oriented actuators.

For multiple support bar systems, the loading mechanism shall be either exclusively tension or exclusively compression and shall be applied at a constant amplitude at any desired frequency. The applied load range shall be in a direction such that the reaction force between the centerbeam and support bar is always tensile. The load range shall not pass through zero load. Minimum preload shall be maintained throughout the duration of the test.

Single support bar systems may be loaded using the same procedures as those for multiple support bar systems. If premature stirrup failure occurs, an applied load range of 70% compression and 30% tension may be used.

The load ranges used in the test shall not be so large as to alter the observed failure mode from that which would be observed under service conditions. Under no circumstance shall imposed stress exceed the yield stress of the material in any portion of the specimen. Each specimen shall be tested using at least two different load (stress) ranges.

If infinite life regime testing is conducted, the first load range should be chosen so that the applied stress range is just above the postulated CAFL. The load range in the subsequent test shall be decreased if failure resulted and increased if the test resulted in a runout. A suggested increment in load is such that the stress range is increased or decreased by 2 ksi. The applicable CAFL shall be selected from those CAFL values corresponding to the AASHTO fatigue categories. The selected CAFL is the one just below the lowest stress range that resulted in cracking.

6-02.3(13)C15 Fatigue Test Failure Criteria

Failure in welded centerbeam-to-support bar connection specimens includes the following:

Centerbeam weld toe cracking originates at or near the centerbeam weld toe, propagates up into the centerbeam at some angle, and grows back over the connection. These cracks typically grow at an angle of about 45 degrees. A specimen shall be considered as failed due to this type of cracking when the crack has grown on any vertical face a length from the point of origin equal to half of the centerbeam depth.

Support bar weld toe cracking originates at or near the support bar weld toe, propagates down into the support bar, and grows back under the connection at some angle, typically about 45 degrees. A specimen shall be considered as failed due to this type of cracking when the crack has grown on any vertical support bar face a length from the point of origin equal to half of the depth of the support bar.

Weld throat cracking originates in the weld throat and typically grows in a plane parallel to the longitudinal axis of the support bar at about mid-depth of the weld throat. A specimen shall be considered as failed due to this type of cracking when a complete fracture of the weld throat has occurred. These cracks have been observed to turn down into the support bar, but only after significant growth. In such instances, the criteria for support bar weld toe cracking shall be applied.

A welded stirrup connection specimen shall be considered as failed when cracks result in the complete fracture of any stirrup leg or when cracks originating at or near a stirrup weld have grown into any face of the centerbeam a length from the stirrup weld toe equal to half of the centerbeam depth.

A bolted centerbeam-to-support bar connection specimen shall be considered as failed when:

1. Fatigue cracks which have grown out of a bolt hole have resulted in the complete fracture of the tension flange of the centerbeam.
2. Fatigue cracks which have grown out of a bolt hole have extended into any face of the centerbeam web a distance equivalent to half of the centerbeam depth less the centerbeam flange thickness.
3. Any portion of a stirrup fractures completely.
4. Any single bolt fractures completely.

6-02.3(13)C16 Alternate Criteria for Termination of a Finite Life Regime Fatigue Test

A test may also be terminated when, for a given stress range, the specimen has survived the number of cycles required to plot the data above either a particular fatigue resistance curve or the maximum permitted in Section 6-02.3(13)C20. For example, if the applied stress range is 17 ksi and the desired fatigue resistance curve is Category C, then based upon the equation presented in Section 6-02.3(13)C19, the test may be terminated after application of about 900,000 cycles provided that the specimen has not failed based on the above described criteria.

6-02.3(13)C17 Nominal Stress Range for Welded Centerbeam-to-Support Bar Systems

The nominal stress range for centerbeam weld toe cracking shall be calculated by taking the square root of the sum of the squares of the longitudinal bending stress range in the centerbeam and the vertical stress range at the top of the weld.

The nominal stress range for support bar weld toe cracking shall be calculated by taking the square root of the sum of the squares of the longitudinal bending stress range in the support bar and the vertical stress range at the bottom of the weld.

The nominal stress range for weld throat cracking shall be the calculated vertical stress range in the throat of the weld.

The nominal stress range in the centerbeam at a welded stirrup shall be calculated as the summation of the longitudinal bending stress ranges at the critical section resulting from vertical and horizontal loading. The entire load range shall be used in the calculation, even if the loading is partly in compression. The effects of stresses in any load-bearing attachments such as the stirrup or yoke shall not be considered when calculating the nominal stress range in the centerbeam.

The load range in the stirrup itself shall be taken as 30% of the total vertical load range carried through the connection. The effect of horizontal forces may be neglected.

6-02.3(13)C18 Nominal Stress Range for Bolted Centerbeam-to-Support Bar Systems

The nominal stress range in the centerbeam shall be taken as the summation of the longitudinal bending stress ranges in the centerbeam resulting from vertical and horizontal loading. Nominal stress ranges shall be calculated using the net section. The effects of stresses in the stirrup shall not be considered when calculating the nominal stress range in the centerbeam.

The nominal load range in the bolt group and the stirrup assembly shall be taken as 30% of the total vertical load range carried through the connection. The effect of horizontal forces may be neglected.

6-02.3(13)C19 Interpretation of Fatigue Test Data

The experimentally acquired data and graphs representing the fatigue resistance of the detail categories delineated in Section 6.6 of the AASHTO LRFD Bridge Design Specifications, shall be juxtaposed on a log-log scale. The equation representing the finite life fatigue resistance of these AASHTO detail categories is:

$$N \equiv A / S^3_{r,eff}$$

Where:

N ≡ number of cycles to failure.

$S_{r,eff}$ ≡ nominal effective stress range representing fatigue resistance.

A ≡ constant defined in Table 6.6.1.2.5-1 of the AASHTO LRFD Bridge Design Specifications.

The minimum number of cycles associated with infinite fatigue life, N_{min}, and the corresponding constant amplitude fatigue limit (CAFL) for each AASHTO detail category is designated in the table below.

Detail Category	N_{min} (infinite fatigue life)	CAFL(ksi)
A	1.8 x 106 cycles	24
B	3.0 x 106 cycles	16
B'	3.5 x 106 cycles	12
C	4.4 x 106 cycles	10
C'	2.5 x 106 cycles	12
D	6.4 x 106 cycles	7.0
E	1.2 x 107 cycles	4.5
E'	2.2 x 107 cycles	2.6

6-02.3(13)C20 Finite Life Regime Testing

The number of cycles, N, to either failure or runout, associated with each of the ten data need not exceed N_{min}, designated in the table in Section 6-02.3(13)C19.

The detail category applicable to fatigue design shall be that corresponding to the highest of the AASHTO detail category fatigue resistance graphs representing a lower bound of all ten experimentally acquired data.

If all but one datum falls above a selected AASHTO S-N curve, that one datum may be discarded and replaced by three new data obtained through additional testing. The additional testing shall be conducted using the same stress range as that of the discarded datum. The three additional data shall be plotted along with the remaining nine data. The applicable detail category shall be that corresponding to the highest of the AASHTO detail category fatigue resistance graphs representing a lower bound of all twelve data, except as limited in the previous table. For any detail, only one datum may be discarded and subsequently replaced with three additional data for any set of ten original data.

The maximum fatigue resistance of any detail shall not exceed that associated with the fatigue category prescribed in the table below.

Type of Detail	Maximum Permitted Category
Welded Multiple Centerbeam-to-Support Bar Connections	C
Weld Stirrup Attachments for Single Support Bar Systems	B
Bolted Stirrup Attachments for Single Support Bar Systems	D
Groove Welded Centerbeam Splices[1]	C
Miscellaneous Welded Connections[2]	C
Miscellaneous Bolted Connections	D

[1]Groove welded full penetration splices may be increased to Category B if weld integrity is verified using non-destructive testing (NDT).

[2]Miscellaneous connections include attachments for equidistant devices.

The fatigue resistance for stirrups welded to a centerbeam flange shall not be taken greater than that defined using the fatigue details defined in Section 6.6 of the AASHTO LRFD Bridge Design Specifications. The applicable fatigue detail for the centerbeam flange and for the stirrup shall be either a “Longitudinally Loaded Groove-Welded Attachment” or a “Longitudinally Loaded Fillet-Welded Attachment”, depending upon the type of connection used.

6-02.3(13)C21 Infinite Life Regime Testing

The applicable constant amplitude fatigue limit (CAFL) for fatigue design may be selected as the highest CAFL of the AASHTO detail categories representing a lower bound to the experimentally acquired data. The CAFL of the AASHTO detail categories are designated in the table in Section 6-02.3(13)C19.

A unique CAFL (different from the CAFL categories delineated in Section 6.6 of the AASHTO LRFD Bridge Design Specifications) may be established if all ten data are within 4 ksi of that unique CAFL.

6-02.3(13)C22 Data Reporting for Fatigue Tests

Fatigue test results and observations shall be reported in the typical S-N format (logarithm (S) vs. logarithm (N)) with the log of the stress range plotted as the ordinate (y-axis). Additionally, the data shall be reported in tabular format. The table shall contain the following information:

1. Nominal stress range at the specific detail, $S_{r,eff}$.
2. Applied load range for each patch.
3. Number of cycles at initial observation of cracking (for reporting purposes only, not included as S-N data).
4. Number of cycles at failure or termination of the test, N, and the reason for stopping the test (failure or termination).
5. Type of crack as described in Section 6-02.3(13)C15. A detailed description of the fatigue crack shall be provided if the observed crack does not resemble any of the crack types described in Section 6-02.3(13)C15.

The following information shall also be reported:

1. Expansion joint system type and manufacturer.
2. Drawings depicting shape, size, and dimensions of the specimen.
3. Drawings depicting fixture details, including specimen orientation.
4. Section properties and dimensions of the centerbeam and support bar.
5. Centerbeam-to-support bar connection details:
    a. Weld procedure specifications for welded expansion joint systems.
    b. Bolt size, material specifications, location, and method of tightening for bolted expansion joint systems.

6-02.3(13)C23 Durability Testing of Elastomeric Support Bearings

This subsection provides guidelines for durability testing of the elastomeric support bearings typically used in modular expansion joint systems as specified In Sections 6-02.3(13)C24 and 6-02.3(13)C25. It is not applicable to compression springs, equidistant springs, or other elastomeric components.

Tests shall be performed dynamically on individual bearings. Fatigue life is evaluated by applying a displacement range to each specimen rather than a load or stress range.

Specimens shall comprise full scale bearing components representative of those installed in field applications. PTFE sliding surfaces or materials typically bonded to the elastomeric support bearings shall be fabricated as an integral part of the specimen.

Prior to testing, each specimen shall be visually inspected for any flaws or defects that could plausibly affect fatigue resistance. Any flaws or details shall be defined and recorded. Data obtained from specimens containing such anomalies shall not be excluded from the data set. Observed anomalies shall also be reported with the test data.

Test fixtures shall have the capability to adequately support and secure the specimen throughout the duration of the test. The fixture shall be designed and fabricated to such tolerances as required to assure that additional stresses will not be generated in the specimen as a consequence of fixture misalignment.

Loads shall be applied through hydraulic actuators or other similar loading devices. Fatigue testing shall be performed using displacement control. Displacement and load ranges shall be continuously monitored throughout the duration of the fatigue test to assure that desired displacement range and minimum preload are maintained.

Load shall be applied to the specimen through flat steel plates that are smooth and free of surface corrosion. These plates shall be sufficiently thick to assure even load distribution to the specimen.

6-02.3(13)C24 Dynamic Stiffness Test

Testing shall be conducted on each specimen to be subjected to fatigue testing in order to establish its dynamic stiffness for at least three different loading frequencies. The maximum of these loading frequencies shall be equal to the service load frequency corresponding to a vehicle traveling at 60 mph. The loading frequency, f, shall be calculated as:

$$f \equiv 0.5 \cdot V / (g + b)$$

where

V	≡	vehicle speed (60 mph at service load)
g	≡	centerbeam gap (assume mid-range configuration)
b	≡	centerbeam width

The load range applied during the dynamic stiffness test shall be that obtained from structural analysis using fatigue wheel load and wheel load distribution factors as specified in Sections 6-02.3(13)C24 and 6-02.3(13)C25.

Each dynamic stiffness test shall be performed three times. Data from individual tests shall be compared to assure consistency of test results.

6-02.3(13)C25 Bearing Fatigue Test

A minimum of three fatigue tests shall be required to establish the durability of each type of bearing.

The fatigue test shall be conducted using displacement control. The displacement (strain) range shall be applied using a sine or other smooth waveform at any frequency less than or equal to the service load frequency calculated in Section 6-02.3(13)C24. The magnitude of the applied displacement amplitude, Δ, shall be calculated as:

$$\Delta \equiv R_v / K$$

where

R_v ≡ vertical reaction force at the support bearing as obtained from structural analysis

K ≡ dynamic stiffness of the support bearing as determined in Section 6-02.3(13)C24

A minimum precompression strain shall be maintained in the specimen throughout the duration of the test. This precompression strain shall be approximately equal to that present in a support bearing in a field installation. The magnitude of the applied cyclic strain shall be at least equal to the precompression strain.

The minimum and maximum dynamic load shall be recorded at the beginning of the test. The minimum and maximum dynamic load shall be monitored and periodically recorded throughout the duration of the test.

At the end of each applied displacement cycle, the displacement shall be held at the precompression level for no less than one half of the period of loading in order to facilitate heat dissipation. Artificial air flow devices (electrical fans) may be used to assist heat dissipation. Excessive heat generation will adversely affect the tested fatigue life.

A specimen shall be accepted as having passed the fatigue test criteria after withstanding 2 million cycles of loading without failure.

The following criteria shall constitute failure:

1. The elastomeric material exhibits excessive deterioration or cracking.
2. The measured minimum dynamic load falls to 30% of the initial dynamic load recorded at test initiation.
3. The measured dynamic load range decreases to half of the initial dynamic load range recorded at test initiation.

Data shall be reported in tabular format and shall contain the following information for each specimen tested:

1. Minimum (precompression) strain, maximum strain, displacement, and load at test initiation.
2. Type of loading impulse (sine wave, ramp, etc.).
3. Number of cycles at initial observation of distress leading to failure (for reporting purposes only, not to be included in the data).
4. Number of cycles at failure.
5. A description of the mode of failure.

The following data shall also be reported for each specimen tested:

1. Bearing type and manufacturer.
2. Drawings depicting shape, size, and dimensions of the specimen including any PTFE sliding surfaces or materials bonded to the specimen.
3. Drawings depicting fixture details, including specimen orientation.

6-02.3(13)C26 Fatigue Testing Laboratory

Fatigue testing shall be performed by an independent testing laboratory. Facilities known to be capable of performing fatigue testing as specified are identified in Section 6-02.3(13)C as supplemented in the Special Provisions.

6-02.3(13)C27 Fabrication

The expansion joint systems shall be fabricated consistent with the details, dimensions, material specifications, and procedures delineated in the shop plans. All fabrication procedures shall be in conformance with the Standard Specifications and the Special Provisions.

All expansion joint systems shall be fabricated by the same manufacturer.

Metallic attachments used to secure elastomeric seals to the centerbeams, if welded to the centerbeams and edge beams, shall be welded continuously along both their top and bottom edges.

All PTFE shall be bonded under controlled conditions and in strict accordance with written instructions provided by the PTFE manufacturer.

All PTFE surfaces shall be smooth and free of bubbles after completion of bonding operations.

All stainless steel sliding surfaces in contact with PTFE shall be polished to a Number 8 mirror finish.

Each stainless steel sheet shall be welded to the steel backing plate in accordance with current AWS specifications. The stainless steel sheet shall be clamped to provide full contact with the steel backing plate during welding. The welds shall not protrude above the sliding surface of the stainless steel sheet.

All steel surfaces, except those surfaces beneath stainless steel sheet, those to be bonded to PTFE, or those in direct contact with strip seals, shall be protected against corrosion by one of the following methods:

1. Zinc metallized in accordance with Section 6-07.3(14).
2. Hot-dip galvanized in accordance with AASHTO M 111.
3. Painted in accordance with Section 6-07.3(9). The color of the final coat, when dry, shall match the color chip SAE AMS Standard 595 Color No. 26357. The surfaces embedded in concrete shall be painted only with a shop coat of inorganic zinc silicate paint.

6-02.3(13)C28 Inspection

Each expansion joint system shall be subjected to and shall pass three levels of inspection in order to be accepted. These three levels are Quality Control Inspection, Quality Assurance Inspection, and Final Inspection. The manufacturer shall provide both Quality Control Inspection and Quality Assurance Inspection. The Contractor shall provide access to the Engineer for the Final Inspection.

Quality control inspection shall be provided by the manufacturer on a full time basis during the fabrication process of all major components to assure that the materials and workmanship meet or exceed the minimum requirements of the contract. Quality control inspection shall be performed by an entity having a line of responsibility distinctly different from that of the manufacturer's fabrication department.

Quality assurance inspection shall be performed by an independent inspection agency provided by the manufacturer. Quality assurance inspection is not required to be full time inspection, but shall be performed during all phases of the manufacturing process.

Final inspection of each expansion joint system will be performed by the Engineer at the job site immediately prior to installation. The Contractor shall provide an accessible work area for this inspection. During final inspection, the Engineer will inspect each expansion joint system for proper alignment, complete bond between expansion joint strip seals and steel components, and proper steel stud placement.

There shall be no bends or kinks in the steel components, except as required to follow bridge deck grades and as specifically detailed on the shop plans. Straightening of unintended bends or kinks will not be permitted. Any expansion joint system exhibiting bends or kinks, other than those shown on the shop plans, shall be removed from the job site and replaced with a new expansion joint system at the expense of the Contractor. Expansion joint strip seals not fully bonded to the steel shall be fully bonded at no additional expense to the Contracting Agency.

Studs will be visually inspected and will be struck lightly with a hammer. Any stud which does not have a complete end weld or does not emit tintinnabulation when struck lightly with a hammer shall be replaced. Any stud located more than one inch, in any direction, from the location specified on the shop plans shall be carefully removed and a new stud shall be welded in the proper location. All stud replacements shall be at no additional expense to the Contracting Agency.

6-02.3(13)C29 Acceptance

Each expansion joint system shall pass all three levels of inspection specified in Section 6-02.3(13)C28 to qualify for acceptance. Any expansion joint system which fails any one of the three levels of inspection shall be replaced or repaired at no expense to the Contracting Agency and to the satisfaction of the Engineer. Any proposed remedial procedures shall be submitted as Type 2E Working Drawings.

The Contractor shall ascertain that the manufacturer has met the fatigue resistance characterization and prequalification requirements of Sections 6-02.3(13)C1 and 6-02.3(13)C2 applicable to the specific expansion joint system being installed. The Contractor shall be responsible for any additional costs and/or time delays associated with selection of an alternative expansion joint system incurred as a result of noncompliance with these requirements, including the failure of the manufacturer to retest revised details or material substitutions of a previously prequalified system.

6-02.3(13)C30 Shipping and Handling

The expansion joint system shall be delivered to the job site and stored in accordance with the manufacturer's shop plans.

Lifting mechanisms, temperature adjustment devices, and temporary anchorages shall not be welded to the centerbeams or edge beams.

Damage to the expansion joint system during shipping or handling shall be just cause for rejection of the expansion joint system.

Damage to the corrosion protection system shall be repaired to the satisfaction of the Engineer.

6-02.3(13)C31 Pre-Installation Conference

A pre-installation conference shall be held 5 to 10-working days before the scheduled installation of the modular expansion joint assembly. The purpose of the conference shall be to discuss construction procedures, personnel, equipment to be used, methods to address congestion surrounding the assembly due to bridge deck steel reinforcing bars, expansion joint assembly supports and construction aids, and concrete placement and consolidation operations, including specific placement and consolidation surrounding the assembly support boxes. Those attending shall include, at a minimum, the superintendent, foremen in charge of erecting the joint assembly and placing the concrete encapsulating the assembly, and representatives from the modular expansion joint assembly manufacturer.

If the project includes more than one modular expansion joint assembly, and if the Contractor's key personnel change between installation operations, or at the request of the Engineer, additional conferences shall be held before each modular expansion joint assembly installation.

6-02.3(13)C32 Installation

A qualified installation technician shall be present at the job site to assure proper installation of each expansion joint system. This technician shall be a full time employee of the manufacturer of the specific expansion joint system being installed. The Contractor shall comply with all recommendations made by the expansion joint manufacturer's installation technician. Each expansion joint system manufacturer's installation technician shall certify to the Engineer that the manufacturer recommended installation procedures were followed. All certifications to the Engineer shall be in writing and shall be signed and dated by the manufacturer's installation technician.

Each expansion joint system shall be installed in strict accordance with the manufacturer's shop plans under Section 6-02.3(13)C2 and the recommendations of the manufacturer's installation technician. All centerbeam welded field splices shall be performed by a certified welder under the direct supervision of the manufacturer's qualified installation technician as specified above. The weld procedure shall have been submitted by the manufacturer and accepted in accordance with Section 6-02.3(13)C2. The welder shall have been trained and certified for performing those specific welds in accordance with the current AASHTO/AWS D1.5 Bridge Welding Code.

Each permanently installed expansion joint system shall match exactly the finished bridge deck profile and grades.

The Contractor shall exercise care at all times to protect each expansion joint system from damage. The Contractor shall protect concrete blockouts and supporting systems from damage and construction traffic prior to installation of the expansion joint systems. After installation, construction loads shall not be allowed on the expansion joint systems. The Contractor shall submit a Type 2 Working Drawing consisting of a proposed method of bridging over each expansion joint system to accommodate any construction traffic.

Each expansion joint system shall be set to a gap width corresponding to the ambient temperature at the time of setting. This information is specified in the Plans and shall also be specified on the shop plans. Any mechanical devices supplied by the joint system manufacturer, for the purpose of setting the expansion joint system to the proper gap width, will remain the property of the manufacturer. When no longer required, the devices shall be returned to the manufacturer.

All forms and debris that may impede movement of the expansion joint systems shall be removed.

Each expansion joint system shall be tested for watertightness after installation. The Contractor shall flood each completely installed expansion joint system with water to a minimum depth of three inches for a duration of at least one hour. If leakage is observed, the expansion joint system shall be repaired to the satisfaction of the Engineer at the Contractor's expense. The repair procedure shall be prepared by the expansion joint system manufacturer and shall be submitted as a Type 2 Working Drawing. After repairs are completed, the expansion joint shall be retested for leakage.

6-02.3(14) Finishing Concrete Surfaces

All concrete shall show a smooth, dense, uniform surface after the forms are removed. If it is porous, the Contractor shall bear the cost of repairing it. The Contractor shall clean and refinish any stained or discolored surfaces.

Subsections A and B (below) describe two classes of surface finishing.

6-02.3(14)A Class 1 Surface Finish

The Contractor shall apply a Class 1 finish to all surfaces of concrete members to the limits designated in the Contract Plans.

The Contractor shall follow steps 1 through 8 below. When steel forms have been used and when the surface of filled holes matches the texture and color of the area around them, the Contractor may omit steps 3 through 8. To create a Class 1 surface, the Contractor shall:

1. Remove all bolts and all lips and edgings where form members have met;
2. Fill all holes greater than ¼ inch and float to an even, uniform finish with mortar conforming to Section 9-20.4(2) at a 1:2 cement/aggregate ratio;
3. Thoroughly wash the surface of the concrete with water;
4. Brush on a mortar conforming to Section 9-20.4(2) at a 1:1 cement/aggregate ratio, working it well into the small air holes and other crevices in the face of the concrete;
5. Brush on no more mortar than can be finished in 1 day;
6. Rub the mortar off with burlap or a piece of carpet as soon as it takes initial set (before it reaches final set);
7. Fog-spray water over the finish as soon as the mortar paint has reached final set; and
8. Keep the surface damp for at least 2 days.

If the mortar becomes too hard to rub off as described in step 6, the Contractor shall remove it with a Carborundum stone and water. Random grinding is not permitted.

6-02.3(14)B Class 2 Surface Finish

The Contractor shall apply a Class 2 finish to all above-ground surfaces not receiving a Class 1 finish as specified above unless otherwise indicated in the Contract. Surfaces covered with fill do not require a surface finish.

To produce a Class 2 finish, the Contractor shall remove all bolts and all lips and edgings where form members have met and fill all form tie holes.

6-02.3(14)C Pigmented Sealer for Concrete Surfaces

The Contractor shall submit a Type 1 Working Drawing consisting of the pigmented sealer manufacturer's written instructions covering, at a minimum, the following:

1. Surface preparation.
2. Application methods.
3. Requirements for concrete curing prior to sealer application.
4. Temperature, humidity and precipitation limitations for application.
5. Rate of application and number of coats to apply.

All surfaces specified in the Plans to receive pigmented sealer shall receive a Class 2 surface finish (except that concrete barrier surfaces shall be finished in accordance with Section 6-02.3(11)A). The Contractor shall not apply pigmented sealer from a batch greater than 12 months past the initial date of color sample acceptance of that batch by the Engineer.

The pigmented sealer color or colors for specific concrete surfaces shall be as specified in the Special Provisions.

The final appearance shall be even and uniform without blotchiness, streaking or uneven color. Surface finishes deemed unacceptable by the Engineer shall be re-coated in accordance with the manufacturer's recommendations at no additional expense to the Contracting Agency.

For concrete surfaces such as columns, retaining walls, pier walls, abutments, concrete fascia panels, and noise barrier wall panels, the pigmented sealer shall extend to 1 foot below the finish ground line, unless otherwise shown in the Plans.

Pigmented Sealer Materials shall be a product listed in the current WSDOT Qualified Products List (QPL). If the pigmented sealer material is not listed in the current WSDOT QPL, a sample shall be submitted to the State Materials Laboratory in Tumwater for evaluation and acceptance in accordance with Section 9-08.3.

6-02.3(14)D Concrete Surface Finishes Produced by Form Liners

The concrete finishes listed in the table below shall be accomplished by the use of either a form liner selected from the products listed in the WSDOT Qualified Products List (QPL), or a form liner accepted by the the State Bridge and Structures Architect and the Engineer. For acceptance of form liners not listed in the current WSDOT QPL, the Contractor shall submit Type 3 Working Drawings consisting of catalog cuts, other descriptive supporting information and a 2-foot square physical sample of the form liner.

Concrete Finish	Horizontal joints in elastomeric form liners are permitted on surfaces greater than 8 feet in height[1] provided that the minimum form liner panel dimensions are:	
	Height (ft)	Width (ft)
Fractured Basalt Finish	8	2
Fractured Fin Finish	8	8
Fractured Granite Finish	8	8
Variable Depth Random Board Finish	8	8
¾ Inch Random Board Finish	8	8
Ribbed Finish	8	8
Striated Finish	8	8
Ashlar Stone Finish	8	8
Block Finish	8	8
Split Face Finish	8	6
River Rock Finish	4	8
Cascadian Stone Finish	4	8

[1]4 feet in height for River Rock Finish and Cascadian Stone Finish

Variable Depth Random Board Finish shall utilize an elastomeric form liner.

¾ Inch Random Board Finish shall utilize either an elastomeric or a plastic form liner. When specified in Contract documents to use wooden form liners, the concrete surface finish shall be achieved with reusable wooden form liners meeting the requirements of this section and Section 6-02.3(14)D1.

For Cascadian Stone Finish, no partial rocks will be allowed in the finished pattern. Horizontal and vertical joints shall be adjusted as needed.

Form liners shall be placed with the pillars, fins, board lines and faux mortar/other joints normal to grade for barrier applications and vertical for all other applications.

Horizontal and vertical joints in ABS, plastic, or elastomeric form liners shall be spliced in accordance with the manufacturer's printed instructions. The Contractor shall submit a Type 1 Working Drawing consisting of the manufacturer's joint splice instructions.

Horizontal joints in elastomeric form liners are permitted in accordance with the requirements in the table above. Horizontal splicing of ABS and plastic form liners to achieve the required height is not permitted and there shall be no horizontal joints.

Once the forms are removed, the Contractor shall treat the joint areas by patching or light sandblasting as required by the Engineer to ensure that the joints are not visible. The concrete formed with ABS and plastic form liners shall be given a light sandblast to remove the glossy finish.

Form liners shall be cleaned, reconditioned, and repaired before each use. Form liners with repairs, patches, or defects which, in the opinion of the Engineer, would result in adverse effects to the concrete finish shall not be used.

Care shall be taken to ensure uniformity of color throughout the textured surface. A change in form release agent will not be allowed.

All surfaces formed by the form liner shall also receive a Class 2 surface finish. Form ties shall be a type that leaves a clean hole when removed. All spalls and form tie holes shall be filled as specified for a Class 2 surface finish.

6-02.3(14)D1 ¾ Inch Random Board Finish Using Wooden Form Liners

The reusable wooden form liners shall conform to Section 6-02.3(17)J and the texture pattern shown in the Plans. The texture pattern shall be accomplished with ¾ inch thick battens in varying widths applied to the surface of the forms. The edge of all battens shall be sloped 15 degrees to facilitate form removal.

The Contractor shall submit a Type 3 Working Drawing consisting of a concrete panel test section, with the ¾ inch random board texture to be used and based on the pattern shown in the Plans. The test section shall be constructed using the forms and materials intended to construct the permanent structures. The test section shall be composed of two ten foot by ten foot form sections which shall be assembled to make a ten foot by 20 foot concrete surface section, and shall include the wall top treatment, and one horizontal joint treatment.

All cracks, holes, slits, gaps, and apertures in forms shall be plugged and caulked with molding plaster to remain completely watertight and withstand the pressures of concrete placement. Joints between the form units shall be sealed with silicone or latex caulking compound. Butt joints may be sealed with non-absorptive sponge tape. Construction joints and expansion joints shall be incorporated into the pattern of the face treatment.

Forms and form ties shall be designed to permit removal without damaging the finish. Prying against the face of the concrete will not be allowed.

Storage of formwork and form materials shall be in a manner to prevent damage or distortion. Any damage to formwork during placing, removal, or storage shall be repaired by the Contractor at no additional expense to the Contracting Agency.

6-02.3(14)E Exposed Aggregate Finish

6-02.3(14)E1 Submittals

The Contractor shall submit Type 2 Working Drawings consisting of the following items:

1. Written description of the equipment to be used and procedure to be followed in producing the exposed aggregate finish.
2. A copy of the manufacturer's written instructions for applying the retardant coating and the clear sealer.
3. Type of nozzle, nozzle pressure, type and gradation of abrasive, blasting techniques, safety procedures, and containment methods and procedures used with all abrasive blasting and water blasting operations.
4. The method and materials used to collect, contain, and dispose of the concrete surface mortar removed from the finish surface, and the chemical agent residue and abrasives used to remove the concrete surface mortar.
5. For formed applications, a sample panel, equal either to the size of one concrete barrier panel minimum for barrier applications, or a four-foot by eight-foot panel for non-barrier applications, cast in a vertical position on the site and constructed in accordance with the procedure outlined in the Type 2 Working Drawing submittal.

6-02.3(14)E2 Producing Exposed Aggregate Finish

The Contractor shall produce all exposed aggregate concrete in accordance with procedure and equipment outlined in the Type 2 Working Drawing submittal. The exposed aggregate shall achieve the same final effect as demonstrated on the sample panel accepted by the Engineer.

Formwork shall be cleaned, reconditioned, and repaired before each use. Formwork with repairs, patches or defects which, in the opinion of the Engineer, would result in adverse effects to the concrete finish shall not be used.

Forms and form joints shall remain completely watertight. Butt joints and joints between form units used on surfaces which are to receive an exposed aggregate finish shall be tongue and grooved, or splined and shall be sealed with a caulking compound.

As an alternative to using tongue and grooved or splined joints, a closed cell polyvinylchloride foam sealer of 3/16 inch thickness with pressure-sensitive adhesive on one or both sides may be used to seal the butt joints between form units. The foam sealer shall be recessed by an amount such that when the form units are compressed to their final position, the foam sealer will be flush with the face of the form units. Adjacent formwork panels, if used, shall be in line and no offset shall occur between panels.

Forms for the exposed aggregate surface for members not yet supporting loads, including the members own load, may be removed as required to effect the exposed aggregate surface, provided the concrete has a minimum age of twelve hours and is of sufficient

strength and hardness so as not to be damaged by the form removal operations and provided that curing and protection operations are maintained.

Removal of forms on the remaining concrete surfaces shall be in accordance with Section 6-02.3(17)N.

After the forms are stripped, the surface mortar shall be removed from the areas specified to receive the exposed aggregate finish.

The exposed aggregate finish shall be obtained by either one or a combination of the two methods described in Sections 6-02.3(14)E3 and 6-02.3(14)E4 as necessary to provide the specified exposed aggregate finish.

6-02.3(14)E3 Retardant Coating Method

A retardant coating conforming to Section 9-08.3(2)A shall be applied to the formwork where concrete surfaces with exposed aggregate finish are shown in the Plans.

For cast-in-place concrete the retardant shall have an effective life of not less than the length of time required for the Class EA concrete to be in place prior to the removal of forms plus 12 hours.

For slip-formed concrete barrier and horizontal to near-horizontal applications, the retardant shall have an effective life of not less than 24 hours. The Contractor shall remove the surface mortar two to three hours after applying the retardant coating.

Retardant shall be applied in accordance with the manufacturer's instructions to remove the surface mortar.

The sealer and form release agent used on the form shall be compatible with the retardant and shall not react with the retardant to produce an undesirable effect on the exposed aggregate finish. The sealer and form release agent to be used on the form shall be as recommended by the manufacturer of the retardant.

Surface mortar shall be removed using one of the following methods:

1. Light abrasive blasting
2. Washing with water under pressure, avoiding excessive pressure which loosens individual aggregate particles.
3. A combination of both methods.

6-02.3(14)E4 Abrasive Blasting Method

As soon as forms are stripped, the exposed aggregate areas shall be abrasive blasted to remove the surface mortar. For slip-formed concrete barrier and horizontal to near-horizontal applications, this shall be done once the concrete has attained a minimum age of 12 hours and is of sufficient strength and hardness to prevent damage.

Adjacent materials and finishes shall be protected from dust, dirt and other damage during abrasive blasting operations. Corners and edge of patterns shall be carefully blasted using back-up boards to maintain a uniform corner or edge line.

The abrasive blast finishing shall be done in as continuous an operation as possible, utilizing the same work crew to maintain continuity of finish on each surface or area of work.

The type and gradation of abrasive grit used, the type of nozzle, nozzle pressure, and blasting techniques shall be as specified in the Type 2 Working Drawing submittal, and as required to expose the aggregate.

The Contractor shall be responsible for safety of the workers and shall equip each with air-fed helmets. The Contractor shall provide suitable enclosures for the collection of grit and dust from the abrasive blasting operation.

After receiving the Engineer's acceptance of the exposed aggregate finish, a 10 percent muriatic acid wash shall be applied to the exposed aggregate surfaces. Surfaces shall be flushed thoroughly with water following a 5 to 10 minute interaction period between the acid solution and the surface.

All stains and streaks on the exposed aggregate surface shall be removed before applying the clear sealer.

6-02.3(14)E5 Applying Clear Sealer

Two seal coatings of clear sealer conforming to Section 9-08.3(2)B shall be applied to the exposed aggregate surfaces in accordance with the manufacturer's recommended procedure.

6-02.3(14)E6 Containment

When producing exposed aggregate finish on concrete surfaces over water, the Contractor shall exercise care and use suitable means to collect and dispose of abrasives and chemical agents, and the resulting concrete surface mortar debris used in or resulting from the finishing of the exposed aggregate surfaces to prevent their entry into the environment surrounding the Structure.

6-02.3(14)F Permeon Treatment

The Contractor shall apply permeon treatment to all concrete surfaces specified in the Plans to receive permeon treatment. The Contractor shall use SAE AMS Standard 595 Color Number 30219 as the target color. The target color is intended as a reference for hue, and is not intended as a reference for opacity or luster. The Contractor is advised that this target color is based on the concentration formula and application rate identified in the QPL for each product. The concentration formula and application rate for products not listed in the QPL will be determined by the Engineer.

The permeon treatment shall be applied only by personnel approved by the manufacturer to apply the product. The Contractor shall furnish certificates of approval from the manufacturer, for the personnel scheduled to perform the work, to the Engineer prior to beginning the treatment operation.

The concrete shall be cured for the time period recommended by the manufacturer prior to receiving the permeon treatment coating.

The Contractor shall clean and prepare the concrete surfaces in accordance with the recommendations of the manufacturer for the use of the treatment product.

The Contractor shall apply the permeon treatment to the surfaces specified, in accordance with the recommendations of the manufacturer for the use of the treatment product.

The Contractor shall prevent permeon treatment from reaching surfaces not specified to receive the permeon treatment.

The Contractor shall prevent pigmented sealer from reaching surfaces that have received permeon treatment. Should pigmented sealer reach surfaces that have received permeon treatment, the pigmented sealer shall be removed and the permeon treatment repaired in accordance with Section 1-07.13.

6-02.3(15) Date Numerals

Standard date numerals shall be placed where shown in the Plans. The date shall be for the year in which the Structure is completed. When an existing Structure is widened or when traffic barrier is placed on an existing Structure, the date shall be for the year in which the original Structure was completed. Unit Contract prices shall cover all costs relating to these numerals.

6-02.3(16) Plans for Falsework and Formwork

The Contractor shall submit all plans for falsework and formwork as Type 2E Working Drawings. A submittal is not required for footing or retaining wall formwork if the concrete placement is 4 feet or less in height.

The design of falsework and formwork shall be based on:

1. Applied loads and conditions which are no less severe than those described in Section 6-02.3(17)A;
2. Allowable stresses and deflections which are no greater than those described in Section 6-02.3(17)B;
3. Special loads and requirements no less severe than those described in Section 6-02.3(17)C;
4. Conditions required by other Sections of 6-02.3(17).

The falsework and formwork plans shall be scale drawings showing the details of proposed construction, including: sizes and properties of all members and components; spacing of bents, posts, studs, wales, stringers, wedges and bracing; rates of concrete placement, placement sequence, direction of placement, and location of construction joints; identification of falsework devices and safe working loads as well as identification of any bolts or threaded rods used with the devices including their diameter, length, type, grade, and required torque. The falsework plans shall show the proximity of falsework to utilities or any nearby Structures including underground Structures. Formwork accessories shall be identified according to Section 6-02.3(17)H. All assumptions, dimensions, material properties, and other data used in making the structural analysis shall be noted on the drawing.

The Contractor shall furnish associated design calculations to the Engineer as part of the submittal. The design calculations shall include the structural and geotechnical design of the foundation and shall show the stresses and deflections in all load-carrying members that are part of the falsework system. Construction details which may be shown in the form of sketches on the calculation sheets shall be shown in the falsework or formwork drawings as well. Falsework or formwork plans will not be accepted in cases where it is necessary to refer to the calculation sheets for information needed for complete understanding of the falsework and formwork plans or how to construct the falsework and formwork.

6-02.3(16)A Vacant

6-02.3(16)B Pre-Contract Review of Falsework and Formwork Plans

The Contractor may request pre-contract review of formwork plans for abutments, wingwalls, diaphragms, retaining walls, columns, girders and beams, box culverts, railings, and bulkheads. Plans for falsework supporting the bridge deck for interior spans between precast prestressed concrete girders may also be submitted for pre-contract review.

To obtain pre-contract review, the Contractor shall electronically submit drawings and design calculations in PDF format directly to: BridgeConstructionSupport@wsdot.wa.gov

The Bridge and Structures Office, Construction Support Engineer will return the falsework or formwork plan to the Contractor with review notes, an effective date of review, and any revisions needed prior to use.

For each contract on which the pre-reviewed falsework or formwork plans will be used, the Contractor shall submit a copy to the Engineer. Construction shall not begin until the Engineer has given concurrence.

If the falsework or formwork being constructed has any deviations to the preapproved falsework or formwork plan, the Contractor shall submit plan revisions for review and approval in accordance with Section 6-02.3(16).

6-02.3(17) Falsework and Formwork

Formwork and falsework are both structural systems. Formwork contains the lateral pressure exerted by concrete placed in the forms. Falsework supports the vertical and/

or the horizontal loads of the formwork, reinforcing steel, concrete, and live loads during construction.

The Contractor shall set falsework, to produce in the finished Structure, the lines and grades indicated in the Contract Plans. The setting of falsework shall allow for shrinkage, settlement, falsework girder camber, and any structural camber the Plans or the Engineer require.

Concrete forms shall be mortar tight, true to the dimensions, lines, and grades of the Structure. Curved surfaces shown in the Contract Plans shall be constructed as curved surfaces and not chorded, except as allowed in Section 6-02.3(17)J. Concrete formwork shall be of sufficient strength and stiffness to prevent overstress and excess deflection as defined in Section 6-02.3(17)B. The rate of depositing concrete in the forms shall not exceed the placement rate in the formwork plan Working Drawing. The interior form shape and dimensions shall also ensure that the finished concrete will conform with the Contract Plans.

If the new Structure is near or part of an existing one, the Contractor shall not use the existing Structure to suspend or support falsework unless the Plans or Special Provisions state otherwise. For prestressed girder and T-beam bridge widenings or stage construction, the bridge deck and the diaphragm forms may be supported from the existing Structure or previous stage, if accepted by the Engineer. For steel plate girder bridge widenings or stage construction, only the bridge deck forms may be supported from the existing Structure or previous stage, if accepted by the Engineer. See Section 6-02.3(17)E for additional conditions.

On bridge decks, forms designed to stay in place made of steel or precast concrete panels shall not be used.

For post-tensioned Structures, both falsework and forms shall be designed to carry the additional loads caused by the post-tensioning operations. The Contractor shall construct supporting falsework in a way that leaves the Superstructure free to contract and lift off the falsework during post-tensioning. Forms that will remain inside box girders to support the placement of the bridge deck concrete shall, by design, resist girder contraction as little as possible. See Section 6-02.3(26) for additional conditions.

6-02.3(17)A Design Loads

The design load for falsework shall consist of the sum of dead and live vertical loads, and a design horizontal load. The minimum total design load for any falsework shall not be less than 100 lbs/sf for combined live and dead load regardless of Structure thickness.

The entire Superstructure cross-section, except traffic barrier, shall be considered to be placed at one time for purposes of determining support requirements and designing falsework girders for their stresses and deflections, except as follows:

For concrete box girder bridges, the girder stems, diaphragms, crossbeams, and connected bottom slabs, if the stem wall is placed more than 5 days prior to the top slab, may be considered to be self supporting between falsework bents at the time the top slab is placed, provided that the distance between falsework bents does

not exceed four times the depth of the portion of the girder placed in the preceding concrete placements.

Falsework bents shall be designed for the entire live load and dead load, including all load transfer that takes place during post-tensioning, and braced for the design horizontal load.

Dead loads shall include the weight of all successive placements of concrete, reinforcing steel, forms and falsework, and all load transfer that takes place during post-tensioning. The weight of concrete with reinforcing steel shall be assumed to be not less than 160 pounds per cubic foot.

Live loads shall consist of a minimum uniform load of not less than 25 psf, applied over the entire falsework plan area, plus the greater of:

1. Actual weights of the deck finishing equipment applied at the rails, or;
2. A minimum load of 75 pounds per linear foot applied at the edge of the bridge deck.

The design horizontal load to be resisted by the falsework bracing system in any direction shall be:

The sum of all identifiable horizontal loads due to equipment, construction sequence, side-sway caused by geometry or eccentric loading conditions, or other causes, and an allowance for wind plus an additional allowance of 1 percent of the total dead load to provide for unexpected forces. In no case shall the design horizontal load be less than 3 percent of the total dead load.

The minimum horizontal load to be allowed for wind on each heavy-duty steel shoring tower having a vertical load carrying capacity exceeding 30 kips per leg shall be the sum of the products of the wind impact area, shape factor, and the applicable wind pressure value for each height zone. The wind impact area is the total projected area of all the elements in the tower face normal to the applied wind. The shape factor for heavy-duty steel shoring towers shall be taken as 2.2. Wind pressure values shall be determined from the following table:

Wind Pressure on Heavy-Duty Steel Shoring Towers		
Height Zone (Feet Above Ground)	Wind Pressure Value	
	Adjacent to Traffic	At Other Locations
0 to 30	20 psf	15 psf
30 to 50	25 psf	20 psf
50 to 100	30 psf	25 psf
Over 100	35 psf	30 psf

The minimum horizontal load to be allowed for wind on all other types of falsework, including falsework girders and forms supported on heavy-duty steel shoring towers, shall be the sum of the products of the wind impact area and the applicable wind pressure value for each height zone. The wind impact area is the gross projected area of the falsework support system, falsework girders, forms and any unrestrained portion of the permanent Structure, excluding the areas between falsework posts or towers

where diagonal bracing is not used. Wind pressure values shall be determined from the following table:

Wind Pressure on All Other Types of Falsework		
Height Zone (Feet Above Ground)	Wind Pressure Value	
	For Members Over and Bents Adjacent to Traffic Openings	At Other Locations
0 to 30	2.0 Q psf	1.5 Q psf
30 to 50	2.5 Q psf	2.0 Q psf
50 to 100	3.0 Q psf	2.5 Q psf
Over 100	3.5 Q psf	3.0 Q psf

The value of Q in the above tabulation shall be determined as follows:

$Q = 1 + 0.2W$; but Q shall not be more than 10.

Where:

W = is the width of the falsework system, in feet, measured normal to the direction of the wind force being considered.

The falsework system shall also be designed so that it will be sufficiently stable to resist overturning prior to the placement of the concrete. The minimum factor of safety against falsework overturning in all directions from the assumed horizontal load for all stages of construction shall be 1.25. If the required resisting moment is less than 1.25 times the overturning moment, the difference shall be resisted by bracing, cable guys, or other means of external support.

Design of falsework shall include the vertical component (whether positive or negative) of bracing loads imposed by the design horizontal load. Design of falsework shall investigate the effects of any horizontal displacement due to stretch of the bracing. This is particularly important when using cable or rod bracing systems.

If the concrete is to be post-tensioned, the falsework shall be designed to support any increased or redistributed loads caused by the prestressing forces.

6-02.3(17)B Allowable Design Stresses and Deflections

The maximum allowable stresses listed in this section are based on the use of identifiable, undamaged, high-quality materials. Stresses shall be appropriately reduced if lesser quality materials are to be used.

These maximum allowable stresses include all adjustment factors, such as the short-term load duration factor. The maximum allowable stresses and deflections used in the design of the falsework and formwork shall be as follows:

6-02.3(17)B1 Deflection

Deflection resulting from dead load and concrete pressure for exposed visible surfaces shall not exceed $1/360$ of the span.

Deflection resulting from dead load and concrete pressure for unexposed non-visible surfaces, including the bottom of the deck slab between girders shall not exceed 1/270 of the span.

In the foregoing, the span length shall be the center line to center line distance between supports for simple and continuous spans, and from the center line of support to the end of the member for cantilever spans. For plywood supported on members wider than 1½ inches, the span length shall be taken as the clear span plus 1½ inches. Also, dead load shall include the weight of all successive placements of concrete, reinforcing steel, forms and falsework self weight. Only the self weight of falsework girders may be excluded from the calculation of the above deflections provided that the falsework girder deflection is compensated for by the installation of camber strips.

Where successive placements of concrete are to act compositely in the completed Structure, deflection control becomes extremely critical. Maximum deflection of supporting members shall not exceed 1/500 of the span for members constructed in several successive placements (such as concrete box girder and concrete T-beam girder Structures). Falsework components shall be sized, positioned, and/or supported to minimize progressive increases in deflection of the Structure which would preload the concrete or reinforcing steel before it becomes fully composite.

6-02.3(17)B2 Timber

Each species and grade of timber/lumber used in constructing falsework and formwork shall be identified in the drawings. The allowable stresses and loads shall not exceed the lesser of stresses and loads given in the table below or factored stresses for designated species and grade in Table 7.3 of the *Timber Construction Manual*, latest edition, by the American Institute of Timber Construction.

Compression perpendicular to the grain reduced to 300 psi for use when moisture content is 19 percent or more (areas exposed to rain, concrete curing water, green lumber).	450 psi
Compression parallel to the grain but not to exceed 1,500 psi.	$\frac{480{,}000 \text{ psi}}{(L/d)^2}$
Flexural stress for members with a nominal depth greater than 8 inches.	1,800 psi
Flexural stress psi for members with a nominal depth of 8 inches or less.	1,500 psi
The maximum horizontal shear.	140 psi
AXIAL tension.	1,200 psi
The maximum modulus of elasticity (E) for timber.	1,600,000 psi

Where:

L is the unsupported length; and

d is the least dimension of a square or rectangular column, or the width of a square of equivalent cross-sectional area for round columns.

The allowable stress for compression perpendicular to the grain, and for horizontal shear shall not be increased by any factors such as short duration loading. Additional requirements are found in other parts of Section 6-02.3(17). Criteria for the design of lumber and timber connections are found in Section 6-02.3(17)I.

Plywood for formwork shall be designed in accordance with the methods and stresses allowed in the *APA Design/Construction Guide for Concrete Forming* as published by the American Plywood Association, Tacoma, Washington. As concrete forming is a special application for plywood, wet stresses shall be used and then adjusted for forming conditions such as duration of load, and experience factors. Concrete pour pressures shall be in accordance with Section 6-02.3(17)J.

6-02.3(17)B3 Steel

For identified grades of steel, design stresses shall not exceed those specified in the *Steel Construction Manual*, latest edition, by the American Institute of Steel Construction, except as follows:

Compression, flexural but not to exceed $0.6F_y$	$\frac{12{,}000{,}000 \text{ psi}}{Ld/bt}$
The modulus of elasticity (E) shall be	29,000,000 psi

When the grade of steel cannot be positively identified as with salvaged steel and if rivets are present, design stresses shall not exceed the following:

Yield point f_y	30,000 psi
Tension, axial, and flexural	16,000 psi
Compression, axial except L/r shall not exceed 120	$14{,}150 - 0.37(KL/r)^2$ psi
Shear on gross section of the web of rolled shapes	9,500 psi
Web crippling for rolled shapes	22,500 psi
Compression, flexural but not to exceed 16,000 psi and L/b not greater than 39	$16{,}000 - 5.2(L/b)^2$ psi
The modulus of elasticity (E) shall be	29,000,000 psi

Where:

- L is the unsupported length;
- d is the least dimension of rectangular columns, or the width of a square of equivalent cross-sectional area for round columns, or the depth of beams;
- b is the flange width;
- t is the thickness of the compression flange;
- r is the radius of gyration of the compression flange about the weak axis of the member; and
- F_y is the specified minimum yield stress, psi, for the grade of steel used.

All dimensions are expressed in inches.

6-02.3(17)C Falsework and Formwork at Special Locations

In addition to the minimum requirements specified in Sections 6-02.3(17)A and 6-02.3(17)B, falsework towers or posts supporting beams directly over Roadways or railroads which are open to traffic or the public shall be designed and constructed so that the falsework will be stable if subjected to impact by vehicles. The use of damaged materials, unidentifiable material, salvaged steel or steel with burned holes or questionable weldments shall not be used for falsework described in this section. For the purposes of this Specification the following public or private facilities shall also be considered as "Roadways": pedestrian pathways and other Structures such as bridges, walls, and buildings.

The dimensions of the clear openings to be provided through the falsework for Roadways, railroads, or pedestrian pathways shall be as specified in the Contract.

Falsework posts or shoring tower systems which support members that cross over a Roadway or railroad shall be considered as adjacent to Roadways or railroads. Other falsework posts or shoring towers shall be considered as adjacent to Roadways or railroads only if the following conditions apply:

1. Located in the row of falsework posts or shoring towers nearest to the Roadway or railroad; and
2. Horizontal distance from the traffic side of the falsework to the edge of pavement is less than the total height of the falsework and forms; or
3. The total height of the falsework and forms is greater than the horizontal clear distance between the base of the falsework and a point 10 feet from the centerline of track.

The Contractor shall provide any additional features for the Work needed to ensure that the falsework will be stable for impact by vehicles; providing adequate safeguards, safety devices, protective equipment, and any other needed actions to protect property and the life, health, and safety of the public; and shall comply with the provisions in Sections 1-07.23 and 6-02.3(17)M. The falsework design at special locations, shall incorporate the minimum requirements detailed in this section, even if protected by concrete median barrier.

The vertical load used for the design of falsework posts and towers which support the portion of the falsework over openings, shall be the greater of the following:

1. 150 percent of the design load calculated in accordance with Section 6-02.3(17)B, but not including any increased or redistributed loads caused by the post-tensioning forces; or
2. 100 percent of the design load plus the increased or redistributed loads caused by the post-tensioning forces.

Each falsework post or each shoring tower leg adjacent to Roadways or railroads shall consist of either steel with a minimum section modulus about each axis of 9.5 inches cubed or sound timbers with a minimum section modulus about each axis of 250 inches cubed.

Each falsework post or shoring tower leg adjacent to Roadways or railroads shall be mechanically connected to its supporting footing at its base, or otherwise laterally restrained, to withstand a force of not less than 2,000 pounds applied at the base of the post or tower leg in any direction except toward the Roadway or railroad track. Posts or tower legs shall be connected to the falsework cap and stringer by mechanical connections capable of resisting a load in any horizontal direction of not less than 1,000 pounds.

For falsework spans over Roadways and railroads, all falsework stringers shall be mechanically connected to the falsework cap or framing. The mechanical connections shall be capable of resisting a load in any direction, including uplift on the stringer, of not less than 500 pounds. All associated connections shall be installed before traffic is allowed to pass beneath the span.

When timber members are used to brace falsework bents which are located adjacent to Roadways or railroads, all connections shall be bolted through the members using ⅝-inch diameter or larger bolts.

Concrete traffic barrier shall be used to protect all falsework adjacent to traveled Roadways. The falsework shall be located so that falsework footings, mudsills, or piles are at least 2 feet clear of the traffic barrier and all other falsework members shall also be at least 2 feet clear of the traffic barrier. Traffic barrier used to protect falsework shall not be fastened, guyed, or blocked to any falsework but shall be fastened to the pavement according to details shown in the Plans. The installation of concrete traffic barrier shall be completed before falsework erection is begun. The traffic barrier at the falsework shall not be removed until allowed by the Engineer. Falsework openings which are provided for the Contractor's own use (not for public use) shall also use concrete traffic barrier to protect the falsework, except the minimum clear distance between the barrier and falsework footings, mudsills, piles, or other falsework members shall be at least 3 inches.

Falsework bents within 20 feet of the center line of a railroad track shall be braced to resist the required horizontal load or 2,000 pounds whichever is greater.

Pedestrian openings through falsework shall be paved or surfaced with full width continuous wood walks which shall be wheel chair accessible and shall be kept clear. Pedestrians shall be protected from falling objects and water falling from construction above. Overhead protection for pedestrians shall extend at least 4 feet beyond the edge of the bridge deck. Plans and details of the overhead protection and pathway shall be submitted with the falsework Working Drawings. Pedestrian openings through falsework shall be illuminated by temporary lighting, constructed and maintained by the Contractor. The temporary lighting shall be constructed in accordance with local electrical code requirements. The temporary lighting shall be steady burning 60-watt, 120-volt lamps with molded waterproof lamp holders spaced at 25-foot centers maximum. All costs relating to pedestrian pathway paving, wood walks, overhead protection, maintenance, operating costs, and temporary pedestrian lighting shall be incidental to applicable adjacent items of Work.

6-02.3(17)D Falsework Support Systems: Foundations, Manufactured Shoring Towers, Caps, and Posts

Foundations for falsework shall be designed for conditions stated in this section using methods shown in the AASHTO Standard Specifications for Highway Bridges Seventeenth Edition – 2002 for allowable stress design, the AASHTO *LRFD Bridge Design Specifications* for load and resistance factor design or the AASHTO *Guide Design Specifications for Bridge Temporary Works*. Allowable stresses for materials shall not exceed stresses and conditions allowed by Section 6-02.3(17)B.

6-02.3(17)D1 Vacant

6-02.3(17)D2 Vacant

6-02.3(17)D3 Bents, Shoring Towers, Piling, Posts, and Caps

Plans for falsework bents or shoring tower systems, including manufactured tower systems shall have plan, cross-section, and elevation view scale drawings showing all geometry. Show in the falsework plans the proximity of falsework to utilities or any nearby Structures including underground Structures. The ground elevation, cross-slopes, relation of stringers to one another, and dimensions to posts or piling shall be shown in the falsework plans. Column, pile, or tower heights shall be indicated. Member sizes, wall thickness and diameter of steel pipe columns or piles shall be shown in the falsework plans. Location of wedges, minimum bearing area and type of wedge material shall be identified in the falsework plans. Bracing size, location, material and all connections shall be described in the falsework plans.

The relationship of the falsework bents or shoring tower systems to the permanent Structure's pier and footing shall be shown. Load paths shall be as direct as possible. Loads shall be applied through the shear centers of all members to avoid torsion and buckling conditions. Where loads cause twisting, biaxial bending, or axial loading with bending, the affected members shall be designed for combined stresses and stability.

Posts or columns shall be constructed plumb with tops and bottoms carefully cut to provide full end bearing. Caps shall be installed at all bents supported by posts or piling unless the falsework Working Drawings specifically permit otherwise. Caps shall be fastened to the piling or posts. The falsework shall be capable of supporting non uniform or localized loading without adverse effect. For example, the loading of cantilevered ends of stringers or caps shall not cause a condition of instability in the adjacent unloaded members.

Timber posts and piling shall be fastened to the caps and mudsills by through-bolted connections, drift pins, or other accepted connections. The minimum diameter of round timber posts shall be shown in the falsework plans. Timber caps and timber mudsills shall be checked for crushing from columns or piling under maximum load.

Steel posts and piling shall be welded or bolted to the caps, and shall be bolted or welded to the foundation. Steel members shall be checked for buckling, web yielding, and web crippling.

Wedges shall be used to permit formwork to be taken up and released uniformly. Wedges shall be oak or close-grained Douglas fir. Cedar wedges or shims shall not be used anywhere in a falsework or forming system. Wedges shall be used at the top or bottom of shores, but not at both top and bottom. After the final adjustment of the shore elevation is complete, the wedges shall be fastened securely to the sill or cap beam. Only one set of wedges (with one optional block) shall be used at one location. Screw jacks (or other allowed devices) shall be used under arches to allow incremental release of the falsework.

Sand jacks may be used to support falsework and are used for falsework lowering only. Sand jacks shall be constructed of steel with snug fitting steel or concrete pistons. Sand jacks shall be filled with dry sand and the jack protected from moisture throughout its use. They shall be designed and installed in such a way to prevent the unintentional migration or loss of sand. All sand jacks shall be tested in accordance with Section 6-02.3(17)G.

When falsework is over or adjacent to Roadways or railroads, all details of the falsework system which contribute to the horizontal stability and resistance to impact shall be installed at the time each element of the falsework is erected and shall remain in place until the falsework is removed. For other requirements see Section 6-02.3(17)C.

Transverse construction joints in the Superstructure shall be supported by falsework at the joint location. The falsework shall be constructed in such a manner that subsequent pours will not produce additional stresses in the concrete already in place.

6-02.3(17)D4 Manufactured Shoring Tower Systems and Devices

Manufactured proprietary shoring tower systems shall be identified in the falsework plans by make and model and safe working load capacity per leg. The safe working load for shoring tower systems shall be based upon a minimum 2½ to 1 factor of safety.

The safe working load capacity, anticipated deflection (or settlement), make and model shall be identified in the falsework plans for manufactured devices such as: single shores, overhang brackets, support bracket and jack assemblies, friction collars and clamps, hangers, saddles, and sand jacks. The safe working load for shop manufactured devices shall be based on a minimum ultimate strength safety factor of 2 to 1. The safe working load for field fabricated devices and all single shores shall be based on a minimum ultimate strength safety factor of 3 to 1.

The safe working load of all devices shall not be exceeded. The design loads shall be as defined by Section 6-02.3(17)A. The maximum allowable free end deflection of deck overhang brackets under working loads applied shall not exceed 3⁄16 inch measured at the edge of the concrete slab regardless of the fact that the deflection may be compensated for by pre-cambering or of setting the elevations high. The Contractor shall comply with all manufacturer's Specifications; including those relating to bolt torque, placing washers under nuts and bolt heads, cleaning and oiling of parts, and the reuse of material. Devices which are deteriorated, bent, warped, or have poorly fitted connections or welds, shall not be installed.

Shoring tower or device capacity as shown in catalogs or brochures published by the manufacturer shall be considered as the maximum load which the shoring is able to safely support under ideal conditions. These maximum values shall be reduced for adverse loading conditions; such as horizontal loads, eccentricity due to unbalanced spans or placing sequence, and uneven foundation settlement.

Copies of catalog data and/or other technical data shall be furnished with the falsework plans to verify the load-carrying capacity, deflection, and manufacturers installation requirements of any manufactured product or device proposed for use. Upon request by the Engineer, the Contractor shall furnish manufacturer certified test reports and results showing load capacity, deflection, test installation conditions, and identify associated components and hardware for shoring tower systems or other devices. In addition to manufacturer's requirements, the criteria shown in the following sections for manufactured proprietary shoring tower systems and devices shall be complied with when preparing falsework plans, calculations, and installing these shoring tower systems and devices as falsework.

Alternative criteria and/or systems shall be submitted as a Type 2 Working Drawing consisting of a written statement on the manufacturer's letterhead, signed by the shoring or device manufacturer (not signed by a material supplier or the Contractor) addressing the following:

1. Identity of the specific Contract on which the alternative criteria and/or system will apply;
2. Description of the alternative criteria and/or system;
3. Technical data and test reports;
4. The conditions under which the particular alternative criteria may be followed; and
5. That a design based on the alternative criteria will not overstress or over deflect any shoring component or device nor reduce the required safety factor.

In any case where the falsework drawings detail a manufactured product and the manufacturer's safe working load, load versus deflection curves, factor of safety, and installation requirements cannot be found in any catalog, the Engineer may require load testing in accordance with Section 6-02.3(17)G to verify the safe working load and deflection characteristics.

Tower leg loads shall not exceed the limiting values under any loading condition or sequence. Frame extensions and any reduced capacity shall be shown in the falsework plans. Screw jacks shall fit tight in the leg assemblies without wobble. Screw jacks shall be plumb and straight. Shoring towers shall be installed plumb, and load distribution beams shall be arranged such that vertical loads are distributed to all legs for all successive concrete placements. There shall be no eccentric loads on shoring tower heads unless the heads have been designed for such loading. Shoring towers shall remain square or rectangular in plan view and shall not be skewed. There shall be no interchanging of parts from one manufactured shoring system to another. Bent or faulty components shall not be used.

For manufactured shoring towers that allow ganging of frames, the number of ganged frames shall be limited to one frame per opposing side of a tower, and the total number of legs per ganged tower shall not exceed eight legs. Ganged frames shall be installed in accordance with the manufacturer's published standards using the manufacturer's components. Other gang arrangements shall not be used.

For manufactured steel shoring tower systems, the Contractor shall have bracing designed and installed for horizontal loads and falsework overturning in accordance with Section 6-02.3(17)A. Minimum bracing criteria and allowable leg loads are described in the following paragraphs.

All shoring tower systems and bracing shall be thoroughly inspected by the Contractor for plumb vertical support members, secure connections, and straight bracing members immediately prior to, at intervals during, and immediately after every concrete placement. For manufactured shoring tower systems, the maximum allowable deviation from the vertical is ⅛ inch in 3 feet. If this tolerance is exceeded, concrete shall not be placed until adjustments have brought the shoring towers within the acceptable tolerance.

6-02.3(17)E Stringers, Beams, Joists, Bridge Deck Support, and Deck Overhangs

All stringers, beams, joists, and bridge deck support shall be designed for the design loads, deflections, and allowable stresses described in the preceding Section 6-02.3(17)A, B, and C and for the following conditions.

At points of support, stringers, beams, joists, and trusses shall be restrained against rotation about their longitudinal axis. The effect of biaxial bending shall be investigated in all cases where falsework beams are not set plumb and the Structure cross-slope exceeds 3 percent.

For box girder and T-beam bridges, the centerline of falsework beams or stringers shall be located within 2 feet of the bridge girder stems and preferably directly under the stems or webs. Stringers supporting formwork for concrete box girder and T-beam slab overhangs shall be stiff enough so that the differential deflection due to the placement of bridge deck concrete is no more than 3⁄16 inch between the outside edge of the bridge deck and the exterior web even if camber strips can compensate for the deflection.

Friction shall not be relied upon for lateral stability of beams or stringers. If the compression flange of a beam is not laterally restrained, the allowable bending stress shall be reduced to prevent flange buckling. If flange restraint is provided and since it is impossible to predict the direction in which a compression flange will buckle, positive restraint shall be provided in both directions. Flange restraint shall be designed for a minimum load of 2 percent of the calculated compression force in the beam flange at the point under consideration.

Camber strips shall be used to compensate for falsework take-up and deflection, vertical alignment, and the anticipated Structure dead load deflection shown in the camber diagram in the Contract Plans. Camber is the adjustment to the profile of a load-supporting beam or stringer so that the completed Structure will have the lines and

grades shown in the Plans. The dead load camber diagram shown in the Contract Plans is the predicted Structure dead load deflection due to self mass. This dead load camber shall be increased by:

1. Amount of anticipated falsework take up,
2. Anticipated deflection of the falsework beam or stringer under the actual load imposed, and
3. Any vertical curve compensation.

Camber strips shall be fastened by nailing to the top of wood members, or by clamping or banding in the case of steel members. Camber strips shall have sufficient contact bearing area to prevent crushing under total load. Camber strips are required when the total camber adjustment exceeds ¼ inch for exterior falsework stringers and ½ inch for interior stringers.

On concrete box girder Structures, the forms supporting the bridge deck shall rest on ledgers or similar supports and shall not be supported from the bottom slab except as provided below. The form supports shall be fastened within 18 inches of the top of the web walls, producing a clear span between web walls. The bridge deck forms may be supported or posted from the bottom slab if the following conditions are met:

1. Permanent access, shown in the Contract Plans, is provided to the cells, and the centerline to centerline distance between web walls is greater than 10 feet;
2. Falsework stringers designed for total load, stresses and deflections in accordance with Section 6-02.3(17)A and B are located directly below each row of posts;
3. Posts have adequate lateral restraint; and
4. All forms (including the bridge deck forms), posts, and bracing are completely removed.

The falsework and forms on concrete box girder Structures supporting a sloping web and deck overhang shall consist of a lateral support system which is designed to resist all rotational forces acting on the stem, including those caused by the placement of bridge deck concrete, bridge deck formwork mass, finishing machine, and other live loads. Stem reinforcing steel shall not be stressed by the construction of the bridge deck slab placement. Overhang brackets shall not be used for the support of bridge deck forms from sloping web concrete box girder bridges.

Deck slab forms between girders or webs shall be constructed such that there is no differential settlement relative to the girders. The support systems for form panels supporting concrete deck slabs and overhangs on girder bridges (such as steel plate girders and prestressed girders) shall be designed as falsework. Falsework supporting deck slabs and overhangs on girder bridges shall be supported directly by the girders so that there will be no differential settlement between the girders and the deck forms during placement of deck concrete.

6-02.3(17)F Bracing

All falsework bracing systems shall be designed to resist the horizontal design load in all directions with the falsework in either the loaded or unloaded condition. All bracing, connection details, specific locations of connections, and hardware used shall be shown in the falsework plans. Falsework diagonal bracing shall be thoroughly analyzed with particular attention given to the connections. The allowable stresses in the diagonal braces may be controlled by the joint strength or the compression stability of the diagonal. Timber bracing for timber falsework bents shall have connections designed in accordance with Section 6-02.3(17)I. Any damaged cross-bracing, such as split timber members shall be replaced. Steel strapping shall avoid making sharp angles or right-angle bends. A means of preventing accidental loss of tension shall be provided for steel strapping. See Sections 6-02.3(17)A, B, and C for design loads and allowable stresses.

Bracing shall not be attached to concrete traffic barrier, guardrail posts, or guardrail.

To prevent falsework beam or stringer compression flange buckling, cross-bracing members and connections shall be designed to carry tension as well as compression. All components, connection details and specific locations shall be shown in the falsework plans. Bracing, blocking, struts, and ties required for positive lateral restraint of beam flanges shall be installed at right angles to the beam in plan view. If possible, bracing in adjacent bays shall be set in the same transverse plane. However, if because of skew or other considerations, it is necessary to offset the bracing in adjacent bays, the offset distance shall not exceed twice the depth of the beam.

All falsework and bracing shall be inspected by the Contractor for plumbness of vertical support members, secure connections, tight cables, and straight bracing members immediately prior to, during, and immediately after every concrete placement.

Bracing shall be provided to withstand all imposed loads during erection of the falsework and all phases of construction for falsework adjacent to any Roadway, sidewalk, or railroad track which is open to the public. All details of the falsework system which contribute to horizontal stability and resistance to impact, including the bolts in bracing, shall be installed at the time each element of the falsework is erected and shall remain in place until the falsework is removed. The falsework plans shall show provisions for any supplemental bracing or methods to be used to conform to this requirement during each phase of erection and removal. Wind loads shall be included in the design of such bracing or methods. Loads, connections, and materials for falsework adjacent to Roadways, shall also be in accordance with Section 6-02.3(17)C.

6-02.3(17)F1 Cable or Tension Bracing Systems

When cables, wire rope, steel rod, or other types of tension bracing members are used as external bracing to resist horizontal forces, or as temporary bracing to support bents while falsework is being erected or removed adjacent to traffic, all elements of the bracing system shall be shown in the falsework plans. Bracing shall not be attached to concrete traffic barrier, guardrail posts, or guardrail. Any damaged bracing, such as frayed and kinked guying systems shall be replaced. Wire rope shall avoid making sharp angles or right-angle bends and a means of preventing accidental loss of tension shall be provided. The following information shall be submitted as a Type 2 Working Drawing:

1. Cable diameter, rod, or tension member size, and allowable working load.
2. Location and method of attaching the cable, rod, or tension member to the falsework. The connecting device shall be designed to transfer both horizontal and vertical forces to the cable without overstressing any falsework component.
3. The type of cable connectors or fastening devices (such as U-bolt clips, plate clamps, etc.) to be used and the efficiency factor for each type. If cables are to be spliced, the splicing method shall be shown.
4. Method of tightening cables, rods, or tension members after installation if tightening is necessary to ensure their effectiveness. Method of preventing accidental loosening.
5. Anchorage details, including the size and mass of concrete anchor blocks, the assumed coefficient of friction for surface anchorages, and the assumed lateral soil bearing capacity for buried anchorages.
6. Method of pre-stretching or preloading cable or tension members.
7. Determination of the potential stretch or elongation of the tension member under the design load and if the resulting lateral deflection will cause excessive secondary stresses in the falsework.

Copies of manufacturer's catalog or brochure showing technical data pertaining to the type of cable to be used shall be furnished with the falsework plans. Technical data shall include the cable diameter, the number of strands and the number of wires per strand, ultimate breaking strength or recommended safe working strength, and any other information as may be needed to identify the cable.

In the absence of sufficient technical data to identify the cable, or if it is old and obviously worn, the Contractor shall perform cable breaking tests to establish the safe working load for each reel of cable furnished. For static guy cable the minimum factor of safety shall be 3 to 1. The Contractor shall provide the Engineer an opportunity to witness these tests.

When cable bracing is used to prevent the overturning of heavy-duty shoring, attention shall be given to the connections by which forces are transferred from the shoring to the cables. Cable restraint shall be designed to act through the cap system to prevent the inadvertent application of forces which the shoring is not designed to withstand. Cables shall not be attached to any tower component.

Cable splices made by lapping and clipping with “Crosby” type clamps shall not be used. Other splicing methods may be used; however, at each location where the cable is spliced, cable strength shall be verified by a load test.

When cables are used as external bracing to resist overturning of a falsework system, the horizontal load to be carried by the cables shall be calculated as follows:

1. When used with heavy-duty shoring systems, cables shall be designed to resist the difference between 1.25 times the total overturning moment and the resistance to overturning provided by the individual falsework towers.
2. When used with pipe-frame shoring systems where supplemental bracing is required, cables shall be designed to resist the difference between 1.25 times the total overturning moment and the resistance to overturning provided by the shoring system as a whole.
3. When used as external bracing to prevent overturning of all other types of falsework, including temporary support during erection and removal of falsework at traffic openings, cables shall be designed to resist 1.25 times the total overturning moment.

The maximum allowable cable design load shall be determined using the following criteria:

1. If the cable is new, or is in uniformly good condition, and if it can be identified by reference to a manufacturer’s catalog or other technical publication, the allowable load shall be the ultimate strength of the cable as specified by the manufacturer, multiplied by the efficiency of the cable connector, and divided by a safety factor of 3 (i.e., safe working load = breaking strength × connector efficiency/safety factor).
2. If the cable is used but still in serviceable condition, or is new or nearly new but cannot be found in a manufacturer’s catalog, the Contractor shall perform load breaking tests. In this case, the cable design load shall not exceed the breaking strength, as determined by the load test, multiplied by the connector efficiency factor, and divided by a safety factor of 3.
3. If the cable is used and still in serviceable condition, or is a new or nearly new cable which cannot be identified, and if load breaking tests are not performed, the cable design load shall not exceed the safe working load shown in the wire rope capacities table multiplied by the cable connector efficiency.

   Cable connectors shall be designed in accordance with criteria shown in the following tables “Efficiency of Wire Rope Connections” and “Applying Wire Rope Clips”. Cable safe working loads are provided in table “Wire Rope Capacities”.

Efficiency of Wire Rope Connections (As compared to Safe Loads on Wire Rope)	
Type of Connection	**Connector Efficiency**
Wire Rope	100%
Sockets – Zink Type	100%
Wedge Sockets	70%
Clips – Crosby Type With Thimble	80%
Knot and Clip (Contractors Knot)	50%
Plate Clamp – 3 Bolt Type With Thimble	80%
Spliced Eye and Thimble:	
¼″ and smaller	100%
⅜″ to ¾″	95%
⅞″ to 1″	88%
1⅛″ to 1½″	82%
1⅝″ to 2″	75%
2⅛″ and larger	70%

Wire Rope Capacities Safe Load in Pounds for New Plow Steel Hoisting Rope 6 Strands of 19-Wires, Hemp Center (Safety Factor of 6)		
Diameter inches	**Weight Lbs./Ft.**	**Safe Load Lbs.**
¼	0.10	1,050
5/16	0.16	1,500
⅜	0.23	2,250
7/16	0.31	3,070
½	0.40	4,030
9/16	0.51	4,840
⅝	0.63	6,330
¾	0.95	7,930
⅞	1.29	10,730
1	1.60	15,000
1⅛	2.03	18,600
1¼	2.50	23,000
1⅜	3.03	25,900
1½	3.60	30,700
1⅝	4.23	35,700
1¾	4.90	41,300

6-02.3(17)F2 Applying Wire Rope Clips

The only correct method of attaching U-bolt wire rope clips to rope ends is to place the base (saddle) of the clip against the live end of the rope, while the "U" of the bolt presses against the dead end.

The clips are usually spaced about six rope diameters apart to give adequate holding power. A wire-rope thimble shall be used in the loop eye to prevent kinking when wire rope clips are used. The correct number of clips for safe application, and spacing distances, are shown below:

Number of Clips and Spacing for Safe Application			
Improved Plow Steel Rope Diameter inches	Number of Clips		Minimum
	Drop Forged	Other Material	Spacing (Inches)
⅜	2	3	3
½	3	4	3½
⅝	3	4	4
¾	4	5	4½
⅞	4	5	5¼
1	5	6	6
1⅛	6	6	6¾
1¼	6	7	7½
1⅜	7	7	8¼
1½	7	8	9

6-02.3(17)F3 Anchor Blocks

Concrete anchor blocks and connections used to resist forces from external bracing shall be shown in the falsework plans. Concrete anchor blocks shall be proportioned to resist both sliding and overturning. When designing anchor block stability, the mass of the anchor block shall be reduced by the vertical component of the cable or brace tension to obtain the net or effective mass to be used in the anchorage computations. The coefficient of friction assumed in the design shall not exceed the following:

	Friction Coefficient
Anchor block set on sand	0.40
Anchor block set on clay	0.50
Anchor block set on gravel	0.60
Anchor block set on pavement	0.60

Multiply the friction coefficient by 0.67 if it is likely the supporting material is wet or will become wet during the construction period.

The method of connecting the cable or brace to the anchor block is part of the anchor block design. The connection shall be designed to resist both horizontal and vertical forces.

6-02.3(17)F4 Temporary Bracing for Bridge Girders During Erection

Steel girders shall be braced in accordance with Section 6-03.3(7)A.

Prestressed concrete girders shall be braced sequentially during girder erection. The bracing shall be designed and detailed by the Contractor and shall be shown in the falsework/formwork Working Drawings. The Contractor shall furnish, install, and remove the bracing at no additional cost to the Contracting Agency.

At a minimum, the Contractor shall brace girders at each end and at midspan to prevent lateral movement or rotation. This bracing shall be placed prior to the release of each girder from the erection equipment. If the bridge is constructed with cast-in-place concrete diaphragms, the bracing may be removed once the concrete in the diaphragms has been placed and cured for a minimum of 24 hours.

6-02.3(17)F5 Temporary Bracing for Bridge Girders During Diaphragm and Bridge Deck Concrete Placement

Girders shall be braced to resist all temporary and construction loads, including those caused by the placing of precast concrete deck panels and concrete for the bridge deck. At a minimum, the Contractor shall brace concrete girders to prevent relative lateral movement and rotation at a spacing not to exceed 60 feet. The Contractor may consider the bracing effects of the diaphragms. The Contractor shall account for the added load from concrete finishing machines and other construction loadings in the design of the bracing.

Bracing shall be designed and detailed by the Contractor and shall be shown in the girder erection plan.

Falsework support brackets and braces shall not be welded to structural steel bridge members or to steel reinforcing bars.

These braces shall be furnished, installed, and removed by the Contractor at no additional expense to the Contracting Agency.

6-02.3(17)G Testing Falsework Devices

The Contractor shall establish the load capacity and deflection (or settlement) of all friction collars and clamps, brackets, hangers, saddles, sand jacks, and similar devices utilizing a recognized independent testing Laboratory accepted by the Engineer. Laboratory tests shall use the same materials and design that will be used on the project. Test loads shall be applied to the device in the same manner that the device will experience loading on the project. Any bolts or threaded rods used with the device shall be identified as to diameter, length, type, grade, and torque. Any wedges, blocks, or shims used with the device on the project shall also be tested with the device. Any adjustable jack system used as a part of a device shall be tested with the device and shall have its maximum safe working extended height identified. Devices shall not be tested in contact with the permanent Structure. Independent members with the same properties as the permanent Structure shall be used to test device connections.

At least 14 days prior to the test, the Contractor shall submit a Type 2 Working Drawing consisting of the test procedure and scale drawing showing how the device will be tested and how data will be collected. The Contractor shall provide the Engineer an opportunity to witness these tests.

The independent testing Laboratory shall provide a certified test report which shall be signed and dated. The test report shall clearly identify the device tested including trademarks and model numbers; identify all parts and materials used, including grade of steel, or lumber, member section dimensions; location, size, and the maximum tested extended height of any adjustable jacks; indicate condition of materials used in the device; indicate the size, length and location of all welds; indicate how much torque was used with all bolts and threaded rods. The report shall describe how the device was tested, report the results of the test, provide a scale drawing of the device showing the location(s) of where deflections or settlements were measured, and show where load was applied. Deflections or settlements shall be measured at load increments and the results shall be clearly graphed and labeled. Prior to installation of falsework devices named in this section, the Contractor shall submit Type 2 Working Drawings consisting of the certified test reports.

The safe working load for shop manufactured devices named in this section shall be derived by dividing the ultimate strength by a safety factor of 2.0. The safe working load for field fabricated or field modified devices (including the use of timber blocks or wedges with the device) shall be determined by dividing the ultimate strength by a safety factor of 3.0. Working load shall include masses of all successive concrete placements, falsework, forms, all load transfer that takes place during post-tensioning, and any live loads; such as workers, Roadway finishing machines, and concrete delivery systems. The maximum allowable free end deflection of deck overhang brackets with combined dead and live working loads applied shall be 3⁄16 inch even though deflection may be compensated for by pre-cambering or setting the elevations high. The Contractor shall comply with all manufacturer's Specifications; including those relating to bolt torque, cleaning and oiling of parts, and the reuse of material. Devices which are deteriorated, bent, warped or have poorly fitted connections or welds, shall not be installed.

6-02.3(17)H Formwork Accessories

Formwork accessories such as form ties, form anchors, form hangers, anchoring inserts, and similar hardware shall be specifically identified in the formwork plans including the name and size of the hardware, manufacturer, safe working load, and factor of safety. The grade of steel shall also be indicated for threaded rods, coil rods, and similar hardware. Wire form ties shall not be used. Welding or clamping formwork accessories to Contract Plan reinforcing steel will not be allowed. Driven types of anchorages for fastening forms or form supports to concrete, and Contractor fabricated "J" hooks shall not be used. Field drilling of holes in prestressed girders is not allowed.

Taper ties may be used provided the following conditions are met:

1. The structure is not designed to resist water pressure (pontoons, floating dolphins, detention vaults, etc.).
2. After the taper tie is removed, plugs designed and intended for plugging taper tie holes shall be installed at each face of concrete. The plug shall be installed a minimum of 1½ inches clear from the face of concrete.
3. After the plug is installed, the hole shall be cleaned of all grease, contamination and foreign matter.
4. Holes on the exposed faces of concrete shall be patched and finished to match the surrounding concrete.

The following table from ACI 347R-88 provides minimum safety factors for formwork accessories. The hardware proposed shall meet these minimum ultimate strength requirements or the manufacturer's minimum requirements, whichever provides the greater factor of safety. The Contractor shall attach copies of the manufacturer's catalog cuts and/or test data of hardware proposed, to the formwork plans and submit the falsework and formwork Working Drawings with supporting calculations in accordance with Section 6-02.3(16). In situations where catalog cuts and/or test data are not available, testing shall be performed in accordance with Section 6-02.3(17)G.

Minimum Safety Factors of Formwork Accessories*		
Accessory	**Safety Factor**	**Type of Construction**
Form Tie	2.0	All applications.
Form Anchor	2.0	Formwork supporting form mass and concrete pressures only.
Form Anchor	3.0	Formwork supporting masses of forms, concrete, construction live loads, and impact.
Form Hangers	2.0	All applications.
Anchoring Inserts	2.0	Placed in previous opposing concrete placement to act as an anchor for form tie.

*Safety factors are based on ultimate strength of the formwork accessory.

The bearing area of external holding devices shall be adequate to prevent excessive bearing stress on form lumber. Form ties and form hangers shall be arranged symmetrically on the supporting members to minimize twisting or rotation of the members. Form tie elongation shall not exceed the allowable deflection of the wale or member that it supports. Inserts, bolts, coil rods, and other fasteners shall be analyzed and designed for appropriately combined bending, shear, torsion, and tension stresses. The formwork shall not be attached to Contract Plan rebar or rebar cages. However, the Contractor may install additional reinforcing steel for formwork anchorage.

Frictional resistance shall not be considered as contributing to the stability of any connection or connecting device, except those designed as friction connectors such as U-bolt friction-type connectors.

Form anchors and anchoring inserts shall be designed considering concrete strength at time of loading, available embedment, location in the member, and any other factors affecting their working strength, and shall be installed in concrete in accordance with the manufacturer's published requirements. Form anchors and anchoring inserts embedded in previous concrete placements shall not be loaded until the concrete has reached the required design strength. The required design strength of concrete for loading of an anchor shall be shown in the formwork drawing if it is assumed that the anchor will be loaded before the concrete has reached its 28-day strength.

Installation of permanent concrete inserts, such as form ties hangers, or embedded anchor assemblies, shall permit removal of all metal to at least ½ inch below the concrete surface. Holes shall be patched in accordance with Section 6-02.3(14). During removal of the outer unit, the bond between the concrete and the inner unit or rod shall not be broken.

6-02.3(17)I Timber Connections

Timber connections shall be designed in accordance with the methods, stresses, and loads allowed in the Timber Construction Manual, Third Edition by the American Institute of Timber Construction (AITC). Timber falsework and formwork connections shall be designed using wet condition stresses for all installations West of the Cascade Range crest line and by criteria provided in the following sections. Frictional resistance shall not be considered as contributing to the stability of any timber connection.

6-02.3(17)I1 Bolted Connections

Tabulated values in the AITC *Timber Construction Manual*, Current Edition are based on square posts. For a round post or pile, the main member thickness shall be the side of a square post having the same cross-sectional area as the round post used.

The AITC Table 6.20 for Douglas Fir-Larch bolt Group 3 and for Hem-Fir bolt Group 8 show design values for bolts to be used when the load is applied either parallel or perpendicular to the direction of the wood grain. When the load is applied at an angle to the grain, as is the case with falsework bracing, the design value for the main member shall be obtained from the Hankinson formula shown in the AITC manual.

Design values in the AITC Table 6.20 apply only to three-member joints (bolt in double-shear) in which the side members are each ½ the thickness of the main member. This joint configuration is not typical of bridge falsework where side members are usually much smaller than main members. For two-member joints (single shear bolt condition), the AITC Table 6.20 values shall be adjusted by a single shear load factor as follows:

1. 0.75 for installations East of the Cascade Range crest line, except as shown in item 3 below;
2. 0.50 for installations West of the Cascade Range crest line; and
3. 0.50 for load acting at an angle to the bolt axis, as is the case with longitudinal bracing when falsework bents are skewed.

Except for connections in falsework adjacent to or over railroads or Roadways, threaded rods and coil rods may be used in place of bolts of the same diameter with no reduction in the tabulated values. At openings for Roadways and railroads, all connections shall be bolted using ⅝-inch diameter or larger through bolts.

Bolt holes shall be a minimum 1/32 inch to a maximum ⅛ inch larger than the bolt diameter. A washer not less than a standard cut washer shall be installed between the wood and the bolt head and between the wood and the nut to distribute the bearing stress under the bolt head and nut and to avoid crushing the fibers. In lieu of standard cut washers, metal plates or straps with dimensions at least equal to that of a standard cut washer may be substituted.

When steel bars or shapes are used as diagonal bracing, the tabulated design values shown in AITC Table 6.20 for the main members loaded parallel to grain (P value) are increased 75 percent for joints made with bolts ½ inch or less in diameter, 25 percent for joints made with bolts 1½ inch in diameter, and proportionally for intermediate diameters. No increase in the tabulated values is allowed for perpendicular-to-grain loading (Q value).

Clearance requirements for end, edge, and bolt spacing distance shall be as shown below. All distances are measured from the end or side of the wood member to the center of the bolt hole. For members which are subject to load reversals the larger controlling distances shall be used for design. For parallel-to-grain loading, the minimum distances for full design load:

1. In tension, minimum end distance shall be seven times the bolt diameter;
2. In compression, minimum end distance shall be four times the bolt diameter; and
3. In tension or compression, the minimum edge distance shall be one and one-half times the bolt diameter.

For perpendicular-to-grain loading, the minimum distance for full design load:

1. Minimum end distance shall be four times the bolt diameter;
2. Edge distance toward which the load is acting shall be at least four times the bolt diameter; and
3. Distance on the opposite edge shall be at least 1½-bolt diameters.

Minimum clearance (spacing) between adjacent bolts in a row shall be four times the bolt diameter, measured center-to-center of the bolt holes.

When more than two bolts are used in a line parallel to the axis of the side member, additional requirements shall be followed as shown in the AITC manual.

6-02.3(17)I2 Lag Screw Connections

Design values for lag screws subject to withdrawal loading are found in AITC Table 6.27. Values for wood having a specific gravity of 0.51 for Douglas Fir-Larch or 0.42 for Hem-Fir shall be assumed when using the table. The withdrawal values are in pounds per inch of penetration of the threaded part of the lag screw into the side grain of the

member holding the point, with the axis of the screw perpendicular to that member. The maximum load on a given screw shall not exceed the allowable tensile strength of the screw at the root section.

AITC recommends against subjecting lag screws to end-grain withdrawal loading. However, if this condition cannot be avoided, the design value shall be 75 percent of the corresponding value for withdrawal from the side grain.

Values in the Group II wood species column shall be used for Douglas Fir-Larch and the Group III wood species column shall be used for Hem-Fir. When the load is applied at an angle to the grain, as is the case with falsework bracing, the design value shall be obtained from the Hankinson formula shown in the AITC manual.

When lag screws are subjected to a combined lateral and withdrawal loading, as would be the case with longitudinal bracing when the falsework bents are skewed, the effect of the lateral and withdrawal forces shall be determined separately. The withdrawal component of the applied load shall not exceed the allowable value in withdrawal. The lateral component of the applied load shall not exceed the allowable lateral load value.

Lag screws shall be inserted in lead holes as follows:

1. The clearance hole for the shank shall have the same diameter as the shank, and the same depth of penetration as the length of unthreaded shank;
2. The lead hole for the threaded portion shall have a diameter equal to 60 to 75 percent of the shank diameter and a length equal to at least the length of the threaded portion. The larger percentile figure in each range shall apply to screws of the greater diameters used in Group II wood species;
3. The threaded portion of the screw shall be inserted in its lead hole by turning with a wrench, not by driving with a hammer; and
4. To facilitate insertion, soap or other lubricant shall be used on the screws or in the lead hole.

6-02.3(17)I3 Drift Pin and Drift Bolt Connections

When drift pins or drift bolts are used, the required length and penetration shall be determined using the following criteria. The lateral load-carrying capacity of drift pins and drift bolts driven into the side grain of a wood member shall be limited to 75 percent of the design values for a common bolt of the same diameter and length in the main member. For drift pin connections, the pin penetration into the connected members shall be increased to compensate for the absence of a bolt head and nut. For drift bolts or pins driven into the end grain of a member, the lateral load-carrying capacity shall be limited to 60 percent of the allowable side grain load (perpendicular to grain value) for an equal diameter bolt with nut. To develop this allowable load the drift bolt or pin shall penetrate at least 12 diameters into the end grain. To fully develop the allowable load of the drift bolts or pins, they shall be driven into predrilled holes, 1/16 inch less in diameter than the drift pin or bolt diameter.

The criteria shown in the AITC *Timber Construction Manual*, Current Edition shall apply to drift bolt or pin connection allowable loads for the following conditions:

1. Withdrawal resistance; and
2. When there are more than two drift bolts or pins in a joint, allowable loads shall be further reduced by applying applicable modification factors shown in the AITC Table 6.3.

6-02.3(17)I4 Nailed and Spiked Joints

Joints using nails or spikes shall conform to the provisions of AITC. For side grain withdrawal, the values in AITC Table 6.35 for wood having a specific gravity of 0.51 for Douglas Fir-Larch and a specific gravity of 0.42 for Hem-Fir shall be used. End grain withdrawal shall not be used. For lateral loading, the values in AITC Table 6.36 for wood species Group II for Douglas Fir-Larch and wood species Group III for Hem-Fir shall be used. Diameters listed in the tables apply to fasteners before application of any protective coating.

When more than one nail or spike is used in a joint, the total design value for the joint in withdrawal or lateral resistance shall be the sum of the design values for the individual nails or spikes.

The tabulated design values for lateral loads are valid only when the nail penetrates into the main member at least 11 diameters for Douglas Fir-Larch and 13 diameters for Hem-Fir. Note that the values are maximum values for the type and size of fastener shown. The tabulated values shall not be increased even if the actual penetration is exceeded.

When main member penetration is less than 11 diameters for Douglas Fir-Larch and 13 diameters for Hem-Fir, the design value shall be determined by straight-line interpolation between zero and the tabulated load, except that penetration shall not be less than ⅓ of that specified.

Double-headed or duplex nails used in falsework and formwork construction are shorter than common wire nails or box nails of the same size designation. They have less penetration into the main member and therefore their load-carrying capacity shall be adjusted accordingly.

Nail and spike minimum spacing in timber connections shall be as follows:

1. The average center-to-center distance between adjacent nails, measured in any direction, shall not be less than the required penetration into the main member for the size of nail being used; and
2. The minimum end distance in the side member, and the minimum edge distance in both the side member and the main member, shall not be less than ½ of the required penetration.

Allowable values for withdrawal and lateral load resistance are reduced when toe nails are used in accordance with the following:

1. For withdrawal loading, the design load shall not exceed ⅔ of the value shown in the applicable design table; and
2. For lateral loading, the design load shall not exceed ⅚ of the value shown in the applicable design table.

Toe nails are recommended to be driven at an approximate angle of 30 degrees with the piece and started approximately ⅓ of the length of the nail from the end or side of the piece.

6-02.3(17)I5 Timber Connection Adjustment for Duration of Load

Tabulated values for timber fasteners are for normal duration of load and may be increased for short duration loading, except for connections used in falsework and formwork for post tensioned Structures and staged construction sequences. Duration of load adjustment for timber connections shall not be allowed for all post tensioned Structures and for staged construction sequences where delayed and/or staged loading occurs for any type of concrete Structure. The adjustment for duration of load as described in this section applies only to design values for timber connectors, such as nails, bolts, and lag screws. Allowable stresses for timber and structural steel components used in the connection, as described in Section 6-02.3(17)B, are maximums and thus shall not be increased.

Tabulated values for nails, bolts, and lag screws may be adjusted by the following duration-of-load factors:

1. 1.25 for falsework design governed by the minimum design horizontal load or greater (3 percent or greater of the dead load),
2. 1.33 for falsework design governed by wind load, and
3. 2.00 for falsework design governed by impact loading.

6-02.3(17)J Face Lumber, Studs, Wales, and Metal Forms

Elements of this section shall be designed for the loads, allowable stresses, deflections, and conditions which pertain from other Subsections of Section 6-02.3(17).

Forms battered or inclined above the concrete will tend to lift up as concrete is placed and shall have positive anchorage or counterweights designed to resist uplift and shall be shown in the formwork plans. Where the concrete pouring sequence causes fresh concrete to be significantly higher along one side of tied forms than the opposite side, a positive form anchorage system shall be designed capable of resisting the imbalance of horizontal thrust, and prevent the dislocation and sliding of the entire form unit.

Wooden forms shall be faced with smooth sanded, exterior plywood. This plywood shall meet the requirements of the National Bureau of Standards, U.S. Product Standard PS 1, and the Design Specification of the American Plywood Association (APA). Each full sheet shall bear the APA stamp. The Contractor shall list in the form plans the grade and class of

plywood. If the Engineer accepts the manufacturer's certification of structural properties, the Contractor may use plywood that does not carry the APA stamp. Plywood panels stamped "shop" or "shop cutting", shall not be used.

Plyform is an APA plywood specifically designed and manufactured for concrete forming. Plyform differs from conventional exterior plywood grades in strength and the exterior face panels are sanded smooth and factory oiled. Likewise, there is a significant difference between grades designated Class 1, Class 2, and Structural I Plyform.

The grades of plywood for various form applications shall be as follows:

1. **Traffic and Pedestrian Barriers** (except those that will receive an architectural surface treatment) – Plywood used for these surfaces shall be APA grade High-Density Overlaid (HDO) Plyform Class I. But if the Contractor coats the form to prevent it from leaving joint and grain marks on the surface, plywood that meets or exceeds APA grades B-B Plyform Class I or B-C (Group I species) may be used. Under this option, the Contractor shall provide for the Engineer's acceptance a 4-foot-square, test panel of concrete formed with the same plywood and coating as proposed in the form plans. This panel shall include one form joint along its centerline. The Contractor shall apply coating material, according to the manufacturer's instructions, before applying chemical release agents.
2. **Other Exposed Surfaces** (all but those on traffic and pedestrian barriers) – Plywood used to form these surfaces shall meet or exceed the requirements of APA grades B-B Plyform Class I or B-C (Group I series). If one face is less than B quality, the B (or better) face shall contact the concrete.
3. **Unexposed Surfaces** (such as the underside of the bridge deck between girders, the interiors of box girders, etc., and traffic and pedestrian barriers where surfaces will receive an architectural treatment) – Plywood used to form these surfaces may be APA grade CDX, provided the Contractor complies with stress and deflection requirements stated elsewhere in these Specifications.

Form joints on an exposed surface shall be in a horizontal or vertical plane. But in wingwalls and box girders, side form joints shall be placed at right angles and parallel to the Roadway grade. Joints parallel to studs or joists shall be backed by a stud or joist. Joints at right angles to studs and joists shall be backed by a stud or other backing the Engineer accepts. Perpendicular backing is not required if studs or joists are spaced:

1. Nine inches or less on center and covered with ½-inch plywood, or
2. Twelve inches or less on center and covered with ¾-inch plywood.

The face grain of plywood shall run perpendicular to studs or joists unless shown otherwise on the Contractor's formwork Working Drawings. Proposals to deviate from the perpendicular orientation shall be accompanied by supporting calculations of the stresses and deflections.

Forming for all exposed curved surfaces shall follow the shape of the curve shown in the Contract Plans and shall not be chorded except as follows. On any retaining wall that follows a horizontal circular curve, the wall stems may be a series of short chords if:

1. The chords within the panel are the same length, unless otherwise allowed by the Engineer;
2. The chords do not vary from a true curve by more than ½ inch at any point; and
3. All panel points are on the true curve.

Where architectural treatment is required, the angle point for chords in wall stems shall fall at vertical rustication joints.

For exposed surfaces of abutments, wingwalls, piers, retaining walls, and columns, the Contractor shall build forms of plywood at least ¾ inch thick with studs no more than 12 inches on center. The Engineer may allow exceptions, but deflection of the plywood, studs, or wales shall never exceed 1/360 of the span (or 1/270 of the span for unexposed surfaces, including the bottom of the deck slab between girders).

All form plywood shall be at least ½ inch thick except on sharply curved surfaces. There, the Contractor may use ¼-inch plywood if it is backed firmly with heavier material.

Round columns or rounded pier shafts shall be formed with a self-supporting metal shell form or form tube that leaves a smooth, nonspiralling surface. Wood forms are not permitted.

Metal forms shall not be used elsewhere unless the Engineer is satisfied with the surface and allows use in writing. The Engineer may withdraw allowing use of metal forms at any time. If permitted to use a combination of wood and metal in forms, the Contractor shall coat the forms so that the texture produced by the wood matches that of the metal. Aluminum shall not be used for metal forms.

For design purposes, the Contractor shall assume that on vertical surfaces concrete exerts 150 pounds per square foot per foot of depth. However, when the depth is reached where the rate of placement controls the pressure, the following table applies:

Rate of Placing Feet per Hour	Pressure, Pounds per Square Foot for Temperature of Concrete as Shown	
	60°F	70°F and Above
2	470	375
3	640	565
4	725	625
5	815	690
6	900	750
7	990	815
8	1,075	875
9	1,165	935
10	1,250	1,000
15	1,670	1,300

The pressures in the above table have been increased to provide an allowance for the vibration and impact.

All corners shall be beveled ¾ inch. However, footings, footing pedestals, and seals need not be beveled unless required in the Plans.

All forms shall be as mortar-tight as possible with no water standing in them as the concrete is placed.

The Contractor shall apply a parting compound on forms for exposed concrete surfaces. This compound shall be a chemical release agent that permits the forms to separate cleanly from the concrete. The compound shall not penetrate or stain the surface and shall not attract dirt or other foreign matter. After the forms are removed, the concrete surface shall be dust-free and have a uniform appearance. The Contractor shall apply the compound at the manufacturer's recommended rate to produce a surface free of dusting action and yet provide easy removal of the forms.

The Engineer may reject any forms that will not produce a satisfactory surface.

6-02.3(17)K Concrete Forms on Steel Spans

Concrete forms on all steel Structures shall be removable and shall not remain in place. Where needed, the forms shall have openings for truss or girder members. Each opening shall be large enough to leave at least 1½ inches between the concrete and steel on all sides of the steel member after the forms have been removed. Unit Contract prices cover all costs related to these openings.

The Contractor shall not weld any part of the form to any steel member.

The compression member or bottom connection of cantilever formwork support brackets shall bear either within 6 inches maximum vertically of the bottom flange or within 6 inches maximum horizontally of a vertical web stiffener. The Contractor's bridge deck form system shall be designed to prevent rotation of the steel girder. This can be achieved by temporary struts and ties or other methods the Contractor shows to be effective. Partial depth cantilever formwork support brackets that do not conform to the above requirements shall not be used unless the Contractor submits Type 2E Working Drawings consisting of details showing the additional formwork struts and ties used to brace the steel girder against web distortion caused by the partial depth bracket.

If the Engineer permits bolt holes in the web to support form brackets, the holes shall be shop drilled unless otherwise allowed by the Engineer. The Contractor shall fill the holes with fully torqued ASTM F3125 Grade A325 bolts in accordance with Section 6-03.3(33). Each bolt head shall be placed on the exterior side of the web. There shall be no holes made in the flanges.

6-02.3(17)L Finishing Machine Support System

Before using any finishing machine, the Contractor shall submit a Type 2 Working Drawing consisting of detailed drawings that show the system proposed to support it. The Contractor shall not attach this (or any other) equipment support system to the sides or suspend it from any girder unless the Engineer permits. The Engineer will not permit such a method if it will unduly alter stress patterns or create too much stress in the girder.

6-02.3(17)M Restricted Overhead Clearance Sign

The Contractor shall notify the Engineer not less than 15 working days before the anticipated start of each falsework and girder erection operation whenever such falsework or girders will reduce clearances available to the public traffic. Falsework openings shall not be more restrictive to traffic than shown in the Contract Plans.

Where the height of vehicular openings through falsework is less than 15 feet, a W 12-2 "Low Clearance Symbol Sign" shall be erected on the Shoulder in advance of the falsework and two or more W 12-301 and/or W 12-302 signs shall be attached to the falsework to provide accurate usable clearance information over the entire falsework opening. The posted low clearance shall include an allowance for anticipated falsework girder deflection (rounded-up to the next whole inch) due to design dead load, including all successive concrete pours. W 12-302 signs shall be used to designate prominent clearance restrictions and limits of usable clearance. In addition, where the clearance is less than the legal height limit (14 feet), a W 12-2 sign shall be erected in advance of the nearest intersecting road or wide point in the road at which a vehicle can detour or turn around. A W 13-501 sign indicating the distance to the low clearance shall be installed below the advance sign. The Engineer will furnish the above noted signs and the Contractor shall erect and maintain them, all in accordance with Section 1-10.3(3).

When erecting falsework that restricts overhead clearance above a railroad track, the Contractor shall immediately (as soon as the restriction occurs) place restricted overhead clearance signs. Sign details are shown in the *Standard Plans*. Unit Contract prices cover all costs relating to these signs.

6-02.3(17)N Removal of Falsework and Forms

If the Engineer does not specify otherwise, the Contractor may request to remove forms based on the criteria in the table below. Both compressive strength and minimum time criteria shall be met if both are listed in the applicable row. The minimum time shall be from the time of the last concrete placement in the forms. In no case shall the Contractor remove forms or falsework without the Engineer's concurrence.

Concrete Placed In	Percent of Specified Minimum Compressive Strength[1]	Minimum Compressive Strength[1]	Minimum Time
Side forms not supporting the concrete weight, including columns, walls, crossbeams, nonsloping box girder webs, abutments, and traffic and pedestrian barriers.			3 days
	or		
		1,400 psi	18 hours
Side forms of footings, pile caps, and shaft caps.[2]			18 hours
Crossbeams, sloping box girder webs, struts, inclined columns, inclined walls, and other forms that support the concrete weight.	80		5 days
Bridge decks supported on stringers, beam, or girders.[3]	80		10 days
Box girders, T-beam girders, and flat-slab Superstructure.[3]	80		14 days
Arches[3]	80		21 days

[1]Strength shall be proved by test cylinders made from the last concrete placed into the form. The cylinders shall be cured according to FOP for AASHTO T 23.

[2]Curing compound shall be immediately applied to the sides when forms are removed.

[3]Where continuous spans or segments are involved, the time for all spans will be determined by the last concrete placed affecting any span.

Before releasing supports from beneath beams and girders, the Contractor shall remove forms from columns to enable the Engineer to inspect the column concrete.

Curing shall comply with the requirements of Section 6-02.3(11). The concrete surface shall not become dry during form removal if removed during the cure period.

Before placing forms for traffic and pedestrian barriers, the Contractor shall completely release all falsework under spans.

The Engineer may allow leaving in place forms for footings in cofferdams or cribs. This decision will be based on whether removing them would harm the cofferdam or crib and whether the forms will show in the finished Structure.

All cells of a box girder Structure which have permanent access shall have all forms completely removed, including the bridge deck forms. All debris and all projections into the cells shall be removed. Unless otherwise shown in the Plans, the bridge deck interior forms in all other cells where no permanent access is available, may be left in place.

Falsework and forms supporting sloping exterior webs shall not be released until the bridge deck and deck overhang concrete has obtained its removal strength and number of days criteria listed in the table above. Stem reshoring shall not be used.

Open joints shown in the Plans shall have all forms completely removed, including Styrofoam products and form anchors, allowing the completed Structure to move freely.

If the Contractor intends to support or suspend falsework and formwork from the bridge Structure while the falsework and formwork is being removed, the Contractor shall submit a Type 2 Working Drawing consisting of the falsework and formwork removal plan and calculations. The falsework and formwork removal plan shall include the following:

1. The location and size of any cast-in-place falsework lowering holes and how the holes are to be filled;
2. The location, capacity, and size of any attachments, beams, cables, and other hardware used to attach to the Structure or support the falsework and formwork;
3. The type, capacity and factor of safety, weight, and spacing of points of reaction of lowering equipment; and
4. The weight at each support point of the falsework and formwork being lowered.

All other forms shall be removed whether above or below the level of the ground or water. Sections 6-02.3(7) and 6-02.3(8) govern form removal for concrete exposed to sea water or to alkaline water or soil. The forms inside of hollow piers, girders, abutments, etc., shall be removed through openings shown in the Plans or as allowed by the Engineer.

6-02.3(17)O Early Concrete Test Cylinder Breaks

The fabrication, curing, and testing of the early cylinders shall be the responsibility of the Contractor. Early cylinders are defined as all cylinders tested in advance of the design age of 28 days whose purpose is to determine the in-place strength of concrete in a Structure prior to applying loads or stresses. The Contractor shall retain a testing Laboratory to perform this Work. Testing Laboratories' equipment shall be calibrated within 1 year prior to testing and testers shall be either ACI certified or qualified in accordance with AASHTO R 18.

The concrete cylinders shall be molded in accordance with FOP for AASHTO T 23 from concrete last placed in the forms and representative of the quality of concrete placed in that pour.

The cylinders shall be cured in the field in accordance with FOP for AASHTO T 23 Section 10.2 Field Curing.

The concrete cylinders shall be tested for compressive strength in accordance with AASHTO T 22. The number of early cylinder breaks shall be in accordance with the Contractor's need and as allowed by the Engineer.

The Contractor shall submit a Type 2 Working Drawing consisting of all test results, proof of equipment calibration, and tester's certification. The Contractor shall not remove forms without the concurrence of the Engineer.

All costs in connection with furnishing cylinder molds, fabrication, curing, and testing of early cylinders shall be included in the unit Contract prices for the various Bid items of Work involved.

6-02.3(18) Placing Anchor Bolts

The Contractor shall comply with the following requirements in setting anchor bolts in piers, abutments, or pedestals:

1. If set in the wet concrete, the bolts shall be accurately placed before the concrete is placed.
2. If the bolts are set in drilled holes, hole diameter shall exceed bolt diameter by at least 1 inch. Grouting shall comply with Section 6-02.3(20).
3. If the bolts are set in pipe, grouting shall comply with Section 6-02.3(20).
4. If freezing weather occurs before bolts can be grouted into sleeves or holes, they shall be filled with an accepted antifreeze solution (non-evaporating).

6-02.3(19) Bridge Bearings

Bridge bearings include the following:

1. Elastomeric bearing pads conforming to Section 9-31.8(1).
2. Fabricated bearing assemblies including, at a minimum, the following:
   a. High-Load Multi-Rotational (HLMR) bridge bearing assemblies, including the following:
      i. Disc bearings, functioning as guided unidirectional or fixed or multi-directional bearings, and consisting of an upper and a lower unit.
      ii. Spherical bearings, functioning as guided or fixed or multi-directional bearings, and consisting of an upper, a middle, and a lower unit.
   b. Fabric pad bearings and transverse stop bearings, functioning as guided bearings and consisting of an upper and a lower unit.
   c. Pin bearings, functioning as guided or fixed bearings, and consisting of an upper, a middle, and a lower unit.

The entire bearing assembly shall be supplied by a single bearing manufacturer.

6-02.3(19)A Design Requirements for HLMR Bearing Assemblies

The Contractor shall design HLMR bearing assemblies based on the AASHTO LRFD Bridge Design Specifications and the following:

1. The bearing assembly design requirements for loads, movements, and rotations shall be as shown In the Plans.
2. The bearing assembly shall be removable and replaceable by raising the bridge superstructure ¼-inch maximum. The bearing shall be held in place by recessing the upper and lower keeper plates and by providing recessed bolted keeper bars on the side of bearing removal.

3. The area of the polyether urethane disc for disc bearings shall be designed for an unfactored stress of 5,000 psi ± 5 percent at full dead load and live load.
4. The mechanical interlock of the solid or woven PTFE sheets to the steel substrates shall be sufficient to develop a horizontal force equal to 10-percent of the maximum unfactored vertical load for spherical bearings with an external restrainer, and 25-percent of the maximum unfactored vertical load for spherical bearings without an external restrainer.
5. The area of the PTFE surface shall be designed so that the contact pressure does not exceed the maximum contact pressure specified in the AASHTO LRFD Bridge Design Specifications. The contact stress shall be determined at the strength limit state as specified In the AASHTO LRFD Bridge Design Specifications.
6. The minimum coefficient of friction on PTFE surfaces used for design shall be those corresponding to 68°F in the AASHTO LRFD Bridge Design Specifications.
7. The anchorage of the sole plates, masonry plates, and guide bars to the supporting structural element shall be designed for the maximum horizontal design force per bearing shown in the Plans, or 20-percent of the maximum unfactored vertical design force per bearing, whichever is greater.
8. The sole and masonry plates shall have leveling capabilities.
9. The guide bars shall maintain all guided components within the guides at all points of translation and rotation of the bearing.

6-02.3(19)B Submittals

6-02.3(19)B1 HLMR Bearing Design Calculations Submittal

The Contractor shall submit Type 2E Working Drawings consisting of design calculations for all HLMR bearing components, including the polyether urethane disc, shear pin, base plates, bearing plates, sole plates, masonry plates, guide bars, keeper plates and bars, and anchor bolts. The submittal shall include, at a minimum, the following:

1. Bending stresses in the plates due to bearing pressure at maximum design load and eccentricity.
2. Concrete bearing pressure under the plates at maximum bearing pressure and eccentricity.
3. Bearing clearances at maximum load and rotation. The calculated clearances shall include the effects of anticipated Initial set and modified center of rotation.
4. Shear stress in the disc bearing shear pin at maximum horizontal load.
5. Design of all connections and mating surfaces.
6. Compressive stress on all sliding surfaces at maximum and minimum design loads, including rotation.

6-02.3(19)B2 HLMR Bearing Manufacturer Experience Submittal

The Contractor shall submit a Type 1 Working Drawing consisting of the name of the HLMR bearing manufacturer with a certification of HLMR bearing manufacturing experience. The certification of experience shall include a list of at least five HLMR bearing Installations performed by the bearing manufacturer on previous projects. The list shall include the following Information at a minimum for each installation:

1. Project Name and Location (Bridge name and highway number).
2. Date of installation.
3. Governmental Agency/Owner.
4. Name, address and phone number of the Governmental Agency's/Owner's representative.

6-02.3(19)B3 Fabrication Shop Drawing Submittal

The Contractor shall submit Type 2 Working Drawings consisting of bearing fabrication shop drawings, including, at a minimum, the following:

1. Bearing schedule identifying location and bearing type as described in Section 6-02.3(19).
2. Minimum and maximum horizontal and vertical service loads for HLMR bearings.
3. Magnitude and direction of movements for HLMR bearings at all bearing support points.
4. Minimum and maximum rotation capacity for HLMR bearings.
5. Construction rotation requirements for HLMR bearings.
6. Plan and elevation of the assembled bearing and each of the components showing dimensions and tolerances.
7. Complete details of all components and sections showing all materials incorporated into the bearing.
8. All AASHTO, ASTM and other material designations.
9. All weld callouts with supporting Weld Procedure Specifications (WPSs) and associated Procedure Qualification Records (PQRs) as required.
10. All surface finishes and coating requirements.
11. Bearing manufacturer's recommendations and procedures for bearing assembly shipment, storage, and installation.

6-02.3(19)B4 Submittals of Acceptance Test Reports and Certificates

The Contractor shall submit the following production samples and test reports and certificates for fabricated bridge bearing assemblies as applicable:

1. A Type 2 Working Drawing consisting of a six-inch square by 1/8-inch thick sample of PTFE taken from the lot of production material.
2. A Type 2 Working Drawing consisting of a six-inch square by 1-inch thick sample of pre-formed fabric pad taken from the lot of production material.
3. Type 1 Working Drawings consisting of Manufacturers' Certificates of Compliance for the PTFE, polyether urethane, pre-formed fabric pad duck, silicone grease, epoxy gel, and resin filler.
4. Type 1 Working Drawings consisting of certified mill test reports for all steel and stainless steel in the bearing assemblies.
5. Type 1 Working Drawings consisting of certified test reports confirming that the pre-formed fabric pads meet the specific requirements of proof load.

6-02.3(19)B5 Quality Assurance and Final Shop Inspection Process Submittal

The Contractor shall submit a Type 1 Working Drawing consisting of the independent inspection entity performing the Quality Assurance Inspection and Final Shop Inspection as specified in Section 6-02.3(19)F. The submittal shall include, at a minimum, the name, address, phone number, and contact person of the inspection entity performing the Inspection, the proposed Quality Assurance Inspection Program, and the forms to be used for the Quality Assurance Inspection Program.

6-02.3(19)B6 HLMR Bearing Testing Procedure Submittal

The Contractor shall submit a Type 1 Working Drawing consisting of the name, address, phone number, and contact person of the testing entity performing the required bearing testing specified in Section 6-02.3(19)E.

The testing entity shall be one of the following:

1. An independent testing agency.
2. The HLMR bearing manufacturer, with Independent verification by the inspection entity performing the certified shop Inspection of the bearings.

6-02.3(19)B7 HLMR Bearing Assembly Inspection Reports and Certificates

The Contractor shall submit Type 1 Working Drawings consisting of the periodic inspection reports of the independent inspection entity performing the required certified shop inspection, at a frequency defined in the Quality Assurance Inspection Program of Sections 6-02.3(19)B5 and 6-02.3(19)F2. The daily inspection reports shall report on the shop fabrication and testing activities relating to the bearing assemblies, and their conformance to the specification requirements.

The Contractor shall submit written documentation from the bearing manufacturer and the independent inspection entity certifying that the bearing assemblies have been manufactured in full compliance with the specification requirements.

6-02.3(19)C Bearing Assembly Fabrication

The edges of all components shall be broken by grinding so that there are no sharp edges.

6-02.3(19)C1 Flatness and Manufacturing Tolerances

Flatness of bearing surfaces shall be determined by the following method:

1. A precision straightedge, longer than the nominal dimension to be measured shall be placed in contact with the surface to be measured as parallel to it as possible.
2. A feeler gauge having an accuracy equal to the tolerance allowed ± 0.001-inch, shall be selected and inserted under the straightedge.
3. Surfaces are acceptable for flatness if the feeler gauge does not pass under the straightedge.
4. In determining the flatness, the straightedge may be located in any position on the surface being measured.

Flatness tolerances are defined as follows:

1. Class A tolerance = 0.001 x nominal dimension
2. Class B tolerance = 0.002 x nominal dimension
3. Class C tolerance = 0.005 x nominal dimension

Manufacturing tolerances for bearing components are as follows:

Polyether Urethane Disc

Diameter:	± 1/8-inch
Thickness:	- 0, +1/16-inch
Flatness:	Class B tolerance

Discs shall be manufactured from a single piece

Spherically Curved Surfaces

Radii:	± 1-percent, surfaces shall be parallel to each other
Spherical Surface Profile:	± 0.0002Dh or 1/128-inches, whichever is greater, where D = length of chord (in inches) between the ends of the PTFE surface in the direction of rotation, and h = projection of the PTFE (in inches) above the top of the confining recess.

PTFE Sheet

Plan dimensions:	Total nominal design area -0, + 1/8-inch
Thickness:	- 0, +1/64-inch
Flatness:	Class A tolerance, both surfaces

Pre-formed Fabric Pad

Plan dimensions:	- 0, + 3/16-inch
Thickness:	- 1/16, + 3/16-inch
Surface Finish:	For pre-formed fabric pads fabricated from multiple layers, all pad edges shall be free from visible horizontal displacement between the individual layers

Stainless Steel Sheet

Plan dimension:	- 0, + 3/16-inch
Flatness:	Class A tolerance, both surfaces

Backing, Bearing, Masonry, Sliding, and Sole Plates of HLMR Bearings

Plan dimensions

Greater than 30-inches:	- 0, + 3/16-inch
30-inches or less:	- 0, + 1/8-inch
Thickness:	- 1/32, + 1/8-inch
Flatness:	Class A tolerance, side in contact with steel, polyether urethane disc, or PTFE
	Class C tolerance, side in contact with epoxy gel or grout or concrete

Width and length of

PFTE recess:	- 0, + 0.04-inch of PTFE sheet size

The maximum gap between the external restrainer and the circular base plate, and the walls of a recess and a recessed plate, for a spherical bearing shall be 0.04-inches.

Backing, Masonry, and Sole Plates of Pin, Fabric Pad, and Transverse Stop Bearings

Plan dimensions:	- 0, + 3/16-inch
Thickness:	- 0, + 3/16-inch
Flatness:	Class A tolerance, side in contact with stainless steel sheet, sole plate and pre-formed fabric pad
	Class C tolerance, side in contact with epoxy gel or grout or concrete

Width and length of

PTFE recess:	- 0, + 1/16-inch of PTFE sheet size

The maximum gap between the external restrainer and the circular base plate, and the walls of a recess and a recessed plate, for a spherical bearing shall be 0.04-inches.

Guide Bar and Keeper Bar

Length:	± 1/8 inch
Section Dimensions:	± 1/16-inch
Flatness:	Class A tolerance, side in contact with steel or PTFE
Bar to bar tolerance:	± 1/32-inch

Bars shall not be more than 1/32-inch out of parallel

Bearing Block

Plan dimensions:	- 0, + ⅛ inch
Thickness:	± 0.015-inch
Groove radius for pin:	As shown in the Plans

Keeper ring grooves in bearing block

Radius, inner and outer:	± 0.005-inch
Depth of groove:	± 0.010-inch

Keeper Ring

Radius, inner and outer:	± 0.010-inch
Thickness:	± 0.030-inch

Pin

Length, shldr to shldr:	-0.020, + 0-inch
Diameter:	As shown in the Plans

Overall Height

HLMR bearing:	- 1/16, + 3/16-inch
Fabric pad bearing:	- 1/16, + 3/16-inch
Pin bearing:	- 0, + 10-percent

6-02.3(19)C2 HLMR Bearing Specific Fabrication Requirements

All bolted connections between structural steel surfaces shall meet the maximum spacing for sealing bolts in accordance with the AASHTO LRFD Bridge Design Specifications.

When the following components are shown in the Plans as part of the HLMR bearing assembly, the following specific fabrication requirements shall apply:

1. PTFE Sheet:
   a. The thickness of solid PTFE sheet shall be a minimum of ⅛-inch and a maximum of 3/16-inch. Solid PTFE sheet shall be recessed for a depth equal to one-half of its thickness into the material it is bonded to.
   b. The thickness of woven PTFE fabric, if used, shall be a minimum of 1/16-inch and a maximum of ⅛-inch.
   c. Dimpled PTFE, if shown in the Plans, shall be unfilled and shall have a maximum thickness of 3/16-inch. Dimples shall be placed on a ½-inch grid and have a depth of 1/16-inch.

d. PTFE sheet shall be recessed and chemically bonded to the supporting steel plate or bar, except that woven PTFE sheet shall be mechanically bonded to the supporting plate or bar. Bonding shall be performed In accordance with the PTFE manufacturer's written procedure.

e. Following the bonding operation, the PTFE surface shall be smooth and free from bubbles. Filled PTFE shall be polished after the bonding operation is complete, in accordance with the AASHTO LRFD Bridge Construction Specifications.

2. Stainless Steel Sheet:

a. The stainless steel sliding surface shall completely cover the PTFE surface in all operating positions plus one additional inch in all directions.

b. The stainless steel shall be 14-gage thick for the main sliding surfaces and 10-gage thick for the guide bars.

c. The stainless steel sheet shall be seal welded all around to the supporting steel plate or bar by the gas tungsten arc welding (GTAW) process in accordance with current AWS specifications. The stainless steel sheet shall be clamped down to have full contact with the supporting steel plate or bar during welding. The welds shall not protrude beyond the sliding surface of the stainless steel sheet.

d. The curved surfaces of spherical bearings that receive stainless steel shall be weld overlaid to produce a surface chemistry equivalent to ASTM A240 Type 304L or 316L stainless steel as shown in the Plans.

e. Stainless steel welded overlay on the curved surface of spherical bearings shall be a minimum of 3/32-inch thick after welding, grinding, and polishing.

3. Steel Plates and Bars:

a. Sole plates and masonry plates shall be 3/4-inch minimum thickness, unless otherwise shown in the Plans.

b. Each guide bar and keeper bar shall be fabricated from a single steel plate.

c. Guide bars and keeper bars shall be connected to the bearing assembly by recessing and bolting.

d. The stainless steel sheet shall be welded to the guide bar or keeper bar before attaching the bar to the bearing assembly.

e. The space between the guide bar or keeper bar and the guided component shall be 3/16-inch ± 1/16-inch.

6-02.3(19)C3 Non-HLMR Bearing Specific Fabrication Requirements

When the following components are shown in the Plans as part of the fabric pad bearing, pin bearing, or transverse stop bearing assembly, the following specific fabrication requirements shall apply:

1. PTFE Sheet:
   a. PTFE shall be ⅛-inch, unless otherwise shown in the Plans. PTFE shall be recessed for a depth equal to one-half of its thickness into the material it is bonded to, with the exposed height of PTFE not less than 3/64-inch.
   b. Dimpled PTFE, if shown in the Plans, shall be unfilled and shall have a maximum thickness of 3/16-inch. Dimples shall be placed on a 1/2-inch grid and have a depth of 1/16-inch.
   c. PTFE sheet shall be recessed and chemically bonded to the supporting steel plate or bar, except that woven PTFE sheet shall be mechanically bonded to the supporting plate or bar. Bonding shall be performed in accordance with the PTFE manufacturer's written procedure.
   d. Following the bonding operation, the PTFE surface shall be smooth and free from bubbles. Filled PTFE shall be polished after the bonding operation is complete, in accordance with the AASHTO LRFD Bridge Construction Specifications.
2. Stainless Steel Sheet:
   a. The stainless steel sheet shall be seal welded all around to the supporting steel plate or bar by the gas tungsten arc welding (GTAW) process in accordance with current AWS specifications.
   b. The stainless steel sheet shall be clamped down to have full contact with the supporting steel plate or bar during welding.
   c. The welds shall not protrude beyond the sliding surface of the stainless steel sheet.
3. Steel Plates and Bars:
   a. Each guide bar and keeper bar shall be fabricated from a single steel plate.
   b. Guide bars and keeper bars shall be connected to the bearing assembly by welding or bolting, as shown in the Plans.

6-02.3(19)D Corrosion Protection

Steel surfaces, except as otherwise specified below, shall be painted in accordance with Section 6-07.3(9), with a finish coat paint color as specified in Section 6-03.3(30) as supplemented in the Special Provisions. The surfaces of all welds fastening stainless steel to structural steel shall be painted as specified for structural steel. Stainless steel shall not be painted. Galvanized fastening hardware (anchor bolts, bolts, nuts, and washers) shall be painted in accordance with Section 6-07.3(11)A.

All coats of paint as specified in Section 6-07.3(9)A for steel surfaces shall be applied in the shop. After the bearing assembly has been erected in its final position with the anchor bolt nuts installed, all surfaces with damaged paint shall be repaired in accordance with Section 6-07.3(9)I.

All coats of paint as specified in Section 6-07.3(11)A for galvanized fastening hardware shall be applied after the bearing assembly has been erected in its final position with the anchor bolt nuts installed and tightened. The Contractor shall prepare the galvanized surfaces for painting in accordance with Section 6-07.3(11)A except only hand or power tool cleaning methods shall be used.

The embedded pipe assembly of the bearing assembly anchorage, when shown in the Plans, shall not be painted.

The following pin bearing components shall be painted only with one shop applied coat of inorganic zinc primer in accordance with Section 6-07.3(9).

1. Keeper rings.
2. Keeper ring groove surface in the bearing blocks.

The following pin bearing components and surfaces shall not be painted, but shall instead be coated with #2 extreme pressure grease:

1. Machined surfaces of the bearing blocks that contact the pin and keeper rings.
2. All surfaces of the pins.
3. All threads of the pin nuts.

The primer paint coated keeper rings shall be coated with #2 extreme pressure grease prior to final bearing assembly.

6-02.3(19)E HLMR Bearing Testing

The Contractor shall provide for HLMR bearing testing. The testing shall be performed by the testing entity selected in accordance with Section 6-02.3(19)B6.

All testing performed by the bearing manufacturer shall be witnessed by the inspection entity performing the certified shop inspection of the bearings.

Failure of the test bearing will result in rejection of all bearings.

The testing requirements specified below may be waived provided:

1. The bearing manufacturer, through the Contractor, shall submit a Type 1 Working Drawing consisting of certified test results from a previous installation of HLMR bearings of similar design and load capacity. This submittal shall accompany the design calculation submittal of Section 6-02.3(19)B1 and the fabrication shop plan submittal of Section 6-02.3(19)B3.
2. The tests performed on the previously installed bearings satisfy the requirements specified below.
3. All test requirements performed on and not satisfied by the previously installed bearings shall be performed on and satisfied by a test bearing in this Contract through a disc bearing Proof Load test conforming to Section 6-02.3(19)E1 or a spherical bearing Wear and Damage Characteristics test conforming to Section 6-02.3(19)E2, as appropriate.

The test bearing may be used as a production bearing provided:

1. The test bearing passed the test.
2. The test bearing was selected from the production bearings.
3. All PTFE in the test bearing assembly shall be replaced with new PTFE.

6-02.3(19)E1 Disc Bearing Proof Load Testing

When fabrication of disc bearings is complete, a Proof Load test shall be performed either on disc bearing assemblies randomly selected from the production bearings, or an equal number of prototype bearings with a minimum design capacity of 400-kips. One disc bearing per lot shall be tested where one lot is defined as a maximum of 25-production bearings.

The Proof Load test shall be performed on the selected test bearing assemblies as follows:

1. A proof load of 150-percent of the design capacity of the bearing shall be applied at the maximum design bearing rotation for a duration of five-minutes, removed, and then reapplied for five-minutes.
2. A bevel plate with a taper equal to the maximum design bearing rotation shall be used to simulate the specified bearing rotation.
3. After completing the specified load duration, the bearing shall be disassembled and inspected for wear and damage.
4. The test bearing shall show no signs of defects and failure while under load, and after disassembly and inspection.

6-02.3(19)E2 Spherical Bearing Wear and Damage Characteristics Testing

When fabrication of spherical bearings is complete, a Wear and Damage Characteristics test shall be performed on spherical bearing assemblies randomly selected from the production bearings. For bearings with a design capacity in excess of 1,000-kips, prototype bearings may be used for the Wear and Damage Characteristics test. One spherical bearing per lot shall be tested where one lot is defined as a maximum of 25-production bearings.

The Wear and Damage Characteristic test shall be performed on the selected test bearing assemblies as follows:

1. The bearing shall be subjected to 5,000-cycles of rotation (2.0 degrees each direction from level, 4.0 degrees total rotation) under the specified vertical dead load plus live load.
2. After completing the load cycles, the bearing shall be disassembled and inspected for wear and damage. A 1/64-inch reduction in PTFE thickness, or damage to the bearing, shall be cause for rejection of the bearing assembly.
3. The test bearing shall show no signs of defects and failure while under load, and after disassembly and inspection.

6-02.3(19)F Bearing Inspection and Acceptance

Three levels of inspection shall be satisfied before the bearings are accepted. The manufacturer shall provide for both Quality Control and Quality Assurance Inspection in accordance with Section 6-02.3(19)F1 and 6-02.3(19)F2. The manufacturer shall provide access for the Final Shop Inspection in accordance with Section 6-02.3(19)F3.

The bearings shall satisfy each of the three levels of inspection as specified below prior to acceptance. Bearings that fail any one of the three levels of inspection shall have the deficiencies addressed in accordance with Section 1-05.7. All proposed corrective procedures shall be submitted as a Type 2 Working Drawing.

6-02.3(19)F1 Quality Control Inspection

During the fabrication process of all bearing assembly components and units, the manufacturer shall provide full time Quality Control Inspection to ensure that the materials and workmanship meet or exceed the minimum requirements of the Contract. Quality Control Inspection shall be the responsibility of the manufacturer's quality control group, which shall be independent of the fabrication group.

6-02.3(19)F2 Quality Assurance Inspection

Quality Assurance Inspection shall be performed by the independent inspection entity performing the certified shop inspection in accordance with Section 6-02.3(19)B5. Quality Assurance Inspection is not required to be full time inspection, but shall be done at all phases of the manufacturing process. The frequency of inspection shall be included in the Quality Assurance Inspection Program.

6-02.3(19)F3 Final Shop Inspection

Prior to shipping the bearings to the job site, a randomly selected representative number of production bearings shall be inspected by the independent inspection entity at the manufacturer's facility. The manufacturer shall provide a clean, dry, and enclosed area for the bearing inspection. The manufacturer shall disassemble and reassemble the bearings for inspection by the independent inspection entity. The independent inspection entity shall certify that the bearings have been inspected, and that the bearings have been manufactured in full compliance with the Contract requirements.

6-02.3(19)G Bearing Component Assembly, Shipping, and Storage

Each bearing, except bearing components welded to the bottom flange of steel girders or embedded into concrete superstructure, shall be fully assembled at the manufacturing plant and delivered to the construction site as a complete unit, ready for installation. The units shall be held together with removable restraints so that the sliding surfaces are not damaged. Softeners shall be placed under the restraints to protect all painted surfaces. The Contractor shall not damage the painted surfaces while shipping, storing and installing the bearing assemblies.

All bearing assemblies shall be marked with the following information prior to shipping:

1. Location of the bearing, including the pier and the specific location along the pier.
2. Direction arrow pointing in the ahead-on-station direction.

The above information shall be marked on the top plate of the upper unit of the bearing assembly. The marks shall be permanent and shall be visible after bearing installation.

The bearing assemblies shall have centerlines marked on both upper and lower units for checking alignment in the field.

The bearing assemblies shall be shipped in light-proof, moisture-proof and dust-proof containers.

6-02.3(19)H Bearing Assembly Field Inspection

The Contracting Agency may perform field inspection of bearing assemblies at the discretion of the Engineer. The Contractor shall provide a clean, dry and enclosed area at the site, spacious enough for the field inspection activities. The Contractor shall disassemble and reassemble the bearings for inspection by the Engineer. The disassembly and reassembly of the bearings shall be in accordance with the bearing manufacturer's written procedure and in the presence of the Engineer.

Bearings that fail the field inspection shall have the deficiencies addressed in accordance with Section 1-05.7. All proposed corrective procedures shall be submitted as a Type 2 Working Drawing.

6-02.3(19)I Bearing Assembly Installation

The Contractor shall install the bearing assembly in accordance with the installation procedure included with the fabrication shop drawing submittal required by Section 6-02.3(19)B3.

Sliding surfaces shall be finished true, lubricated, and installed level, or installed as shown in the Plans for transverse stop bearings.

PTFE sheet shall not be greased, except as otherwise noted. A thin uniform film of silicone grease shall be applied to the entire dimpled PTFE sheet before installation (all dimples shall be filled with grease).

For bearing assemblies with PTFE and stainless steel components, the Contractor shall take special care at all times to ensure protection of the PTFE and stainless steel surfaces from coming in contact with concrete and any other foreign matter.

The grout pad, and masonry plate when shown in the Plans, shall be formed and placed in accordance with Section 6-02.3(20), and installed level. The grout pad thickness shall be adjusted based on final bearing design dimensions, and to achieve final grade profile elevations as shown in the Plans. When shown with a masonry plate, the grout pad shall be pressure installed starting at the middle of the masonry plate.

For cast-in-place concrete superstructures, the upper units of bearing assemblies shall be anchored to the superstructure as shown in the Plans. For steel and precast concrete superstructures, the uppermost unit of bearing assemblies shall be connected or anchored to the superstructure as shown in the Plans.

When specified in the Plans for bearing assemblies supporting steel or precast concrete superstructure, the interface between the sole plate and the bridge superstructure (or the upper and lower sole plates when two separate components) shall be set with epoxy gel just before setting the superstructure in place. The (lower) sole plate surface in contact with the epoxy gel shall receive a thin uniform film of silicone grease, to prevent bonding to the epoxy gel. The threads of the sole plate clamping bolts shall be greased to prevent bonding and allow future removal. The Contractor shall apply the epoxy gel by troweling it onto the bottom surface of the steel girder flange or the upper sole plate welded to the steel girder flange and shall immediately bolt the (lower) sole plate in place to obtain a level surface.

Before the epoxy gel has cured, the steel or precast concrete superstructure shall be set in place, squeezing out the excess epoxy gel while filling the interface between the steel surfaces. Excess epoxy and grease shall be removed immediately. After the epoxy gel has cured, the sole plate clamping bolts shall be tightened to snug tight.

When the upper unit of the pin bearing consists of an upper bearing block welded to a sole plate, the top surface of the sole plate shall receive a thin uniform film of silicone grease, and the bolt threads connecting the pin assembly to the steel superstructure shall be greased, prior to fastening the sole plate to the steel superstructure.

Specified surfaces of the bearing blocks, pins, and pin nuts shall be coated with grease as specified in Section 6-02.3(19)D.

After installation, the orientation of the spherically curved units shall be ± ½ degree from level.

6-02.3(20) Grout for Anchor Bolts and Bridge Bearings

Grout shall conform to Section 9-20.3(2) for anchor bolts and for bearing assemblies with bearing plates. Grout shall conform to Section 9-20.3(3) for elastomeric bearing pads and fabric pad bearings without bearing plates.

Grout shall be a workable mix with a viscosity that is suitable for the intended application. Grout shall not be placed outside of the manufacturer recommended range of thickness. The Contractor shall receive concurrence from the Engineer before using the grout.

Field grout cubes and cylinders shall be fabricated and tested in accordance with Section 9-20.3 when requested by the Engineer, but not less than one per bridge pier or once per day.

Before placing grout, the substrate on which it is to be placed shall be prepared as recommended by the manufacturer to ensure proper bonding. The grout shall be cured as recommended by the manufacturer. The grout may be loaded when a minimum of 4,000 psi compressive strength is attained.

To grout bridge bearing masonry plates, the Contractor shall:

1. Build a form approximately 4 inches high with sides 4 inches outside the base of each masonry plate,
2. Fill each form to the top with grout,
3. Work grout under all parts of each masonry plate,
4. Remove each form after the grout has hardened,
5. Remove the grout outside each masonry plate to the base of the masonry plate,
6. Bevel off the grout neatly to the top of the masonry, and
7. Place no additional load on the masonry plate until the grout has set at least 72 hours.

After all grout under the masonry plate and in the anchor bolt cavities has attained a minimum strength of 4,000 psi, the anchor bolt nuts shall be tightened to snug tight. “Snug tight” means either the tightness reached by (1) a few blows from an impact wrench, or (2) the full effort of a person using a spud wrench. Once the nut is snug tight, the anchor bolt threads shall be burred just enough to prevent loosening of the nut.

6-02.3(21) Drainage of Box Girder Cells

To drain box girder cells, the Contractor shall provide and install, according to details in the Plans, short lengths of nonmetallic pipe in the bottom slab at the low point of each cell. The pipe shall have a minimum inside diameter of 4 inches. If the difference in Plan elevation is 2 inches or less, the Contractor shall install pipe in each end of the box girder cell. All drainage holes shall be screened in accordance with the Plan details.

6-02.3(22) Drainage of Substructure

The Contractor shall use weep holes and gravel backfill that complies with Section 9-03.12(2) to drain fill material behind retaining walls, abutments, tunnels, and wingwalls. To maintain thorough drainage, weep holes shall be placed as low as possible. Weep holes shall be covered with geotextile meeting the requirements of Section 9-33.2, Table 2 Class C before backfilling. Geotextile screening shall be bonded to the concrete with an accepted adhesive. Gravel backfill shall be placed and compacted as required in Section 2-09.3(1)E. In addition, if the Plans require, tiling, French or rock drains, or other drainage devices shall be installed.

If underdrains are not installed behind the wall or abutment, all backfill within 18 inches of weep holes shall comply with Section 9-03.12(4). Unless the Plans require otherwise, all other backfill behind the wall or abutment shall be gravel backfill for walls.

6-02.3(23) Opening to Traffic

Bridges with a bridge deck made of concrete shall remain closed to all traffic, including construction equipment, until the concrete has reached the 28-day specified compressive strength. This strength shall be determined with cylinders made of the same concrete as the bridge deck and cured under the same conditions. A concrete deck bridge shall never be opened to traffic earlier than 10 days after the deck concrete was placed and never before the Engineer allows.

For load restrictions on bridges under construction, refer to Section 6-01.6.

After curing bridge approach slabs in accordance with Section 6-02.3(11), the bridge approach slabs may be opened to traffic when a minimum compressive strength of 2,500 psi is achieved.

6-02.3(24) Reinforcement

Although a bar list is normally included in the Plans, the Contracting Agency does not guarantee its accuracy and it shall be used at the Contractor's risk. Reinforcement fabrication details shall be determined from the information provided in the Plans.

Before delivery of the reinforcing bars, the Contractor shall submit Type 1 Working Drawings consisting of two informational copies of the supplemental bending diagrams.

6-02.3(24)A Field Bending

Field bending of AASHTO M31 Grade 60 and ASTM A706 Grade 60 reinforcement shall be done in accordance with the requirements of this section. Field bending of all other reinforcement shall require a Type 2 Working Drawing showing the bend radii, bending and heating procedures, and any inspection or testing requirements.

Field bending shall not be done on reinforcement within the top or bottom third of column lengths or within plastic hinge regions identified in the Plans. Field bending shall not be done on bar sizes No. 14 or No. 18.

In field-bending steel reinforcing bars, the Contractor shall:

1. Make the bend gradually using a bending tool equipped with a bending diameter as listed in Table 1. Bending shall not be done by means of hammer blows and pipe sleeves. When bending to straighten a previously bent bar, move a hickey bar progressively around the bend.
2. Apply heat as described below for bending bar sizes No. 6 through No. 11 and for bending bar sizes No. 5 and smaller when the bars have been previously bent. Previously unbent bars of sizes No. 5 and smaller may be bent without heating when the bar temperature is 40°F or higher. When previously unbent bars of sizes No. 5 and smaller have a bar temperature lower than 40°F, they shall be heated to within the range of 100°F to 150°F prior to bending. In applying heat for field-bending steel reinforcing bars, the Contractor shall:
    a. Avoid damage to the concrete by insulating any concrete within 6 inches of the heated bar area;
    b. Apply two heat tips simultaneously at opposite sides of bar sizes No. 7 or larger;
    c. Heat the bar to within the required temperature range shown in Table 2 as verified by using temperature-indicating crayons or other suitable means;
    d. Heat a minimum bar length as shown in Table 3. Locate the heated section of the bar to include the entire bending length;
    e. Bend immediately after the required temperature range has been achieved. Maintain the bar within the required temperature range during the entire bending process;
    f. Do not cool bars artificially with water, forced air, or other means.
3. Limit any bend or straightening to these maximum angles: 135 degrees for bar sizes No. 8 or smaller, and 90 degrees for bar sizes No. 9 through No. 11.

4. Repair epoxy coating on epoxy coated bars in accordance with Section 6-02.3(24)H.

Table 1 Bending Diameters for Field-Bending Reinforcing Bars

Bar Size	Bend Diameter/Bar Diameter Ratio	
	Heat Not Applied	Heat Applied
No. 4, No. 5	8	8
No. 6 through No. 9	Not Permitted	8
No. 10, No. 11	Not Permitted	10

The minimum bending diameters for stirrups and ties for No. 4 and No. 5 bars when heat is not applied shall be specified in Section 9-07.

Table 2 Preheating Temperatures for Field-Bending Reinforcing Bars

Bar Size	Temperature (F)	
	Minimum	Maximum
No. 4	1,200	1,250
No. 5, No. 6	1,350	1,400
No. 7 through No. 9	1,400	1,450
No. 10, No. 11	1,450	1,500

Table 3 Minimum Bar Length to be Heated (d = nominal diameter of bar)

Bar Size	Bend Angle		
	45°	90°	135°
No. 4 through No. 8	8d	12d	15d
No. 9	8d	12d	Not Permitted
No. 10, No. 11	9d	14d	Not Permitted

6-02.3(24)B Protection of Materials

The Contractor shall protect reinforcing steel from all damage. When placed into the Structure, the steel shall be free from dirt, loose rust or mill scale, paint, oil, and other foreign matter.

When transporting, storing, or constructing in close proximity to bodies of salt water, plain and epoxy-coated steel reinforcing bar shall be kept in enclosures that provide protection from the elements.

If plain or epoxy-coated steel reinforcing bar is exposed to mist, spray, or fog that may contain salt, it shall be flushed with fresh water prior to concrete placement.

When the Engineer requires protection for reinforcing steel that will remain exposed for a length of time, the Contractor shall protect the reinforcing steel:

1. By cleaning and applying a coat of paint conforming to Section 9-08.1(2)B over all exposed surfaces of steel, or

2. By cleaning and painting paint conforming to Section 9-08.1(2)B on the first 6 inches of the steel bars protruding from the concrete and covering the bars with polyethylene sleeves.

The paint shall have a minimum dry film thickness of 1 mil.

Epoxy-coated steel reinforcing bars shall not be exposed to environmental conditions for a cumulative duration exceeding 60 days on site prior to full embedment in concrete. Any provisions made to protect the reinforcing bars shall provide suitable protection from ultraviolet radiation including light and allow adequate ventilation to minimize condensation.

6-02.3(24)C Placing and Fastening

The Contractor shall position reinforcing steel as the Plans require and shall ensure that the steel is set within specified tolerances. Adjustments to reinforcing details outside of specified tolerances to avoid interferences and for other purposes are acceptable when approved by the Engineer.

When spacing between bars is 1 foot or more, they shall be tied at all intersections. When spacing is less than 1 foot, every other intersection shall be tied. If the Plans require bundled bars, they shall be tied together with wires at least every 6 feet. All epoxy-coated bars in the top mat of the bridge deck shall be tied at all intersections, however they may be tied at alternate intersections when spacing is less than 1 foot in each direction and they are supported by continuous supports meeting all other requirements of supports for epoxy-coated bars. Other epoxy-coated bars shall also be tied at all intersections, but shall be tied at alternate intersections when spacing is less than 1 foot in each direction. Wire used for tying epoxy-coated reinforcing steel shall be plastic coated. **Tack welding is not permitted on reinforcing steel**.

Abrupt bends in the steel are permitted only when one steel member bends around another. Vertical stirrups shall pass around main reinforcement or be firmly attached to it.

For slip-formed concrete, the reinforcing steel bars shall be tied at all intersections and cross braced to keep the cage from moving during concrete placement. Cross bracing shall be with additional reinforcing steel. Cross bracing shall be placed both longitudinally and transversely.

After reinforcing steel bars are placed in a traffic or pedestrian barrier and prior to slip-form concrete placement, the Contractor shall check clearances and reinforcing steel bar placement. This check shall be accomplished by using a template or by operating the slip-form machine over the entire length of the traffic or pedestrian barrier. All clearance and reinforcing steel bar placement deficiencies shall be corrected by the Contractor before slip-form concrete placement.

Precast concrete supports (or other accepted devices) shall be used to maintain the concrete coverage required by the Plans. The precast concrete supports shall:

1. Have a bearing surface measuring not greater than 2 inches in either dimension, and
2. Have a compressive strength equal to or greater than that of the concrete in which they are embedded.

In slabs, each precast concrete support shall have either: (1) a grooved top that will hold the reinforcing bar in place, or (2) an embedded wire that protrudes and is tied to the reinforcing steel. If this wire is used around epoxy-coated bars, it shall be coated with plastic.

Precast concrete supports may be accepted based on a Manufacturer's Certificate of Compliance.

In lieu of precast concrete supports, the Contractor may use metal or all-plastic supports to hold uncoated bars. Any surface of a metal chair support that will not be covered by at least ½ inch of concrete shall be one of the following:

1. Hot-dip galvanized after fabrication in keeping with AASHTO M232 Class D;
2. Coated with plastic firmly bonded to the metal. This plastic shall be at least 3⁄32 inch thick where it touches the form and shall not react chemically with the concrete when tested in the State Materials Laboratory. The plastic shall not shatter or crack at or above -5°F and shall not deform enough to expose the metal at or below 200°F; or
3. Stainless steel that meet the requirements of ASTM A493, Type 302. Stainless steel chair supports are not required to be galvanized or plastic coated.

In lieu of precast concrete supports, epoxy-coated reinforcing bars may be supported by one of the following:

1. Metal supports coated entirely with a dielectric material such as epoxy or plastic,
2. Other epoxy-coated reinforcing bars, or
3. All-plastic supports.

Damaged coatings on metal bar supports shall be repaired prior to placing concrete.

All-plastic supports shall be lightweight, non-porous, and chemically inert in concrete. All-plastic supports shall have rounded seatings, shall not deform under load during normal temperatures, and shall not shatter or crack under impact loading in cold weather. All-plastic supports shall be placed at spacings greater than 1 foot along the bar and shall have at least 25 percent of their gross place area perforated to compensate for the difference in the coefficient of thermal expansion between plastic and concrete. The shape and configuration of all-plastic supports shall permit complete concrete consolidation in and around the support.

A “mat” is two adjacent and perpendicular layers of reinforcing steel. In bridge decks, top and bottom mats shall be supported adequately enough to hold both in their proper positions. If bar supports directly support, or are directly supported on No. 4 bars, they shall be spaced at not more than 3-foot intervals (or not more than 4-foot intervals for bars No. 5 and larger). Wire ties to girder stirrups shall not be considered as supports. To provide a rigid mat, the Contractor shall add other supports and tie wires to the top mat as needed.

Unless noted otherwise, the minimum concrete cover for main reinforcing bars shall be:

3 inches to a concrete surface deposited against earth without intervening forms.

2½ inches to the top surface of a concrete bridge deck or bridge approach slab.

2 inches to a concrete surface when not specified otherwise in this section or in the Contract documents.

1½ inches to a concrete barrier or curb surface.

Except for top cover in bridge decks and bridge approach slabs, minimum concrete cover to ties and stirrups may be reduced by ½ inch but shall not be less than 1 inch. Minimum concrete cover shall also be provided to the outermost part of mechanical splices and headed steel reinforcing bars.

Reinforcing steel bar location, concrete cover, and clearance shall not vary more than the following tolerances from what is specified in the Contract documents:

Reinforcing bar location for members 12 inches or less in thickness: ±0.25 inch

Reinforcing bar location for members greater than 12 inches in thickness: ±0.375 inch

Reinforcing bar location for bars placed at equal spacing within a plane: the greater of either ±1 inch or ±1 bar diameter within the plane. The total number of bars shall not be fewer than that specified.

The clearance between reinforcement shall not be less than the greater of the bar diameter or 1 inch for unbundled bars. For bundled bars, the clearance between bundles shall not be less than the greater of 1 inch or a bar diameter derived from the equivalent total area of all bars in the bundle.

Longitudinal location of bends and ends of bars: ±1 inch

Embedded length of bars and length of bar lap splices:

No 3 through No. 11	-1 in.
No. 14 through No. 18	-2 in.

Concrete cover measured perpendicular to concrete surface (except for the top surface of bridge decks, bridge approach slabs and other roadway surfaces): ±0.25 inch

Concrete cover measured perpendicular to concrete surface for the top surface of bridge decks, bridge approach slabs and other roadway surfaces: +0.25 inch, -0 inch

Before placing any concrete, the Contractor shall:

1. Clean all mortar from reinforcement, and
2. Obtain the Engineer's permission to place concrete after the Engineer has inspected the placement of the reinforcing steel. (Any concrete placed without the Engineer's permission shall be rejected and removed.)

6-02.3(24)D Splicing

The Contractor shall supply steel reinforcing bars in the full lengths the Plans require. Unless the Engineer concurs in writing, the Contractor shall not change the number, type, or location of splices.

The Engineer may permit the Contractor to use thermal or mechanical splices in place of the method shown in the Plans if they are of an accepted design. Use of a new design may be granted if:

1. The Contractor provides technical data and proof from the manufacturer that the design will perform satisfactorily, and
2. Sample splices and materials from the manufacturer pass the Engineer's tests.

The Contractor shall:

1. Not lap-splice reinforcing bars Nos. 14 or 18.
2. Not permit any welded or mechanical splice to deviate in alignment more than ¼ inch per 3½ feet of bar.
3. Distribute splices evenly, grouping them together only at points of low tensile stress.
4. Ensure at least 2 inches clearance between any splice and the nearest bar or the surface of the concrete (or 1½ inch for the length of the sleeve on mechanical splices).
5. Rigidly clamp or wire all splices in a way accepted by the Engineer.
6. Place lap-spliced bars in contact for the length of the splice and tie them together near each end.
7. Securely fasten the ends and edges of welded-wire-fabric reinforcement, overlapping them enough to maintain even strength.

6-02.3(24)D1 Splicing of Hoop Reinforcement for Columns and Shafts

When the Plans show steel reinforcement bar hoops, the hoops shall be spliced by one of the following methods:

1. Resistance butt weld splice, welded in accordance with Section 6-02.3(24)I.
2. Welded direct butt splice, welded in accordance with Section 6-02.3(24)J.
3. Welded lap splice if shown in the Plans, welded in accordance with Section 6-02.3(24)K.

All welded splices of hoop reinforcement shall be welded in the shop.

6-02.3(24)E Welding Reinforcing Steel

Welding of steel reinforcing bars shall conform to the requirements of ANSI/AWS D1.4 Structural Welding Code – Reinforcing Steel, latest edition, except where superseded by the Special Provisions, Plans, and these Specifications.

Before any welding begins, the Contractor shall submit a Type 2 Working Drawing consisting of the welding procedure for each type of welded splice to be used, including the weld procedure Specifications and joint details. The weld procedure Specifications shall be written on a form taken from AWS D1.4 Annex A, or equivalent. Test results of tensile strength, macroetch, and visual examination shall be included. The form shall be signed and dated.

Welders shall be qualified in accordance with AWS D1.4. The Contractor shall be responsible for the testing and qualification of welders, and shall submit Type 2 Working Drawings consisting of welder qualification and retention records. The weld joint and welding position a welder is qualified in shall be in accordance with AWS D1.4. The welder qualifications shall remain in effect indefinitely unless, (1) the welder is not engaged in a given process of welding for which the welder is qualified for a period exceeding 6 months, or (2) there is some specific reason to question a welder's ability.

Filler metals used for welding reinforcing bars shall be in accordance with AWS D1.4 Table 5.1. All filler metals shall be low-hydrogen and handled in compliance with low-hydrogen practices specified in the AWS code.

Short circuiting transfer with gas metal arc welding will not be allowed. Slugging of welds will not be allowed.

For the purpose of compatibility with AWS D1.4, welded lap splices for spiral or hoop reinforcing shall be considered Flare-V groove welds, indirect butt joints.

The Contractor is responsible for using a welding sequence that will limit the alignment distortion of the bars due to the effects of welding. The maximum out-of-line permitted will be ¼ inch from a 3.5-foot straightedge centered on the weld and in line with the bar.

The ground wire from the welding machine shall be clamped to the bar being welded.

Where epoxy-coated steel reinforcing bars are specified to be spliced by welding, the epoxy coating shall be left off or removed from the surfaces to be heated, but in no cases less than six inches of each bar being welded. After the welding is complete, the Contractor shall apply epoxy patching material to the uncoated portions of the bar in accordance with Section 6-02.3(24)H.

6-02.3(24)F Mechanical Splices

The Contractor shall form mechanical splices with an Engineer-accepted system using sleeve filler metal, threaded coupling, or another method that complies with this section.

If necessary to maintain required clearances after the splices are in place, the Contractor shall adjust, relocate, or add stirrups, ties, and bars.

Before splicing, the Contractor shall provide the Engineer with the following information for each shipment of splice material:

1. The type or series identification (and heat treatment lot number for threaded-sleeve splices),
2. The grade and size of bars to be spliced,
3. A manufacturer's catalog with complete data on material and procedures,
4. A written statement from the manufacturer that the material is identical to that used earlier by the Engineer in testing and accepting the system design, and
5. A written statement from the Contractor that the system and materials will be used according to the manufacturer's instructions and all requirements of this section.

All splices shall meet these criteria:

1. Mechanical splices shall develop at least 125 percent of the specified yield strength of the unspliced bar. The ultimate tensile strength of the mechanical splice shall exceed that of the unspliced bar.
2. The total slip of the bar within the spliced sleeve of the connector after loading in tension to 30.0 ksi and relaxing to 3.0 ksi shall not exceed the following measured displacements between gage points clear of the splice sleeve:
    a. 0.01 inches for bar sizes up to No. 14.
    b. 0.03 inches for No. 18 bars.
3. The maximum allowable bar size for mechanical laps splices shall be No. 6.

The Engineer will visually inspect the splices and accept all that appear to conform with the test samples. For sleeve-filler splices, the Engineer will allow voids within the limits on file in the Working Drawing design submittal. If the Engineer considers any splice defective, it shall be removed and replaced at the Contractor's expense.

In preparing sleeve-filler metal splices, the Contractor shall:

1. Clean the bar surfaces by: (a) oxyacetylene torch followed by power wire brushing, or (b) abrasive blasting;
2. Remove all slag, mill scale, rust, and other foreign matter from all surfaces within and 2 inches beyond the sleeve;
3. Grind down any projection on the bar that would prevent placing the sleeve;

4. Prepare the ends of the bars as the splice manufacturer recommends and as the accepted procedure requires; and
5. Preheat, just before adding the filler, the entire sleeve and bar ends to 300°F, plus or minus 50°F. (If a gas torch is used, the flame shall not be directed into the sleeve.)

When a metallic, sleeve-filler splice is used (or any other system requiring special equipment), both the system and the operator shall qualify in the following way under the supervision of the State Materials and Fabrication Inspector. The operator shall prepare six test splices (three vertical, three horizontal) using bars having the same AASHTO Designation and size (maximum) as those to be used in the Work. Each test sample shall be 6 foot plus the length of the splice. The bar alignment shall not deviate more than ⅛ inch from a straight line over the whole length of the sample. All six samples must meet the tensile strength and slip criteria specified in this section.

The Contractor shall provide labor, materials, and equipment for making these test samples at no expense to the Contracting Agency. The Contracting Agency will test the samples at no cost to the Contractor.

6-02.3(24)G Job Control Tests

As the Work progresses, the Engineer may require the Contractor to provide a sample splice (thermal or mechanical) to be used in a job control test. The operator shall create this sample on the job site with the Engineer present using bars of the same size as those being spliced in the Work. The sample shall comply with all requirements of these Specifications, and is in addition to all other sample splices required for qualification. The Engineer will require no more than two samples on any project with fewer than 200 splices and no more than one sample per 100 splices on any project with more than 200 splices.

6-02.3(24)H Epoxy-Coated Steel Reinforcing Bar

This Work is furnishing, fabricating, coating, and placing epoxy-coated steel reinforcing bars as the Plans, these Specifications, and the Special Provisions require. Coating material shall be applied electrostatically, by spraying, or by the fluidized-bed method.

All epoxy-coated bars shall comply with the requirements of Section 9-07. Fabrication may occur before or after coating.

The Contractor shall protect epoxy-coated bars from damage using padded or nonmetallic slings and straps free from dirt or grit. To prevent abrasion from bending or sagging, the Contractor shall lift bundled bars with a strong-back, multiple supports, or a platform bridge. Bundled bars shall not be dropped or dragged. During shop or field storage, bars shall rest on wooden or padded cribbing. The Contractor may substitute other methods for protecting the bars if the Engineer concurs. If the Engineer believes the coated bars have been badly damaged, they will be rejected.

Metal chairs and supports shall be coated with epoxy (or another inert coating accepted by the Engineer). The Contractor may use other support devices with the Engineer's concurrence. Plastic coated tie wires (accepted by the Engineer) shall be used to protect the coated bars from being damaged during placement.

The bars shall be placed as the Plans require and held firmly in place during placing and setting of the concrete. All bars shall be placed and fastened as specified in Section 6-02.3(24)C.

In the interval between installing coated bars and concreting the deck, the Contractor shall protect the coating from damage that might result from other construction Work.

The Engineer will inspect the coated bars after they are placed and before the deck concrete is placed. The Contractor shall patch any areas that show significant damage (as defined below).

Significant damage means any opening in the coating that exposes the steel in an area that exceeds:

1. 0.05 square inch (approximately ¼ inch square or ¼ inch in diameter or the equivalent).
2. 0.012 square inches (approximately ⅛ inch square or ⅛ inch in diameter) when the opening is within ¼ inch of another opening of equal or larger size.
3. 6 inches long, any width.
4. 0.50 square inch aggregate area in any 1 foot length of bar.

The Contractor shall patch significantly damaged areas with a patching material obtained from the epoxy resin manufacturer and accepted by the Engineer. This material shall be compatible with the coating and inert in concrete. Areas to be patched shall be clean and free of surface contaminants. Patching shall be done before oxidation occurs and according to the resin manufacturer's instructions.

6-02.3(24)I Resistance Butt Weld Splicing of Hoop Reinforcement for Columns and Shafts

6-02.3(24)I1 Splicing Quality Control Manager

The Contractor shall designate in writing a Splicing Quality Control Manager (SQCM). The SQCM shall be responsible for the quality of all hoop reinforcement splicing, including the inspection of materials and workmanship, and submitting, receiving, and approving all correspondence, required submittals, and reports regarding hoop reinforcement splicing to and from the Engineer.

6-02.3(24)I2 Splice Sample Test Facilities

Qualification testing and testing of production sample splices shall be performed at an independent qualified testing laboratory at no additional expense to the Contracting Agency. The laboratory shall have the following:

1. Proper facilities, including a tensile testing machine capable of breaking full size samples of all steel reinforcing bar splices.
2. Operators who have received documented training for performing the testing requirements of ASTM A370.
3. A record of annual calibration of testing equipment performed by an independent third party that has standards that are traceable to the National Institute of Standards and Technology and a formal reporting procedure, including published test forms. Calibration records shall be made available for the Engineer's review upon request.

6-02.3(24)I3 Splice Qualification Report

The Contractor shall submit a Splice Qualification Report as a Type 2 Working Drawing. This report shall include, at a minimum:

1. Name of the designated Splicing Quality Control Manager (SQCM).
2. Splice material information
3. Names of the operators who will be performing the splicing
4. Descriptions of the positions, locations, equipment, and procedures that will be used in the splice work.
5. Fabricator's Quality Control Manual for the fabrication of hoops including, but not be limited to, the following:
    a. The pre-production procedures for the qualification of material and equipment.
    b. The methods and frequencies for performing quality control procedures during production.
    c. The calibration procedures and calibration frequency for all equipment.
    d. The welding procedure specification for resistance welding.
    e. The method for identifying and tracking lots.
6. Certifications from the fabricator for qualifications of operators and procedures based on sample qualification tests performed within the past 24 months of the date of the Splice Qualification Report submittal.
    a. Each operator shall be certified by performing two sample splices for each bar size of each splice type that the operator will be performing in the work.
7. Certified test results for all qualification sample splices, tested by an independent qualified testing laboratory and conforming to the specified production test criteria.

6-02.3(24)I4 Production Control Splice Test Criteria

For the purpose of hoop reinforcement splice testing, a lot of splices are defined as 200, or a fraction thereof, of the same type of splice for each bar diameter that is used in the work. A production control sample shall consist of four splices removed from each lot of completed splices.

The Contractor shall select the splices comprising the lot. The Engineer will, or the SQCM shall if the Engineer is not available, select the product control sample of four splices to be tested from each lot.

Production control testing shall be performed for all hoop reinforcement splices used in the work. Production control samples shall be tested in accordance with ASTM A370.

6-02.3(24)I5 Sample Test Criteria

After the splices in a lot have been completed, the SQCM shall notify the Engineer in writing that the splices in this lot conform to the specifications and are ready for testing.

At least one week before sample testing, the Contractor shall notify the Engineer by a Type 1 Working Drawing of the date and location of the testing to allow the Engineer the opportunity to witness the testing.

Samples shall achieve at least 125 percent of the specified yield strength of the bar. In addition, either necking of the bar or a plateau of the stress-strain curve shall be evident at rupture.

6-02.3(24)I6 Sample Acceptance Criteria

If all four sample splices from a lot conform to the requirements of Section 6-02.3(24)I5, all splices in the lot represented by the test will be considered acceptable.

If only two or three of the four sample splices from a lot conform to the requirements of Section 6-02.3(24)I5, the Engineer will, or the SQCM shall if the Engineer is not available, select an additional set of four samples for re-test from the same lot of splices. Should any of the four sample splices from this additional test fail to conform to these requirements; all splices in the lot will be rejected.

Should only one sample splice from a lot conform to the requirements of Section 6-02.3(24)I5, all splices in the lot will be rejected.

Whenever a lot of splices are rejected, the rejected lot and subsequent lots of splices shall not be used in the work until the following requirements are met:

1. The SQCM performs a complete review of the Contractor's quality control process for these splices.
2. A written report is submitted to the Engineer describing the cause of the failure of the splices in this lot and provisions for preventing similar failures in future lots.
3. The Engineer has provided the Contractor with written notification that the report and any corrective action is acceptable.

All bars within a lot shall be visually inspected to verify bar offset at the joint doesn't exceed what is permitted in ANSI/AWS D1.4/D1.4M:2018 Section 6.2.1. Any splice with offsets exceeding those as specified in ANSI/AWS D1.4/D1.4M:2018 Section 6.2.1 will be rejected.

6-02.3(24)I7 Reporting Test Results

A Production Control Test Report for all testing performed on each lot shall be prepared by the independent testing laboratory performing the testing and submitted to the SQCM. The report shall include the following information for each test:

1. Contract number.
2. Dates received and tested.
3. Lot number.
4. Bar diameter, hoop diameter, and bar length.
5. Type of splice.
6. Length of test specimen.
7. Physical condition of the test sample splice and description of break and location in relation to splice.
8. Any noticeable defects.
9. Ultimate tensile strength of each splice.

The SQCM shall review, approve with a signature, and submit each Production Control Test Report as a Type 2 Working Drawing. The Contractor shall not encase the splices represented by the report in concrete until receiving the Engineer's written response to the submittal.

6-02.3(24)J Welded Direct Butt Splicing of Hoop Reinforcement for Columns and Shafts

6-02.3(24)J1 Welded Direct Butt Splices

Welded direct butt splices shall be complete joint penetration butt welds conforming to ANSI/AWS D1.4/D1.4M:2018 figure 5.2. Split pipe backing shall not be used.

Thermite welding is not allowed.

6-02.3(24)J2 Nondestructive Splice Tests

Radiographic examinations shall be performed on 25 percent of all complete joint penetration butt welded splices from a lot defined as 200, or a fraction thereof, of the same type of splice for each bar diameter that is used in the work.

All splices shall be 100 percent visually inspected.

All required radiographic examinations shall be performed by the Contractor in accordance with ANSI/AWS D1.4/D1.4M:2018 and as specified below.

Before radiographic examination, welds shall conform to ANSI/AWS D1.4/D1.4M Section 6.4. Radiographic acceptance shall be in accordance with ANSI/AWS D1.4/D1.4M Table 6.1. Acceptance criteria for bar size #7 shall be the same as for bar size #8.

Should more than 12 percent of the splices which have been radiographically examined in any lot be defective, an additional 25 percent of the splices from the same lot, selected by the Engineer, or by the SQCM if the Engineer is not available, shall be radiographically examined. Should more than 12 percent of the cumulative total of splices tested from the same lot be defective, all remaining splices in the lot shall be radiographically examined.

All defects shall be repaired in accordance with ANSI/AWS D1.4/D1.4M, latest edition.

The Contractor shall notify the Engineer in writing a minimum of 48 hours before performing any radiographic examinations.

The radiographic procedure used shall conform to ANSI/AWS D1.1, ANSI/AWS D1.4/D1.4M:2018 Section 9.9, and the following:

1. Two exposures shall be made for each splice. For each of the two exposures, the radiation source shall be centered on each bar to be radiographed. The first exposure shall be made with the radiation source placed at zero degrees from the top of the weld and perpendicular to the weld root and identified with a station mark of “0”. The second exposure shall be at 90 degrees to the “0” station mark and shall be identified with a station mark of “90”. When obstructions prevent a 90 degree placement of the radiation source for the second exposure, and when approved in writing by the Engineer, the source may be rotated, around the centerline of the steel reinforcing bar, a maximum of 25 degrees.
2. If more than one weld is to be radiographed during one exposure, the angle between the root line of each weld and the direction to the radiation source shall not be less than 65 degrees.
3. Radiographs shall be made by either X-ray or gamma ray. Radiographs made by X-ray or gamma rays shall have densities of not less than 2.3 nor more than 3.5 in the area of interest. A tolerance of 0.05 in density is allowed for densitometer variations. Gamma rays shall be from the iridium 192 isotope and the emitting specimen shall not exceed 0.18 inches in the greatest diagonal dimension.
4. The radiographic film shall be placed perpendicular to the radiation source at all times; parallel to the root line of the weld unless source placement determines that the film shall be turned; and as close to the root of the weld as possible.
5. The minimum source to film distance shall be maintained so as to ensure that all radiographs maintain a maximum geometric unsharpness of 0.020 at all times, regardless of the size of the steel reinforcing bars.

6. Penetrameters shall be placed on the source side of the bar and perpendicular to the radiation source at all times. One penetrameter shall be placed in the center of each bar to be radiographed, perpendicular to the weld root, and adjacent to the weld. Penetrameter images shall not appear in the weld area.
7. When radiography of more than one weld is being performed per exposure, each exposure shall have a minimum of one penetrameter per bar, or three penetrameters per exposure. When three penetrameters per exposure are used, one penetrameter shall be placed on each of the two outermost bars of the exposure, and the remaining penetrameter shall be placed on a centrally located bar.
8. An allowable weld buildup of 0.16 inch may be added to the total material thickness when determining the proper penetrameter selection. No image quality indicator equivalency will be accepted. Wire penetrameters or penetrameter blocks shall not be used.
9. Penetrameters shall be sufficiently shimmed using a radiographically identical material. Penetrameter image densities shall be a minimum of 2.0 and a maximum of 3.6.
10. Radiographic film shall be Class 1, regardless of the size of the steel reinforcing bars.
11. Radiographs shall be free of film artifacts and processing defects, including, but not limited to, streaks, scratches, pressure marks or marks made for the purpose of identifying film or welding indications.
12. Each splice shall be identified on each radiograph and the radiograph identification and marking system shall be established between the Contractor and the Engineer before radiographic inspection begins. Film shall be identified by lead numbers only; etching, flashing or writing in identifications of any kind will not be permitted. Each piece of film identification information shall be legible and shall include, as a minimum, the following information:
    a. The Contractor's name.
    b. The name of the nondestructive testing firm.
    c. Contract number.
    d. Date of the test.
    e. Initials of the radiographer.
    f. Part number.
    g. Weld number.

    The letter "R" and repair number shall be placed directly after the weld number to designate a radiograph of a repaired weld.
13. Radiographic film shall be developed within a time range of one minute less to one minute more than the film manufacturer's recommended maximum development time. Sight development will not be allowed.

14. Processing chemistry shall be done with a consistent mixture and quality, and processing rinses and tanks shall be clean to ensure proper results. Records of all developing processes and any chemical changes to the developing processes shall be kept and furnished to the Engineer upon request. The Engineer may request, at any time, that a sheet of unexposed film be processed in the presence of the Engineer to verify processing chemical and rinse quality.
15. The results of all radiographic interpretations shall be recorded on a signed certification and a copy kept with the film packet.

Technique sheets prepared in accordance with ASME Boiler and Pressure Vessels Code Section V Article 2 Section T-291 shall also contain the developer temperature, developing time, fixing duration and all rinse times.

The Contractor shall maintain the radiographs and the radiographic inspection report(s) in the shop until the Engineer reviews them or requests copies. If the Engineer reviews them in the shop then the film and reports shall be released to the Engineer for permanent record keeping at that time. If copies are requested, the Contractor shall submit a Type 2 Working Drawing consisting of the film and a PDF or two paper copies of the radiographic inspection report. Adequate facilities and equipment shall be provided the Engineer for examining film, if performed in the shop.

If the Engineer has not reviewed the film and reports in the shop or requested copies within ten working days of completion of the lot, the Contractor shall submit a Type 2 Working Drawing consisting of the film and reports.

6-02.3(24)K Welded Lap Splicing of Hoop Reinforcement for Shafts

All production splices shall be 100 percent visually inspected for weld quality, size and length.

6-02.3(25) Prestressed Concrete Girders

Precast concrete girders shall be constructed in accordance with Section 6-02.3(9), except as modified in this section.

The manufacturing facility of prestressed concrete girders shall be certified by the Precast/Prestressed Concrete Institute's Plant Certification Program for the type of prestressed member to be produced and shall be approved by WSDOT as a Certified Prestress Concrete Fabricator prior to the start of production. WSDOT certification will be granted at, and renewed during, the annual prestressed plant review and approval process in accordance with WSDOT *Materials Manual* M 46-01.04 Standard Practice QC 6.

The Contracting Agency intends to perform Quality Assurance Inspection. By its inspection, the Contracting Agency intends only to facilitate the Work and verify the quality of that Work. This inspection shall not relieve the Contractor of any responsibility for identifying and replacing defective material and workmanship.

The various types of prestressed concrete girders are:

Prestressed Concrete I Girder – Refers to a prestressed concrete girder with a flanged I shaped cross section, requiring a cast-in-place concrete deck to support traffic loads. WSDOT standard girders in this category include Series W42G, W50G, W58G, and W74G.

Prestressed Concrete Wide Flange I Girder – Refers to a prestressed concrete girder with an I shaped cross section with wide top and bottom flanges, requiring a cast-in-place concrete deck to support traffic loads. WSDOT standard girders in this category include Series WF36G, WF42G, WF50G, WF58G, WF66G, WF74G, WF83G, WF95G, and WF100G.

Prestressed Concrete Wide Flange Deck Girder – Refers to a prestressed concrete wide flange I girder with extended top flange widths designed to support traffic loads, and designed to be mechanically connected at the flange edges to adjacent girders at the job site. WSDOT standard girders in this category include Series WF39DG, WF45DG, WF53DG, WF61DG, WF69DG, WF77DG, WF86DG, WF98DG, and WF103DG.

Prestressed Concrete Wide Flange Thin Deck Girder – Refers to a prestressed concrete wide flange I girder with extended top flange widths requiring a cast-in-place concrete deck to support traffic loads. Flange edges extend to flange edges of adjacent girders at the job site. WSDOT standard girders in this category include Series WF36TDG, WF42TDG, WF50TDG, WF58TDG, WF66TDG, WF74TDG, WF83TDG, WF95TDG, and WF100TDG.

Prestressed Concrete Deck Bulb Tee Girder – Refers to a prestressed concrete girder with a top flange designed to support traffic loads, and designed to be mechanically connected at the flange edges to adjacent girders at the job site. WSDOT standard girders in this category include Series W35DG, W41DG, W53DG, and W65DG.

Prestressed Concrete Slab Girder – Refers to a prestressed concrete slab girder, with or without voids. Prestressed concrete ribbed section girders and prestressed concrete double tee girders shall conform to the requirements specified for prestressed concrete slab girders.

Prestressed Concrete Tub Girder – Refers to prestressed concrete tub girders with a U shaped cross section, requiring a cast-in-place concrete deck to support traffic loads. WSDOT standard girders in this category include Series U**G* or Series UF**G*, where U specifies webs without top flanges, UF specifies webs with top flanges, ** specifies the girder height in inches, and * specifies the bottom flange width in feet.

Spliced Prestressed Concrete Girder – Refers to prestressed concrete girders initially fabricated in segments which are longitudinally spliced together with cast-in-place concrete closures and post tensioning. Post tensioning materials and construction shall conform to Section 6-02.3(26), except that ducts for prestressed concrete wide flange I girders may be 24-gage, semi-rigid, galvanized, corrugated, ferrous metal. WSDOT prestressed concrete wide flange I girders in this category include Series WF74PTG, WF83PTG, WF95PTG, and WF100PTG. WSDOT prestressed concrete tub girders in this category include Series U**PTG* and UF**PTG* where U, UF, **, and * are as defined for prestressed concrete tub girders.

6-02.3(25)A Shop Drawings

Shop drawings for prestressed concrete girders shall be submitted as Type 2 Working Drawings. The only deviations to the Plans that will be permitted are those approved by the annual plant approval process and those listed below:

1. Addition of inserts for construction purposes including falsework.
2. Small penetrations no larger than 1-inch diameter for construction purposes including overhang bracket supports, deck formwork hangers and temporary girder bracing. Penetrations in top flanges shall be offset from the edge of the flange the minimum distance shown in the Plans.
3. Small penetrations no larger than 2-inch in diameter for girder shipping tie-downs.
4. Small adjustments in girder length to account for elastic shortening, creep and shrinkage
5. Strand adjustments, as long as the center of gravity of the strands remains at the location shown in the plans and concrete cover is not reduced.
6. Diaphragm web hole vertical adjustments to avoid harped strands.
7. Substitution of welded wire reinforcement for conventional reinforcing steel.

Shop drawings shall show the size and location of all inserts and penetrations. Penetrations for deck formwork and falsework shall match the deck formwork Working Drawings. Field-drilled holes in prestressed concrete girders are not allowed.

Deformed welded wire reinforcement conforming to Sections 9-07.7 and 9-07.8 may be substituted for the mild steel reinforcement shown in the plans. The substitution shall be submitted as a Type 2E Working Drawing. The AASHTO LRFD Bridge Design Specification requirements (latest edition including interims) shall be satisfied, including at a minimum the following Articles:

5.8.2.6 Types of Transverse Reinforcement

5.8.2.8 Design and Detailing Requirements

5.10.3 Spacing of Reinforcement

5.10.6.3 Ties

5.10.7 Transverse Reinforcement for Flexural Members

5.10.8 Shrinkage and Temperature Reinforcement

5.10.10 Pretensioned Anchorage Zones

5.11.2.5 Welded Wire Fabric

5.11.2.6.3 Anchorage of Wire Fabric Reinforcement

5.11.6 Splices of Welded Wire Fabric

Yield strengths in excess of 75.0 ksi shall not be used for welded wire reinforcement.

The spacing of vertical welded wire reinforcement within slabs and girder webs shall not exceed 18 inches or the height of the member minus 3 inches, whichever is less. Longitudinal wires and welds are permitted in girder flanges but shall be excluded from girder webs. For vertical welded wire reinforcement in prestressed concrete slab girders, no welded joints other than those required for anchorage shall be permitted. Epoxy-coated wire and welded wire reinforcement shall conform to Section 9-07.3 with the exception that ASTM A884 Class A Type I shall be used instead of ASTM A775.

Shop drawings for spliced prestressed concrete girders shall also conform to Section 6-02.3(26)A. The Working Drawings for spliced prestressed concrete girders shall include all details related to the post-tensioning operations in the field, including details of hardware required, tendon geometry, blockout details, and details of additional or modified steel reinforcing bars required in cast-in-place closures.

6-02.3(25)B Prestressing

Each stressing system shall have a pressure gauge or load cell that will measure jacking force. The gauge shall display pressure accurately and readably with a dial at least 6 inches in diameter or with a digital display. Each jack and its gauge shall be calibrated as a unit and shall be accompanied by a certified calibration chart. The Contractor shall submit a Type 1 Working Drawing consisting of one copy of this chart. The cylinder extension during calibration shall be in approximately the position it will occupy at final jacking force.

Jacks and gauges shall be recalibrated and recertified:

1. Annually,
2. After any repair or adjustment, and
3. Anytime there are indications that the jack calibration is in error.

The Engineer may use load cells to check jacks, gauges, and calibration charts before and during tensioning.

All load cells shall be calibrated and shall have an indicator that shows prestressing force in the strand. The range of this cell shall be broad enough that the lowest 10 percent of the manufacturer's rated capacity will not be used to measure jacking force.

From manufacture to encasement in concrete, prestressing strand shall be protected against dirt, oil, grease, damage, and all corrosives. Strand shall be stored in a dry, covered area and shall be kept in the manufacturer's original packaging until placement in the forms. If prestressing strand has been damaged or pitted, it will be rejected. Prestressing strand with rust shall be spot-cleaned with a nonmetallic pad to inspect for any sign of pitting or section loss. Once the prestressing steel has been installed, no welds or grounds for welders shall be made on the forms or the steel in the girder, except as specified.

When the Plans require temporary strands, they may be pretensioned or post-tensioned. If they are post-tensioned, they shall be stressed on the same day that the permanent prestress is released and prior to lifting the girder or segment. When the Plans require continuous temporary strands for spliced prestressed concrete girders, the girder

shall be spliced and the temporary strands shall be post-tensioned prior to lifting the spliced girder.

The Contractor shall be responsible for properly sizing the anchorage plates to prevent bursting or splitting of the concrete due to post-tensioning. The inside diameter of the debonding sleeves for all temporary strands shall be large enough such that the temporary strands fully retract upon cutting. Temporary strands shall be cut or released in accordance with Section 6-02.3(25)L5.

Post-tensioning of spliced prestressed concrete girders shall conform to Section 6-02.3(26) and the following requirements:

1. Before tensioning, the Contractor shall remove all side forms from the cast-in-place concrete closures. From this point until 48 hours after grouting the tendons, the Contractor shall keep all construction and other live loads off the Superstructure and shall keep the falsework supporting the superstructure in place.
2. The Contractor shall not tension the post-tensioning reinforcement until the concrete in the cast-in-place closures reaches the minimum compressive strength specified in the Plans. This strength shall be measured with concrete cylinders made of the same concrete and cured under the same conditions as the cast-in-place closures.
3. All post-tensioning shall be completed before placing the sidewalks and barriers on the Superstructure.

6-02.3(25)C Casting

Side forms shall be steel except that cast-in-place concrete closure forms for spliced prestressed concrete girders, interior forms of prestressed concrete tub girders, and end bulkhead forms of prestressed concrete girders may be wood. Interior voids for prestressed concrete slab girders with voids shall be formed by either wax soaked cardboard or expanded polystyrene forms. The interior void forms shall be secured in the position as shown in the Working Drawings, and shall remain in place.

All concrete mixes to be used shall be preapproved in the WSDOT plant certification process. The temperature of the concrete when placed shall be between 50°F and 90°F.

Slump shall not exceed 4 inches for normal concrete nor 7 inches with the use of a high range water-reducing admixture, nor 9 inches when both a high range water-reducing admixture is used and the water/cement ratio is less than or equal to 0.35. For self-consolidating concrete (SCC), the slump requirements specified above do not apply, and are instead replaced by the target slump flow and slump flow range specified as part of the SCC mix design.

Air-entrainment is not required in the concrete placed into prestressed concrete girders, including cast-in-place concrete closures for spliced prestressed concrete girders.

6-02.3(25)C1 Acceptance Testing of Concrete for Prestressed Concrete Girders

Compressive strength cylinders and concrete acceptance testing shall be performed once per prestressed concrete girder or once per fabrication line of prestressed concrete girders. Concrete shall not be placed until fresh concrete testing indicates concrete is within acceptable limits.

Acceptance testing shall be performed by the Contractor and test results shall be submitted to the Engineer. Unless otherwise noted below, the test methods described in Section 6-02.3(5)D shall be followed. Concrete compressive strength shall be in accordance with Section 6-02.3(25)E.

Concrete that is not self-consolidating concrete will be accepted as follows:

1. Temperature within the allowable temperature band.
2. Slump below the maximum allowed.

Concrete that is self-consolidating concrete will be accepted as follows:

1. Temperature within the allowable temperature band.
2. Slump flow within the target slump flow range
3. VSI less than or equal to 1 in accordance with ASTM C1611, Appendix X1, using Filling Procedure B.
4. J ring passing ability less than or equal to 1.5-inches.
5. Rapid assessment of static segregation resistance of self-consolidating concrete using penetration test in accordance with ASTM C1712 shall be less than or equal to 15 mm.

6-02.3(25)D Curing

During curing, the Contractor shall keep the girder in a saturated curing atmosphere until the girder concrete has reached the required release strength. If the Engineer concurs, the Contractor may shorten curing time by heating the outside of impervious forms. Heat may be radiant, convection, conducted steam, or hot air. With steam, the arrangement shall envelop the entire surface with saturated steam. Hot air curing will not be allowed, unless the Contractor submits Type 2 Working Drawings consisting of the proposed method to envelop and maintain the girder in a saturated atmosphere. Saturated atmosphere means a relative humidity of at least 90 percent. The Contractor shall never allow dry heat to touch the girder surface at any point.

Under heat curing methods, the Contractor shall:

1. Keep all unformed girder surfaces in a saturated atmosphere throughout the curing time;
2. Embed a thermocouple (linked with a thermometer accurate to plus or minus 5°F) 6 to 8 inches from the top or bottom of the girder on its centerline and near its midpoint;

3. Monitor with a recording sensor (accurate to plus or minus 5°F) arranged and calibrated to continuously record, date, and identify concrete temperature throughout the heating cycle;
4. Make this temperature record available for the Engineer to inspect;
5. Heat concrete to no more than 100°F during the first 2 hours after placing the concrete, and then increase no more than 25°F per hour to a maximum of 175°F;
6. Cool concrete, after curing is complete, no more than 25°F per hour, to 100°F; and
7. Keep the temperature of the concrete above 60°F until the girder reaches release strength.

The Contractor may strip side forms from prestressed concrete girders once the concrete has reached a minimum compressive strength of 3,000 psi. All damage from stripping is the Contractor's responsibility.

Curing of cast-in-place concrete closures for spliced prestressed concrete girders shall conform to Section 6-02.3(11).

6-02.3(25)E Contractors Control Strength

Concrete strength shall be measured on test cylinders cast from the same concrete as that in the girder. These cylinders shall be cured under time-temperature relationships and conditions that simulate those of the girder. If the forms are heated by steam or hot air, test cylinders will remain in the coolest zone throughout curing. If forms are heated another way, the Contractor shall provide a record of the curing time-temperature relationship for the cylinders for each girder to the Engineer. When two or more girders are cast in a continuous line and in a continuous pour, a single set of test cylinders may represent all girders provided the Contractor demonstrates uniformity of casting and curing to the satisfaction of the Engineer.

The Contractor shall mold, cure, and test enough of these cylinders to satisfy Specification requirements for measuring concrete strength. The Contractor may use 4- by 8-inch or 6- by 12-inch cylinders.

Test cylinders may be cured in a moist room or water tank in accordance with FOP for AASHTO T 23 after the girder concrete has obtained the required release strength. If, however, the Contractor intends to ship the girder prior to the standard 28-day strength test, the design strength for shipping shall be determined from cylinders placed with the girder and cured under the same conditions as the girder. These cylinders may be placed in a noninsulated, moisture-proof envelope.

To measure concrete strength in the girder, the Contractor shall randomly select two test cylinders. The average compressive strength of the two cylinders shall be equal or greater than the specified strength and neither cylinder shall have a compressive strength that is more than 5 percent below the specified strength.

If too few cylinders were molded to carry out all required tests on the girder, the Contractor shall remove and test cores from the girder under the surveillance of the

Engineer. If the Contractor casts cylinders to represent more than one girder, all girders in that line shall be cored and tested. Cores shall avoid all prestressing strands, steel reinforcing bars and interior voids.

For prestressed concrete slab girders, a test shall consist of four cores measuring 3 inches in diameter by 6 inches in length (for slabs) or by the thickness of the web (for ribbed and double tee sections). Two cores shall be taken from each side of the girder with one on each side of the girder span midpoint, at locations accepted by the Engineer. The core locations for prestressed concrete ribbed and double tee sections shall be immediately beneath the top flange.

For prestressed concrete tub girders, a test shall consist of four cores measuring 3 inches in diameter by the thickness of the web. Two cores shall be taken from each web approximately 3 feet to the left and to the right of the center of the girder span.

For all other prestressed concrete girders, a test shall consist of three cores measuring 3 inches in diameter by the thickness of the web and shall be removed from just below the top flange; one at the midpoint of the girder's length and the other two approximately 3 feet to the left and approximately 3 feet to the right.

The cores shall be taken in accordance with AASHTO T 24 and shall be tested in accordance with AASHTO T 22. The Engineer may accept the girder if the average compressive strength of the all test cores from the girder are at least 85 percent of the specified compressive strength with no one core less than 75 percent of specified compressive strength. If there are more than four cored holes in a girder, the prestressing reinforcement shall not be released until the holes are patched and the patch material has attained a minimum compressive strength equal to the required release compressive strength.

All cored holes shall be patched and cured prior to shipment of the girder. The girder shall not be shipped until tests show the patch material has attained a minimum compressive strength of 4,000 psi.

If the annual plant approval includes procedures for patching cored holes, the cored holes shall be patched in accordance with this procedure. Otherwise, the Contractor shall submit a core hole patching procedure as a Type 2 Working Drawing.

6-02.3(25)F Prestress Release

Side and flange forms that restrain deflection shall be removed before release of the prestressing reinforcement.

All strands shall be released in a way that will minimize eccentricity of the prestressing force about the centerline of the girder. This release shall not occur until tests show each girder has reached the minimum compressive strength required by the Plans.

The Contractor may request permission to release the prestressing reinforcement at a minimum concrete compressive strength less than specified in the Plans. This request shall be submitted as a Type 2E Working Drawing analyzing changes in vertical deflection, girder lateral stability and concrete stresses in accordance with Section 6-02.3(25)L2.

6-02.3(25)G Protection of Exposed Reinforcement

When a girder is removed from its casting bed, all prestressing reinforcement strands projecting from the girder shall be cleaned and painted with a minimum dry film thickness of 1 mil of paint conforming to Section 9-08.1(2)B, and all steel reinforcing bars, including welded wire fabric, projecting from the girder shall be protected in accordance with Section 6-02.3(24)B. During handling and shipping, projecting reinforcement shall be protected from bending or breaking. Just before placing concrete around the painted projecting bars or strands, the Contractor shall remove from them all spattered concrete remaining from girder casting, dirt, oil, and other foreign matter.

6-02.3(25)H Finishing

The Contractor shall apply a Class 1 finish, as defined in Section 6-02.3(14), to:

1. The exterior surfaces of the outside girders; and
2. The bottoms, sides, and tops of the lower flanges on all girders, including the top of the bottom slab between the tub girder webs.

All other girder surfaces shall receive a Class 2 finish.

The interface on girders that contact a cast-in-place concrete deck shall have a finish of dense, screeded concrete without a smooth sheen or laitance on the surface. After vibrating and screeding, and just before the concrete reaches initial set, the Contractor shall texture the interface. This texture shall be applied with a steel brooming tool that etches the surface transversely leaving grooves ⅛ to ¼ inch wide, between ⅛ and ¼ inch deep, and spaced ¼ to ½ inch apart.

On prestressed concrete wide flange deck girders, deck bulb tee girders, ribbed section girders and double tee girders, the Contractor shall test the top surface for flatness and make corrections in accordance with Section 6-02.3(10)D3 except that the straightedge need not exceed the width of the girder top flange when checking the transverse direction. The top surface shall be finished in accordance with Section 6-02.3(10)D6.

The Contractor may repair defects in prestressed concrete girders in accordance with Section 6-01.16.

6-02.3(25)I Fabrication Tolerances

The girders shall be fabricated as shown in the processed shop drawings, and shall meet the dimensional tolerances listed below. Construction tolerances of cast-in-place closures for spliced prestressed concrete girders shall conform to the tolerances specified for spliced prestressed concrete girders. Actual acceptance or rejection will depend on how the Engineer believes a defect outside these tolerances will affect the Structure's strength or appearance:

1. Length: ± ¼ inch per 25 feet of beam length, up to a maximum of ± 1½ inches

2. Width:

Flanges and webs:	+ ⅜ inch, - ¼ inch
Slab girders:	± ¼ inch

3. Girder Depth (overall): ± ¼ inch

4. Flange Depth: ± ¼ inch

5. Strand Position:

Individual strands:	± ¼ inch
Bundled strands:	± ½ inch
Harped strand group center of gravity at the girder ends:	± 1 inch

6. Longitudinal Location of Harp Points for Harped

   Strands from Design Locations: ± 20 inches

7. Position of an Interior Void, vertically and horizontally: ± ½ inch

8. Bearing Recess (center of recess to girder end): ± ⅝ inch

9. Girder Ends (deviation from square or designated skew):

Horizontal:	± ⅛ inch per foot of girder width, up to a maximum of ± ½ inch
Vertical:	± 3/16 inch per foot of girder depth, up to a maximum of ± 1 inch

10. Bearing Area Deviation from Plane (in length or width of bearing): ± ⅛ inch.

11. Stirrup Reinforcing Spacing: ± 1 inch.

12. Stirrup Projection from Top of Girder:

Wide flange thin deck and slab girders:	± ½ inch
All other girders:	± ¾ inch

13. Mild Steel Concrete Cover: - ⅛ inch, + ⅜ inch.

14. Local smoothness of any surface: ± ¼ inch. in 10 feet

15. Differential Camber between Girders in a Span (measured in place at the job site):

    For wide flange deck and deck bulb tee girders with a cast-in-place reinforced concrete deck:

    Cambers shall be equalized when the differences in cambers between adjacent girders exceeds ± ¾ inch

    For wide flange deck, deck bulb tee and slab girders without a cast-in-place reinforced deck:

    Cambers shall be equalized when the differences in cambers between adjacent girders exceeds ± ¼ inch

16. Position of Inserts for Structural Connections: ± 1 inch.
17. Position of Lifting Embedments: ± 3 inches longitudinal, ± ¼ inch transverse.
18. Weld Ties: ± ½ inch longitudinal, ± ⅛ inch vertical.
19. Position of post tensioning ducts in spliced prestressed concrete girders: ± ¼ inch.
20. Deviation from a smooth curve for post-tensioning ducts at closures based on the sum total of duct placement and alignment tolerances: ± ⅜ inch.

6-02.3(25)J Horizontal Alignment

The Contractor shall check and record the horizontal alignment (sweep) of each girder at the following times:

1. Initial – Upon removal of the girder from the casting bed
2. Shipment – Within 14 days prior to shipment; and
3. Erection – After girder erection and cutting temporary top strands but prior to any equalization, welding ties or placement of diaphragms.

Horizontal alignment of the top and bottom flanges shall be checked and recorded. Alternatively, the Contractor may check and record the horizontal alignment of the web near mid-height of the girder. Each check shall be made by measuring the maximum offset at mid-span relative to a chord that starts and stops at the girder ends. The Contractor shall check and record the alignment at a time when the girder is not influenced by temporary differences in surface temperature. Records for the initial check (item 1 above) shall be included in the Contractor's prestressed concrete certificate of compliance. Records for all other checks shall be submitted as a Type 1 Working Drawing.

For each check (items 1 to 3 above), the alignment shall not be offset more than ⅛ inch for each 10 feet of girder length. Girders not meeting this tolerance for the shipment check (item 2 above) shall require an analysis of girder lateral stability and stresses in accordance with Section 6-02.3(25)L2. The Contractor shall perform this analysis and submit it as a Type 2E Working Drawing prior to shipment of the girder. Any girder that exceeds an offset of ⅛ inch for each 10 feet of girder length for the erection check (item 3 above) shall be corrected at the job site to the ⅛ inch maximum offset per 10 feet of girder length before concrete is placed into the diaphragms. The Contractor shall submit a Type 2 Working Drawing for any required corrective action.

The maximum distance between the side of a prestressed concrete slab girder, or the edge of the top flange of a wide flange deck, wide flange thin deck or deck bulb tee girder, and a chord that extends the full length of the girder shall be ± ½ inch after erection (item 3 above).

6-02.3(25)K Vertical Deflection

The Contractor shall check and record the vertical deflection (camber) of each girder at the following times:

1. Initial – Upon removal of the girder from the casting bed;
2. Shipment – Within 14 days prior to shipment;
3. Erection – After girder erection and cutting temporary top strands but prior to any equalization, welding ties or placement of diaphragms.

At a minimum, survey data shall be taken at each girder end and at midspan. The Contractor shall perform and record each check at a time when the alignment of the girder is not influenced by temporary differences in surface temperature. Records for the initial check (Item 1 above) shall be included in the Contractor's Prestressed Concrete Certificate of Compliance. Records for all other checks shall be submitted as a Type 1 Working Drawing.

Girders with vertical deflections not meeting the limit shown in the Plans for the shipment check (item 2 above) shall require an analysis of girder lateral stability and stresses in accordance with Section 6-02.3(25)L2. The Contractor shall perform this analysis and submit it as a Type 2E Working Drawing prior to shipment.

The "D" dimensions shown in the Plans are computed upper and lower bounds of girder vertical deflections at midspan based on a time lapse of 40 and 120 days after release of the prestressing strands. Any temporary top strands are assumed to be cut 30 days prior to these elapsed times (10 and 90 days after release of the prestressing strands). Any diaphragms are assumed to be placed. The "D" dimensions are intended to advise the Contractor of the expected range of girder vertical deflection at the time of deck placement. A positive (+) "D" dimension indicates upward deflection.

If the girder vertical deflection measured for the erection check (item 3 above) is not between the lower "D" dimension bound shown in the Plans and the upper "D" dimension bound shown in the Plans plus ¾ inches, the Engineer may require corrective action. The Contractor shall submit a Type 2 Working Drawing for any required corrective action.

6-02.3(25)L Handling and Storage

The Contractor shall be responsible for safely lifting, shipping, and erecting prestressed concrete girders.

During handling and storage, each prestressed concrete girder shall always be kept plumb and upright. It shall be lifted only by the lifting embedments (strand lift loops or high-strength threaded steel bars) at either end.

The Contract documents may provide shipping and handling details for girders including lifting embedment locations (L), shipping support locations (L_1 and L_2), minimum shipping support rotational spring constants (K_θ), minimum shipping support center-to-center wheel spacings (W_{cc}), vertical deflections and number of temporary top strands.

These shipping and handling details have been determined in accordance with Section 6-02.3(25)L2 and are suggested only.

The Contractor shall submit a Type 2E Working Drawing analyzing girder lateral stability and concrete stresses during lifting, storage, shipping and erection in accordance with Section 6-02.3(25)L2 in the following cases:

1. If any of the analysis assumptions listed in Section 6-02.3(25)L2 are invalid. Determination of validity shall be made by the Contractor, except that analysis assumptions shall be considered invalid if the actual values are outside of the provided tolerances.
2. If the Contractor intends to use shipping and handling details different than those provided in the Contract documents.
3. If the Contract documents do not provide shipping and handling details.

6-02.3(25)L1 Lifting and Handling Devices

For strand lift loops, only ½-inch diameter or 0.6-inch diameter strand conforming to Section 9-07.10 shall be used, and a minimum 2-inch diameter straight pin of a shackle shall be used through the loops. Multiple loops shall be held level in the girder during casting in a manner that allows each loop to carry its share of the load during lifting. The minimum distance from the end of the girder to the centroid of the strand lift loops shall be 3 feet. The loops for all prestressed concrete girders, with the exception of prestressed concrete slab girders, shall project a minimum of 1′-6″ from the top of the girder. The loops for prestressed concrete slab girders shall project a minimum of 4 inches. Loops shall extend to within 3 inches clear of the bottom of the girder, terminating with a 9-inch long 90-degree hook. Loads on individual loops shall be limited to 12 kips, and all girders shall be picked up at a minimum angle of 60 degrees from the top of the girder.

For high-strength threaded steel bars, a minimum of two 1⅜-inch diameter bars conforming to Section 9-07.11 shall be used at each end of the girder. The lifting hardware that connects to the bars shall be designed, detailed, and furnished by the Contractor. The minimum distance from the end of the girder to the centroid of the lifting bars shall be 3 feet. Lifting bars shall extend to within 3 inches clear of the bottom of the girder and shall be anchored in the bottom flange with steel plates and nuts. The minimum size of embedded plates for lifting bars shall be ½ inch thick by 3 inches square. Lifting forces on the lifting bars shall not exceed 58 kips on an individual bar, and shall be within 10 degrees of perpendicular to the top of the girder.

6-02.3(25)L2 Girder Lateral Stability and Stress Analysis

Analysis for girder lateral stability and concrete stresses during lifting, storage, shipping and erection shall be in accordance with the PCI *Recommended Practice for Lateral Stability of Precast, Prestressed Concrete Bridge Girders*, First Edition, Publication CB-02-16-E and the AASHTO *LRFD Bridge Design Specifications* edition identified in the Contract documents. The following design criteria shall be met:

1. Factor of Safety against cracking shall be at least 1.0

2. Factor of Safety against failure shall be at least 1.5
3. Factor of Safety against rollover shall be at least 1.5
4. Prestressed concrete girder stresses shall be limited to the following values at all stages of construction and in service:

Condition	Stress	Location	Allowable Stress (ksi)
Temporary Stress at Transfer and Lifting from Casting Bed	Tensile	In areas without bonded reinforcement sufficient to resist the tensile force in the concrete	$0.0948\lambda\sqrt{f'_{ci}} \leq 0.2$
		In areas with bonded reinforcement sufficient to resist the tensile force in the concrete	$0.24\lambda\sqrt{f'_{ci}}$
	Compressive	All locations	$0.65f'_{ci}$
Temporary Stress at Shipping and Erection	Tensile	In areas without bonded reinforcement sufficient to resist the tensile force in the concrete	$0.0948\lambda\sqrt{f'_c} \leq 0.2$
		In areas with bonded reinforcement sufficient to resist the tensile force in the concrete	$0.19\lambda\sqrt{f'_c}$
		In areas with bonded reinforcement sufficient to resist the tensile force in the concrete when shipping at 6% superelevation, without impact	$0.24\lambda\sqrt{f'_c}$
	Compressive	All locations	$0.65f'_c$
Final Stresses at Service Load	Tensile	Precompressed tensile zone	0.0
	Compressive	Effective prestress and permanent loads	$0.45f'_c$
		Effective prestress, permanent loads and transient (live) loads	$0.60f'_c$
Final Stresses at Fatigue Load	Compressive	Fatigue I Load Combination plus one-half effective prestress and permanent loads	$0.40f'_c$

Variables are as defined in the AASHTO LRFD Bridge Design Specifications.

The analysis shall address any effects on girder vertical deflection (camber), “A” dimensions at centerline of bearings and deck screed cambers (C).

Suggested shipping and handling details provided in the Contract documents have been determined using the following analysis assumptions:

1. Girder dimensions, strand locations and lifting embedment locations are within the tolerances specified in Section 6-02.3(25)I
2. Girder horizontal alignment (sweep) is within the tolerance specified in Section 6-02.3(25)J
3. Girder vertical deflection (camber) at midspan is less than or equal to the value shown in the Plans for shipping

4. Minimum concrete compressive strength at release (f'ci) has been reached before initial lifting from casting bed. Minimum concrete compressive strength at 28 days (f'c) has been reached before shipping.
5. Height of girder bottom above roadway at shipping supports is less than or equal to 72 inches
6. Height of shipping support roll center above roadway is 24 inches, ± 2 inches
7. Shipping support longitudinal placement (L_1 and L_2) tolerance is ± 6 inches
8. Shipping support lateral placement tolerance is ±1 inches
9. Shipping supports provide the minimum shipping support rotational spring constant (K_θ) and minimum shipping support center-to-center wheel spacings (W_{cc}) shown in the Plans
10. For shipping at highway speeds a ±20 percent dynamic load allowance (impact) is included with a typical roadway superelevation of 2 percent
11. For turning at slow speeds, no dynamic load allowance (impact) is included with a maximum roadway superelevation of 6 percent
12. Wind, centrifugal and seismic forces are not considered

6-02.3(25)L3 Girder Storage

If girders are to be stored, the Contractor shall place them on a stable foundation that will keep them in a vertical position. Stored girders shall be supported at the bearing recesses or, if there are no recesses, approximately 2 to 3 feet from the girder ends. After post-tensioning, spliced prestressed concrete girders shall be supported at points between 2 and 5 feet from the girder ends, unless otherwise shown in the Plans. For long-term storage of girders with initial horizontal curvature, the Contractor may wedge one side of the bottom flange, tilting the girders to control curvature. If the Contractor elects to set girders out of plumb during storage, the Contractor shall have the proposed method analyzed by the Contractor's engineer to ensure against damaging the girder.

6-02.3(25)L4 Girder Shipping

After the girder has reached its 28-day design strength, the girder and a completed Certification of Compliance, signed by a Precast/Prestressed Concrete Institute Certified Technician or a Professional Engineer, shall be submitted to the Engineer for inspection. If the Engineer finds the certification and the girder to be acceptable, the Engineer will stamp the girder "Approved for Shipment".

No prestressed concrete slab girder shall be shipped for at least 3 days after concrete placement. No prestressed concrete wide flange deck, deck bulb tee or tub girder shall be shipped for at least 7 days after concrete placement, except that they may be shipped 3 days after concrete placement when L/(bd) is less than or equal to 5.0, where L equals the shipping length of the girder, b equals the girder top flange width (for prestressed concrete wide flange deck and deck bulb tee girders) or the bottom flange width (for

prestressed concrete tub girders), and d equals the girder depth, all in feet. No other girder shall be shipped for at least 10 days after concrete placement.

Girder support locations during shipping shall be no closer than the girder depth to the ends of the girder at the girder centerline.

If the Contractor elects to assemble spliced prestressed concrete girders into shipping configurations not shown in the Contract documents, the Contractor shall submit a Type 2E Working Drawing analyzing girder lateral stability and concrete stresses in accordance with Section 6-02.3(25)L2 before shipping.

6-02.3(25)L5 Girder Erection

Before erecting any prestressed concrete girders, the Contractor shall submit an erection plan as a Type 2E Working Drawing. The erection plan shall provide complete details of the erection process including at a minimum:

1. Temporary falsework support, bracing, guys, deadmen, and attachments to other Structure components or objects;
2. Procedure and sequence of operation;
3. Girder stresses during progressive stages of erection in accordance with Section 6-02.3(25)L2;
4. Girder weights, lift points, lifting embedments and devices, spreaders, and angle of lifting cables in accordance with Section 6-02.3(25)L, etc.;
5. Crane(s) make and model, mass, geometry, lift capacity, outrigger size, and reactions;
6. Girder launcher or trolley details and capacity (if intended for use);
7. Locations of cranes, barges, trucks delivering girders, and the location of cranes and outriggers relative to other Structures, including retaining walls and wing walls; and
8. Plans and calculations for all temporary support and bracing systems to resist all anticipated construction loads through construction of the bridge deck.

The erection plan shall include drawings, notes, catalog cuts, and calculations clearly showing the above listed details, assumptions, and dimensions. Material properties and Specifications, structural analysis, and any other data used shall also be included.

The concrete in piers and crossbeams shall reach at least 80 percent of design strength before girders are placed on them.

The Contractor shall hoist girders only by the lifting embedments at the ends, always keeping the girders plumb and upright. When the girders are to receive a cast-in-place concrete deck, lifting embedments shall be removed after erection to provide a minimum 2½-inch clearance to the top of the deck. When the girders are not to receive a cast-in-place concrete deck, lifting embedments shall be removed 1-inch below the girder surface and grouted with an epoxy grout conforming to Section 9-26.3(1)A.

The girders shall be braced in accordance with Sections 6-02.3(17)F4 and 6-02.3(17)F5. **When temporary strands in the top flange are used, they shall be cut after the girders are braced and before the girder deflections are equalized and the intermediate diaphragms are cast**.

Instead of the oak block wedges shown in the Plans, the Contractor may use Douglas fir blocks if the grain is vertical. The height of oak block wedges at the girder centerline shall not exceed the width.

The Contractor shall fill all block-out holes with a mortar or grout acceptable to the Engineer.

Stop plates and dowel bars for prestressed concrete girders shall be set with either epoxy grout conforming to Section 9-26.3 or type IV epoxy bonding agent conforming to Section 9-26.1.

6-02.3(25)M Girder to Girder Connections

When differential camber between adjacent girders in a span exceeds the tolerance in Section 6-02.3(25)I, the Contractor shall submit a method of equalizing deflections as a Type 1 Working Drawing. Any temporary strands in the top flange shall be cut in accordance with Section 6-02.3(25)L5 prior to equalizing girder deflections.

Prestressed concrete girders shall be constructed in the following sequence:

1. If required, deflections shall be equalized in accordance with the Contractor's equalization plan.
2. Any intermediate diaphragms shall be placed and any weld ties shall be welded in accordance with Section 6-03.3(25). Welding ground shall be attached directly to the steel plates being welded when welding the weld-ties.
3. Any keyways between adjacent girders shown in the Plans to receive grout shall be filled flush with the surrounding surfaces using a grout conforming to Section 9-20.3(2).
4. Equalization equipment shall not be removed and other construction equipment shall not be placed on the structure until intermediate diaphragms and keyway grout have attained a minimum compressive strength of 2,500 psi.

6-02.3(26) Cast-In-Place Prestressed Concrete

Unless otherwise shown in the Plans, concrete for cast-in-place prestressed bridge members shall be Class 4000D in the bridge deck, and Class 4000 at all other locations. Air entrainment shall conform to Sections 6-02.3(2)A and 6-02.3(3).

The Contractor shall construct supporting falsework in a way that leaves the Superstructure free to contract and lift off the falsework during post-tensioning. Forms that will remain inside box girders to support the bridge deck shall, by design, resist girder contraction as little as possible.

Before tensioning, the Contractor shall remove all side forms from girders. From this point until 48 hours after grouting the tendons, the Contractor shall keep all construction and other live loads off the Superstructure and shall keep the falsework supporting the Superstructure in place.

Once the prestressing steel is installed, no welds or welding grounds shall be attached to metal forms, structural steel, or reinforcing bars of the structural member.

The Contractor shall not stress the strands until all concrete has reached a compressive strength of at least 4,000 psi (or the strength shown in the Plans). This strength shall be measured on concrete test cylinders made of the same concrete cured under the same conditions as the cast-in-place unit.

All post-tensioning shall be completed before sidewalks and barriers are placed.

6-02.3(26)A Shop Drawings

Before casting the structural elements, the Contractor shall submit Type 2E Working Drawings of the prestressing system shop drawings.

These shop drawings shall show complete details of the methods, materials, and equipment the Contractor proposes to use in prestressing Work. The shop drawings shall follow the design conditions shown in the Plans unless the Engineer permits equally effective variations.

In addition, the shop drawings shall show:

1. The method and sequence of stressing.
2. Technical data on tendons and steel reinforcement, anchorage devices, anchorage device efficiency and acceptance test results and records, anchoring stresses, types of tendon conduit, and all other data on prestressing operations.
3. Stress and elongation calculations. Separate stress and elongation calculations shall be submitted for each tendon if the difference in tendon elongations exceeds 2 percent.
4. That tendons in the bridge will be arranged to locate their center of gravity as the Plans require.
5. Details of additional or modified reinforcing steel required by the stressing system.
6. Procedures and lift-off forces at both ends of the tendon for performing a force verification lift-off in the event of discrepancies between measured and calculated elongations.

Couplings or splices will not be permitted in prestressing strands. Couplings or splices in bar tendons are subject to the Engineer's acceptance.

Friction losses used to calculate forces of the post-tensioning steel shall be based on the assumed values used for the design. The assumed anchor set, friction coefficient "μ", and friction wobble coefficient "k" values for design are shown in the Plans. The post-tensioning supplier may revise the assumed anchor set value provided all the stress and force limits listed in Section 6-02.3(26)G are met.

The Contractor shall determine all points of interference between the mild steel reinforcement and the paths of the post-tensioning tendons. Details to resolve interferences shall be submitted with the shop drawings for approval. Where reinforcing bar placement conflicts with post-tensioning tendon placement, the tendon profile shown in the Plans shall be maintained.

The Contractor may deviate from the processed shop drawings only after submitting a new Type 2E Working Drawing that describes the proposed changes.

Before physical completion of the project, the Contractor shall provide the Engineer with reproducible originals of the shop drawings and any processed changes. The shop drawings shall be provided in an electronic format.

6-02.3(26)B General Requirements for Anchorages

Post-tensioning reinforcement shall be secured at each end by means of an accepted anchorage device, which shall not kink, neck down, or otherwise damage the post-tensioning reinforcement. The anchorage assembly shall be grouted to the Engineer's satisfaction.

The structure shall be reinforced with steel reinforcing bars in the anchorage zone in the vicinity of the anchorage device. This reinforcement shall be categorized into two zones. The first or local zone shall be the concrete surrounding and immediately ahead of the anchorage device. The second or general zone shall be the overall anchorage zone, including the local zone.

The steel reinforcing bars required for concrete confinement in the local zone shall be determined by the post-tensioning system supplier and shall be shown in the shop drawings. The calculations shall be submitted with the shop drawings. The local zone steel reinforcing bars shall be furnished and installed by the Contractor, at no additional cost to the Contracting Agency, in addition to the structural reinforcement required by the Plans. The steel reinforcing bars required in the general zone shall be as shown in the Plans and are included in the appropriate Bid items.

The Contractor shall submit Type 2E Working Drawings consisting of details, certified test reports, and/or supporting calculations, as specified below, which verify the structural adequacy of the anchorage devices. This requirement does not apply where the anchorage devices have been previously accepted by the Contracting Agency for the same Structure configuration. The Contractor shall also submit any necessary changes to the Contract Plans. The test report shall specify all pertinent test data.

Dead ended anchorages will not be permitted. Dead ended anchorages are defined as anchorages that cannot be accessed during the stressing operations.

Materials and workmanship shall conform to the applicable requirements of Sections 6-03 and 9-06.

Before installing the anchorage device, the Contractor shall submit a Manufacturer's Certificate of Compliance.

Anchorage devices shall meet the requirements listed in either Sections 6-02.3(26)C or 6-02.3(26)D.

All anchorages shall develop at least 96 percent of the actual ultimate strength of the prestressing steel, when tested in an unbonded state, without exceeding anticipated set. This anchor efficiency test shall be performed, or inspected and certified, by an independent testing agency accepted by the Engineer.

6-02.3(26)C Normal Anchorage Devices

Normal anchorage devices, defined as post-tensioning anchorage assemblies conforming to the factored bearing resistance requirements specified in this section, shall provide a factored bearing resistance greater than or equal to 1.2 times the maximum jacking force. The Contractor shall submit Type 2E Working Drawings consisting of calculations showing that the factored bearing resistances of the anchorage devices are not exceeded.

The factored bearing resistance of the anchorages shall be taken as:

$$P_r = \varphi f_n A_b$$

For which f_n is the lesser of:

$$f_n = 0.7 f'_{ci} \sqrt{\frac{A}{A_g}}, \text{and}$$

$$f_n = 2.25 f'_{ci}$$

Where:

φ	=	Resistance factor of 0.70
A	=	Maximum area of the portion of the supporting surface that is similar to the loaded area and concentric with it and does not overlap similar areas for adjacent anchorage devices (square inches)
A_b	=	Effective net area of the bearing plate calculated as the area A_g, minus the area of openings in the bearing plate (square inches)
A_g	=	Gross bearing area of the bearing plate calculated in accordance with the requirements specified below (square inches)
f'_{ci}	=	Nominal compressive strength of concrete at the time of application of the tendon force (ksi)

The full bearing plate area may be used for A_g and the calculation of A_b if the plate material does not yield at the factored tendon force and the slenderness of the bearing plate, n/t, conforms to:

$$(n/t) \leq 0.08(E_b/f_b)^{0.33}$$

Where:

E_b	=	Modulus of elasticity of the bearing plate material (ksi)
f_b	=	Stress in the anchor plate at a section taken at the edge of the wedge hole or holes (ksi)
n	=	Projection of the base plate beyond the wedge hole or wedge plate, as appropriate (inches)
t	=	average thickness of the bearing plate (inches)

For anchorages with separate wedge plates, n may be taken as the largest distance from the outer edge of the wedge plate to the outer edge of the bearing plate. For rectangular bearing plates, this distance shall be measured parallel to the edges of the bearing plate. If the anchorage has no separate wedge plate, n may be taken as the projection beyond the outer perimeter of the group of holes in the direction under consideration.

For bearing plates that do not meet the slenderness requirement specified above, the effective gross bearing area, A_g, shall be taken as:

1. For anchorages with separate wedge plates, the area geometrically similar to the wedge plate, with dimensions increased by twice the bearing plate thickness.
2. For anchorages without separate wedge plates, the area geometrically similar to the outer perimeter of the wedge holes, with dimensions increased by twice the bearing plate thickness.

6-02.3(26)D Special Anchorage Devices

Special anchorage devices, defined as post-tensioning anchorage assemblies that do not conform to the factored bearing pressure requirements specified in Section 6-02.3(26)C, shall conform to the acceptance test requirements specified below. Acceptance testing shall be performed, or inspected and certified, by an independent testing agency accepted by the Engineer. Results of the special anchorage device acceptance testing shall be recorded and submitted as a Type 1 Working Drawing.

6-02.3(26)D1 Test Block Requirements

The test block shall be a rectangular prism of sufficient size to contain all the special anchorage device components that will also be embedded in the concrete of the Structure being post-tensioned. The arrangement of the special anchorage device components shall conform to practical application to the project and the special anchorage device manufacturer's recommendations. The test block shall contain an empty duct of a size appropriate for the maximum tendon size that can be accommodated by the special anchorage device.

6-02.3(26)D2 Test Block Dimensions

The dimensions of the test block perpendicular to the tendon in each direction shall be the smaller of twice the minimum edge distance or the minimum spacing specified by the special anchorage device manufacturer, with the stipulation that the concrete cover over any confining reinforcing steel or supplementary skin reinforcement shall be appropriate for the project-specific application and circumstances. The length of the block along the axis of the tendon shall be at least two times the larger of the cross-section dimensions.

6-02.3(26)D3 Local Zone Reinforcement for Confinement

The confining reinforcing steel in the local zone of the test block shall be the same as that recommended by the special anchorage device manufacturer.

6-02.3(26)D4 Supplementary Skin Reinforcement

In addition to the special anchorage device and the associated local zone reinforcement for confinement, supplementary skin reinforcement may be provided throughout the test block. Such supplementary skin reinforcement shall be as specified by the special anchorage device manufacturer, but shall not exceed a volumetric ratio of 0.01.

The Contractor shall furnish and install supplementary skin reinforcement in the anchorage zone of the Structure similar in configuration and equivalent in volumetric ratio to the supplementary skin reinforcement used in the test block at no additional cost to the Contracting Agency. The steel reinforcing bars shown in the Plans in corresponding portions of the general zone may be counted toward this reinforcement requirement.

6-02.3(26)D5 Test Block Concrete Strength

The compressive strength of the test block at the time of acceptance testing shall not exceed the compressive strength of the Structure being post-tensioned at the time of post-tensioning.

6-02.3(26)D6 Special Anchorage Device Acceptance Testing

Special anchorage device acceptance testing shall be conducted in accordance with one of the following test methods:

1. Cyclic load test.
2. Sustained load test.
3. Monotonic load test.

The loads specified for the tests are specified in fractions of the ultimate load F_{pu} of the largest tendon that the special anchorage device is designed to accommodate. The specimen shall be loaded in accordance with conventional usage of the device in post-tensioning applications, except that the load may be applied directly to the wedge plate or equivalent area.

6-02.3(26)D7 Cyclic Loading Test

A load of $0.8F_{pu}$ shall be applied. The load shall then be cycled between $0.1F_{pu}$ and $0.8F_{pu}$ until crack widths stabilize, but for not less than ten cycles. Crack widths are considered stabilized if they do not change by more than 0.001 inches over the last three readings. Upon completion of the cyclic loading portion of the test, the specimen shall be loaded to failure, or, if limited by the capacity of the loading equipment, to at least $1.1F_{pu}$.

Crack widths and crack patterns shall be recorded at the initial load of $0.8F_{pu}$, at least at the last three consecutive peak loadings before termination of the cyclic loading portion of the test, and at $0.9F_{pu}$. The maximum load shall also be reported.

6-02.3(26)D8 Sustained Loading Test

A load of $0.8F_{pu}$ shall be applied and held constant until crack widths stabilize, but not less than 48 hours. Crack widths are considered stabilized if they do not change by more than 0.001 inches over the last three readings. Upon completion of the sustained loading portion of the test, the specimen shall be loaded to failure, or, if limited by the capacity of the loading equipment, to at least $1.1F_{pu}$.

Crack widths and crack patterns shall be recorded at the initial load of $0.8F_{pu}$, at least three times at intervals of not less than 4 hours during the last 12 hours of the sustained loading time period, and at $0.9F_{pu}$. The maximum load shall also be reported.

6-02.3(26)D9 Monotonic Loading Test

A load of $0.9F_{pu}$ shall be applied and held constant for 1 hour. Upon completion of the 1-hour load hold period, the specimen shall be loaded to failure, or, if limited by the capacity of the loading equipment, to at least $1.2F_{pu}$.

Crack widths and crack patterns shall be recorded at $0.9F_{pu}$, at the conclusion of the 1-hour load hold period, and at $1.0F_{pu}$. The maximum load shall also be reported.

6-02.3(26)D10 Special Anchorage Device Test Performance Requirements

The test block shall conform to the following load requirements under test load:

1. The maximum test load for cyclic loading and sustained loading tests shall be $1.1F_{pu}$ minimum.
2. The maximum test load for monotonic loading tests shall be $1.2F_{pu}$ minimum.

The test block shall conform to the following crack width requirements under test load:

1. Cracks shall not exceed 0.010 inches in width at $0.8F_{pu}$ at completion of the cyclic loading test or sustained loading test, or at $0.9F_{pu}$ after the 1-hour load hold period of the monotonic loading test.
2. Cracks shall not exceed 0.016 inches at $0.9F_{pu}$ for the cyclic loading test or the sustained loading test, or at $1.0F_{pu}$ for the monotonic loading test.

6-02.3(26)D11 Test Series Requirements

A test series shall consist of three test specimens. Each one of the tested specimens shall conform to the acceptance criteria specified above. If one of the three specimens fails to pass the test, a supplementary test series of three additional specimens shall be conducted. The three additional test specimens shall conform to the specified acceptance criteria.

6-02.3(26)D12 Special Anchorage Device Acceptance Testing Results Report

The special anchorage device acceptance testing results report shall be a Type 1 Working Drawing consisting of the following:

1. Dimensions of the test specimen.
2. Working drawings with details and dimensions of the special anchorage device, including all confining reinforcing steel.
3. Amount and arrangement of supplementary skin reinforcement.
4. Type and yield strength of reinforcing steel.
5. Type and compressive strength of the concrete at the time of testing.
6. Type of testing procedure and all measurements specified for each specimen under the test.

The special anchorage device manufacturer shall specify auxiliary and confining reinforcement, minimum edge distance, minimum anchor spacing, and minimum concrete strength at the time of stressing required for proper performance of the local zone.

6-02.3(26)E Ducts

Ducts shall be round, except that ducts for transverse post-tensioning of bridge deck slabs may be rectangular. Ducts shall conform to the following requirements for internal embedded installation and external exposed installation. Elliptical shaped duct may be used if allowed by the Engineer.

6-02.3(26)E1 Ducts for Internal Embedded Installation

Ducts, including their splices, shall be semi-rigid, air and mortar tight, corrugated plastic ducts of virgin polyethylene or polypropylene materials, free of water-soluble chlorides or other chemicals reactive with concrete or post-tensioning reinforcement. Ducts, including their splices, shall either have a white coating on the outside or shall be of a white material with ultraviolet stabilizers added. Ducts, including their splices, shall be capable of withstanding concrete pressures without deforming or permitting the intrusion of cement paste during placement of concrete. All fasteners shall be appropriate for use with plastic ducts, and all clamps shall be of an accepted plastic material.

Polyethylene ducts shall conform to ASTM D3350 with a cell classification of 345464A. Polypropylene ducts shall conform to ASTM D4101 with a cell classification range of PP0340B14541 to PP0340B67884. Resins used for duct fabrication shall have a minimum oxidation induction time of 20 minutes, in accordance with ASTM D3895, based on tests performed by the duct fabricator on samples taken from the lot of finished product. The duct thickness shall be as specified in Section 10.8.3 of the AASHTO *LRFD Bridge Construction Specifications*, latest edition and current interims.

All duct splices, joints, couplings, and connections to anchorages shall be made with devices or methods (mechanical couplers, plastic sleeves, shrink sleeves) that are accepted by the duct manufacturer and produce a smooth interior alignment with no lips or kinks. All connections and fittings shall be air and mortar tight. Taping is not acceptable for connections and fittings.

Each duct shall maintain the required profile within a placement tolerance of plus or minus ¼ inch for longitudinal tendons and plus or minus ⅛ inch for transverse slab tendons during all phases of the work. The minimum acceptable radius of curvature shall be as recommended by the duct manufacturer and as supported by documented industry standard testing. The ducts shall be completely sealed to keep out all mortar.

Each duct shall be located to place the tendon at the center of gravity alignment shown in the Plans. To keep friction losses to a minimum, the Contractor shall install ducts to the exact lines and grades shown in the Plans. Once in place, the ducts shall be tied firmly in position before they are covered with concrete. During concrete placement, the Contractor shall not displace or damage the ducts.

The ends of the ducts shall:

1. Permit free movement of anchorage devices, and
2. Remain covered after installation in the forms to keep out all water or debris.

Immediately after any concrete placement, the Contractor shall force blasts of oil-free, compressed air through the ducts to break up and remove any mortar inside before it hardens. Before deck concrete is placed, the Contractor shall satisfy the Engineer that ducts are unobstructed and contain nothing that could interfere with tendon installation, tensioning, or grouting. If the tendons are in place, the Contractor shall show that they are free in the duct.

Ducts shall be capped and sealed at all times until the completion of grouting to prevent the intrusion of water.

Strand tendon duct shall have an inside cross-sectional area large enough to accomplish strand installation and grouting. The area of the duct shall be at least 2.5 times the net area of prestressing steel in the duct. The maximum duct diameter shall be 4½ inches.

The inside diameter of bar tendon duct shall at least be ¼ inch larger than the bar diameter. At coupler locations the duct diameter shall at least be ¼ inch larger than the coupler diameter.

Ducts installed and cast into concrete prior to prestressing steel installation, shall be capable of withstanding at least 10 feet of concrete fluid pressure.

Ducts shall have adequate longitudinal bending stiffness for smooth, wobble free placement. A minimum of three successful duct qualification tests are required for each diameter and type of duct, as follows:

1. Ducts with diameters 2 inches and smaller shall not deflect more than 3 inches under its own weight, when a 10-foot duct segment is supported at its ends.
2. Ducts larger than 2 inches in diameter shall not deflect more than 3 inches under its own weight, when a 20-foot duct segment is supported at its ends.
3. Duct shall not dent more than ⅛ inch under a concentrated load of 100 pounds applied between corrugations by a #4 steel reinforcing bar.

When the duct must be curved in a tight radius, more flexible duct may be used, subject to the Engineer's concurrence.

6-02.3(26)E2 Ducts for External Exposed Installation

Duct shall be high-density polyethylene (HDPE) conforming to ASTM D3035. The cell classification for each property listed in the table below:

Property	Cell Classification
1	3 or 4
2	2, 3, or 4
3	4 or 5
4	4 or 5
5	2 or 3
6	2, 3, or 4

The color code shall be C.

Duct for external tendons, including their splices, shall be water tight, seamless or welded, and be capable of resisting at least 150 psi grout pressure.

Transition couplers between ducts shall conform to either the standard pressure ratings of ASTM D3035 or the hydrostatic design stresses of ASTM F714 at 73°F. The inside diameter through the coupled length shall not be less than that produced by the dimensional tolerances specified in ASTM D3035.

Workers performing HDPE pipe welding shall have satisfactorily completed a certified HDPE pipe welding course and shall have a minimum of 5 years experience in welding HDPE pipe.

The Contractor shall submit a Type 2 Working Drawing consisting of the name and HDPE pipe welding work experience of each HDPE pipe welder proposed to perform this Work in the project. The experience submittal for each HDPE pipe welder shall include:

1. The name of the pipe welder.
2. The name, date, and location of the certified HDPE pipe welding course, with the course completion certificate.
3. A list of at least three projects in the last 5 years where the pipe welder performed HDPE pipe welding, including:
    a. The project name and location, and date of construction.
    b. The Governmental Agency/Owner.
    c. The name, address, and phone number of the Governmental Agency/Owner's representative.

The Engineer may require the HDPE pipe welder to demonstrate test HDPE pipe welding before receiving final acceptance.

6-02.3(26)E3 Transitions

Transitions between ducts and wedge plates shall have adequate length to reduce the angle change effect on the performance of strand-wedge connection, friction loss at the anchorage, and fatigue strength of the post-tensioning reinforcement.

6-02.3(26)E4 Vents, Grout Injection Ports, Drains, and Caps

The Contractor shall install vents at high points and drains at low points of the tendon profile (and at other places if the Plans require). Vents at high points shall consist of a set of three vents: one to be installed at the high point of the duct, and flanking vents to be installed on either side of the high-point vent at locations where the duct profile is 8 to 12 inches below the elevation of the high-point vent. Vents shall include grout injection ports.

Vents and drains shall have a minimum inside diameter of ¾ inches, and shall be of either stainless steel, nylon, or polyolefin materials, free of water-soluble chlorides or other chemicals reactive with concrete or post-tensioning reinforcement. Stainless steel vents and drains shall conform to ASTM A240 Type 316. Nylon vents and drains shall conform to cell classification S-PA0141 (weather-resistant). Polyolefin vents and drains shall contain an antioxidant with a minimum oxidation induction time of 20 minutes in accordance with ASTM D3895. Polyolefin vents and drains shall also have a stress crack resistance of 3 hours minimum when tested at an applied stress of 350 psi in accordance with ASTM F2136.

All fasteners shall be appropriate for use with plastic ducts, and all clamps shall be of an accepted plastic material. Taping of connections is not allowed. Valves shall be positive mechanical shut-off valves. Valves, and associated caps, shall have a minimum pressure rating of 100 psi.

Vents shall point upward and remain closed until grouting begins. Drains shall point downward and remain open until grouting begins. Ends of stainless steel vents and drains shall be removed 1 inch inside the concrete surface after grouting has been completed. Ends of nylon or polyolefin vents and drains may be left flush to the surface unless

otherwise specified by the Engineer. Vents, except for grout injection, are not required for transverse post-tensioning ducts in the bridge deck unless specified in the Plans.

Caps shall be made of either stainless steel or fiber reinforced polymer (FRP). Stainless steel caps shall conform to ASTM A240 Type 316L. The resin for FRP caps shall be either nylon, polyester, or acrylonitrite butadiene styrene (ABS). Nylon shall conform to cell classification S-PA0141 (weather-resistant). Caps shall be sealed with "O" ring seals or precision-fitted flat gaskets placed against the bearing plate. Caps shall be fastened to the anchorage with stainless steel bolts conforming to ASTM A240 Type 316L.

6-02.3(26)E5 Leak Tightness Testing

The Contractor shall test each completed duct assembly for leak tightness after placing concrete but prior to placing post-tensioning reinforcement. The Contractor shall submit a Type 2 Working Drawing consisting of the equipment used to conduct the leak tightness testing and to monitor and record the pressure maintained in and lost from the closed assembly, and the process to be followed in conducting the leak-tightness testing along with the post-tensioning system shop drawings in accordance with Section 6-02.3(26)A.

Prior to testing, all grout caps shall be installed and all vents, grout injection ports, and drains shall either be capped or have their shut-off valves closed. The Contractor shall pressurize the completed duct assembly to an initial air pressure of 50 psi. This pressure shall be held for five minutes to allow for internal adjustments within the assembly. After five minutes, the air supply valve shall be closed. The Contractor shall monitor and measure the pressure maintained within the closed assembly, and any subsequent loss of pressure, over a period of one minute following the closure of the air supply valve. The maximum pressure loss for duct assemblies equal to or less than 150 feet in length shall be 25 psig. The maximum pressure loss for duct assemblies greater than 150 feet in length shall be 15 psig. If the pressure loss exceeds the allowable, locations of leakage shall be identified, repaired or reconstructed using methods accepted by the Engineer. The repaired system shall then be retested. The cycle of testing, repair and retesting of each completed duct assembly shall continue until the completed duct assembly completes a test with pressure loss within the specified amount.

6-02.3(26)F Prestressing Reinforcement

All prestressing reinforcement strand shall comply with Section 9-07.10. They shall not be coupled or spliced. Tendon locations shown in the Plans indicate final positions after stressing (unless the Plans say otherwise). No tendon made of 7-wire strands shall contain more than 37 strands of ½-inch diameter, or more than 27 strands of 0.6-inch diameter.

All prestressing reinforcement bar shall conform to Section 9-07.11. They shall not be coupled or spliced except as otherwise specified in the Plans or Special Provisions.

Prestressing reinforcement not conforming to either Section 9-07.10 or 9-07.11 will not be allowed except as otherwise noted. Such reinforcement may be used provided it is specifically allowed by the Plans or Special Provisions, it satisfies all material and performance criteria specified in the Plans or Special Provisions, and receives the Engineer's acceptance.

From manufacture to encasement in concrete or grout, prestressing strand shall be protected against dirt, oil, grease, damage, and all corrosives. Strand shall be stored in a dry, covered area and shall be kept in the manufacturer's original packaging. If prestressing strand has been damaged or pitted, it will be rejected. Prestressing strand with rust shall be spot-cleaned with a nonmetallic pad to inspect for any sign of pitting or section loss. If the prestressing reinforcement will not be stressed and grouted for more than 7 calendar days after it is placed in the ducts, the Contractor shall place an accepted corrosion inhibitor conforming to Federal Specification MIL-I-22110C in the ducts.

The feeding ends of the strand tendons shall be equipped with a bullet nosing or similar apparatus to facilitate strand tendon installation.

Strand tendons may be installed by pulling or pushing. Any equipment capable to performing the task may be used, provided it does not damage the strands and conforms to the following:

1. Pulling lines shall have a capacity of at least 2.5 times the dead weight of the tendons when used for essentially horizontal tendon installation.
2. Metal pushing wheels shall not be used.
3. Bullets for checking duct clearance prior to concreting shall be rigid and be ⅛ inch smaller than the inside diameter of the duct. Bullets for checking duct after concreting shall be less than ¼ inch smaller than the inside diameter of the duct.

6-02.3(26)G Tensioning

Equipment for tensioning post-tensioning reinforcement shall meet the following requirements:

1. Stressing equipment shall be capable of producing a jacking force of at least 81 percent of the specified tensile strength of the post-tensioning reinforcement.
2. Jacking force test capacity shall be at least 95 percent of the specified tensile strength of the post-tensioning reinforcement.
3. Wedge seating methods shall assure uniform seating of wedge segments and uniform wedge seating losses on all strand tendons.
4. Accumulation of differential seating losses during tensioning cycling shall be prevented by proper devices.
5. Jacks used for stressing tendons less than 20 feet long shall have wedge power seating capability.

The Contractor shall not begin to tension the tendons until:

1. All concrete has reached a compressive strength of at least 4,000 psi or the strength specified in the Plans. When tensioning takes place prior to 28-day compressive strength testing on concrete sampled in accordance with Section 6-02.3(25)H, compressive strength shall be verified on field cured cylinders in accordance with the FOP for AASHTO T23.
2. The Engineer is satisfied that all strands are free in the ducts.

Tendons shall be tensioned to the values shown in the Plans (or processed shop drawings) with hydraulic jacks. When stressing from both ends of a tendon is specified, it need not be simultaneous unless otherwise specified in the Plans. The jacking sequence shall follow the processed shop drawings.

Each jack shall have a pressure gauge that will determine the load applied to the tendon. The gauge shall display pressure accurately and readably with a dial at least 6 inches in diameter or with a digital display. Each jack and its gauge shall be calibrated as a unit and shall be accompanied by a certified calibration chart. The Contractor shall provide one copy of this chart to the Engineer for use in monitoring. The cylinder extension during calibration shall be in approximately the position it will occupy at final jacking force.

All jacks and gauges must be recalibrated and recertified: (1) at least every 180 days, and (2) after any repair or adjustment. The Engineer may use pressure cells to check jacks, gauges, and calibration charts before and during tensioning.

These stress limits apply to all tendons (unless the Plans set other limits):

1. During jacking prior to seating: 90 percent of the yield strength of the steel.
2. At anchorages after seating: 70 percent of the specified tensile strength of the steel.
3. At service limit state after losses: 80 percent of the yield strength of the steel.

Tendons shall be anchored at initial stresses that will ultimately maintain service loads at least as great as the Plans require.

As stated in Section 6-02.3(26)A, the assumed design friction coefficient "μ" and wobble coefficient "k" shown in the Plans shall be used to calculate the stressing elongation. These coefficients may be revised by the post-tensioning supplier by the following method provided it is accepted by the Engineer:

> Early in the project, the post-tensioning supplier shall test, in place, two representative tendons of each size and type shown in the Plans, for the purpose of accurately determining the friction loss in a strand and/or bar tendon.
>
> The test procedure shall consist of stressing the tendon at an anchor assembly with load cells at the dead end and jacking end. The test specimen shall be tensioned to 80 percent of the specified tensile strength in 10 increments. For each increment, the gauge pressure, elongation, and load cell force shall be recorded and the data furnished to the Engineer. The theoretical elongations and post-tensioning forces shown on the post-tensioning shop drawings shall be re-evaluated by the post-tensioning supplier using the results of the tests and corrected as necessary. Revisions to the theoretical elongations shall be submitted as a Type 2E Working Drawing. The apparatus and methods used to perform the tests shall be proposed by the post-tensioning supplier and be subject to the Engineer's acceptance.
>
> All costs associated with testing and evaluating test data shall be included in the unit Contract prices for the applicable items of Work involved.

As tensioning proceeds, the Engineer will be recording the applied load, tendon elongation, and anchorage seating values.

Elongation measurements shall be made at each stressing location to verify that the tendon force has been properly achieved. If proper anchor set has been achieved and the measured elongation of each strand tendon is within plus or minus 7 percent of the accepted calculated elongation, the stressed tendon represented by the elongation measurements is acceptable to the Contracting Agency.

In the event discrepancies greater than 7 percent exist between the measured and calculated elongations, the jack calibration shall be checked and stressing records reviewed for any evidence of wire or strand breakage. If the jack if properly calibrated and there is no evidence of wire or strand breakage, a force verification lift off shall be performed to verify the force in the tendon. The post-tensioning supplier force verification lift off procedure shall provide access for visual verification of anchor plate lift off. The jacking equipment shall be capable of bridging and lifting off the anchor plate. The tendon is acceptable if the verification lift off force is not less than 99 percent of the accepted calculated force nor more than 70 percent of the specified tensile strength of the prestressing steel or as accepted by the Engineer.

Elongation measurements shall be recorded for bar tendons to verify proper tensioning only. Acceptance will be by force verification lift off. The bar tendon is acceptable if the verification lift off force is not less than 95 percent nor more than 105 percent of the accepted calculated force or as accepted by the Engineer.

When removing the jacks, the Contractor shall relieve stresses gradually before cutting the prestressing reinforcement. The prestressing strands shall be cut a minimum of 1 inch from the face of the anchorage device.

6-02.3(26)H Grouting

Grout for post-tensioning reinforcement shall conform to Section 9-20.3(1). Prepackaged components of the grout mix shall be used within 6 months or less from date of manufacture to date of usage. Grout for post-tensioning reinforcement will be accepted based on manufacturer's certificate of compliance in accordance with Section 1-06.3, except that the water-cementitious material ratio of 0.45 maximum shall be field verified.

All grout produced for any single structure shall be furnished by one supplier.

All grouting operations shall be conducted by ASBI-certified grout technicians.

The Contractor shall submit a Type 2 Working Drawing consisting of the grouting operation Plan. The grouting operation Plan shall include, but not be limited to, the following:

1. Names of the grout technicians, accompanied by documentation of their ASBI certification.
2. Type, quantity, and brand of materials used in the grouting operations, including all manufacturer's certificates of compliance.

3. Type of equipment to be used, including meters and measuring devices used to positively measure the quantity of materials used to mix the post-tensioning grout, the equipment capacity in relation to demand and working conditions, and all back-up equipment and spare parts.
4. General grouting procedure.
5. Duct leak tightness testing and repair procedures as specified in Section 6-02.3(26)E.
6. Methods used to control the rate of grout flow within the ducts.
7. Theoretical grout volume calculations, and target flow rates recommended by the grout manufacturer as a function of the mixer equipment and the expected range of ambient temperatures.
8. Grout mixing and pumping procedures.
9. Direction of grouting.
10. Sequence of use of the grout injection ports, vents, and drains.
11. Procedures for handling blockages.
12. Procedures for postgrouting repairs.

Post-tensioning grout shall be mixed in accordance with the prepackaged grout manufacturer's recommendations using high-shear colloidal mixers. Mechanical paddle mixers will not be allowed. The grout produced for filling post-tensioning ducts shall be free of lumps and undispersed cement. All equipment used to mix each batch of post-tensioning grout shall be equipped with appropriate meters and measuring devices to positively measure all quantities of all materials used to produce the mixed grout. The field test for water-cementitious materials ratio shall be performed prior to beginning the grout injection process. Grouting shall not begin until the material properties of each batch of grout have been confirmed as acceptable.

After tensioning the tendons, the Contractor shall again blow oil-free, compressed air through each duct. All drains shall then be closed and the vents opened. Grout caps shall be installed at tendon ends prior to grouting. After completely filling the duct with grout, the Contractor shall pump the grout from the low end at a pressure of not more than 250 psig, except for transverse tendons in deck slabs the grout pressure shall not exceed 100 psig. Grout shall be continuously wasted through each vent until no more air or water pockets show. At this point, all vents shall be closed and grouting pressure at the injector held between 100 and 200 psig for at least 10 seconds, except for transverse tendons in deck slabs the grouting pressure shall be held between 50 and 75 psig for at least 10 seconds. The Contractor shall leave all plugs, caps, and valves in place and closed for at least 24 hours after grouting.

Grouting equipment shall:

1. Include a pressure gauge with an upper end readout of between 275 and 325 psig;
2. Screen the grout before it enters the pump with an easily reached screen that has clear openings of no more than 0.125 inches;

3. Be gravity fed from an attached, overhead hopper kept partly full during pumping; and
4. Be able to complete the largest tendon on the project in no more than 20 minutes of continuous grouting.

In addition, the Contractor shall have standby equipment (with a separate power source) available for flushing the grout when the regular equipment cannot maintain a one-way flow of grout. This standby equipment shall be able to pump at 250 psig.

The grout mix shall be injected within 30 minutes after the water is added to the cement. Temperature of the surrounding concrete shall be at least 35°F from the time the grout injecting begins until 2-inch cubes of the grout have a compressive strength of 800 psi. Cubes shall be made in accordance with WSDOT T 813 and stored in accordance with FOP for AASHTO T 23. If ambient conditions are such that the surrounding concrete temperature may fall below 35°F, the Contractor shall provide a heat source and protective covering for the Structure to keep the temperature of the surrounding concrete above 35°F. Grout temperature shall not exceed 90°F during mixing and pumping. If conditions are such that the temperature of the grout mix may exceed 90°F, the Contractor will make necessary provisions, such as cooling the mix water and/or dry ingredients, to ensure that the temperature of the grout mix does not exceed 90°F.

6-02.4 Measurement

Except as noted below, all classes of concrete shall be measured in place by the cubic yard to the neat lines of the Structure as shown in the Plans.

Exception: concrete in cofferdam seals. Payment for Class 4000W concrete used in these seals will be based on the volume calculated using the neatline dimensions for the seal as shown in the Contract Plans. For calculated purposes, the horizontal dimension will be increased by 1 foot outside the seal neatline perimeter. The vertical dimension is the distance between the top and bottom neatline elevations. No payment will be made for any concrete that lies outside of these limits to accommodate the Contractor's cofferdam configuration. If the Engineer eliminates the seal in its entirety a Contract change order will be issued.

Exception: concrete in a separate lump-sum, Superstructure Bid item. Any concrete quantities noted under this item in the Special Provisions will not be measured. Although the Special Provisions list approximate quantities for the Contractor's convenience, the Contracting Agency does not guarantee the accuracy of these estimates. Before submitting a Bid, the Contractor shall have verified the quantities. Even though actual quantities used may vary from those listed in the Special Provisions, the Contracting Agency will not adjust the lump sum Contract price for Superstructure (except for processed changes).

The Contracting Agency will pay for no concrete placed below the established elevation of the bottom of any footing or seal.

Lean concrete will be measured by the cubic yard for the quantity of material placed in accordance with the producer's invoice, except that lean concrete included in other Contract items will not be measured.

No deduction will be made for pile heads, reinforcing steel, structural steel, bolts, weep holes, rustications, chamfers, edgers, joint filler, junction boxes, miscellaneous hardware, ducts or less than 6-inch diameter drain pipes when computing concrete quantities for payment.

All reinforcing steel will be measured by the computed weight of all steel required by the Plans. The weight of mechanical splices will be based on the weight specified in the manufacturer's existing catalog cut for the specific item. Splices noted as optional in the plans but installed by the Contractor will be included in the measurement. Epoxy-coated bars will be measured before coating. The Contractor shall furnish (without extra allowance):

1. Bracing, spreaders, form blocks, wire clips, and other fasteners.
2. Extra steel in splices not shown in the Plans or specified in the Plans as optional.
3. Extra shear steel at construction joints not shown in the Plans when the Engineer permits such joints for the Contractor's convenience.

The following table shall be used to compute weight of reinforcing steel:

Steel Reinforcing Bar		
Deformed Bar Designation Number	**Nominal Diameter inches**	**Unit Weight Pounds per Foot**
3	0.375	0.376
4	0.500	0.668
5	0.625	1.043
6	0.750	1.502
7	0.875	2.044
8	1.000	2.670
9	1.128	3.400
10	1.270	4.303
11	1.410	5.313
14	1.690	7.650
18	2.260	13.600

Gravel backfill will be measured as specified in Section 2-09.4.

Expansion joint system___seal - superstr. will be measured by the linear foot along its completed line and slope.

Expansion joint modification will be measured by the linear foot of expansion joint modified along its completed line and slope.

Prestressed concrete girder will be measured by the linear foot of girder specified in the Proposal.

Bridge approach slab will be measured by the square yard.

Permeon treatment will be measured by the square yard of concrete surface area receiving the treatment.

Fabricated bearing assemblies (HLMR bearings, fabric pad bearings, transverse restrainer bearings, and pin bearings) will be measured per each for each bearing assembly furnished and installed.

6-02.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Conc. Class ____", per cubic yard.

"Commercial Concrete", per cubic yard.

All concrete, except in Superstructure when this is covered by a separate Bid item, will be paid for at the unit Contract price per cubic yard in place for the various classes of concrete. All costs in connection with concrete curing, producing concrete surface finish, and furnishing and applying sealer to concrete surfaces as specified, shall be included in the unit contract price per cubic yard for "Conc. Class ____". If the concrete is to be paid for other than by class of concrete, then the costs shall be included in the associated item of work.

"Superstructure (name bridge)", lump sum.

All costs in connection with constructing, finishing and removing the bridge deck test slab as specified in Section 6-02.3(10)D1 shall be included in the lump sum Contract price for "Superstructure___" or "Bridge Deck___" for one bridge in each project, as applicable.

All costs in connection with providing holes for vents, for furnishing and installing cell drainage pipes for box girder Structures, and furnishing and placing grout and shims under steel shoes shall be included in the unit Contract prices for the various Bid items involved.

All costs in connection with the construction of weep holes, including the gravel backfill for drains surrounding the weep holes except as provided in Section 2-09.4, shall be included by the Contractor in the unit Contract price per cubic yard for "Conc. Class ____".

"Lean Concrete", per cubic yard.

Lean concrete, except when included in another Bid item, will be paid for at the unit Contract price per cubic yard.

"St. Reinf. Bar ____", per pound.

"Epoxy-Coated St. Reinf. Bar ____", per pound.

Payment for reinforcing steel shall include the cost of drilling holes in concrete for, and setting, steel reinforcing bar dowels with epoxy bonding agent, and furnishing, fabricating, placing, and splicing the reinforcement. In Structures of reinforced concrete where there are no structural steel Bid items, such minor metal parts as expansion joints, bearing assemblies, and bolts will be paid for at the unit Contract price for "St. Reinf. Bar ____" unless otherwise specified.

"Gravel Backfill for Foundation Class A", per cubic yard.

"Gravel Backfill for Foundation Class B", per cubic yard.

"Gravel Backfill for Wall", per cubic yard.

"Deficient Strength Conc. Price Adjustment", by calculation.

"Deficient Strength Conc. Price Adjustment" shall be calculated and paid for as described in Section 6-02.3(5)L. For the purpose of providing a common Proposal for all Bidders, the Contracting Agency has entered an amount for the item "Deficient Strength Conc. Price Adjustment" in the Bid Proposal to become a part of the total Bid by the Contractor. The item "Deficient Strength Conc. Price Adjustment" covers all applicable classes of concrete.

"Expansion Joint System _____ - Superstr.", per linear foot.

"Expansion Joint Modification - ___", per linear foot.

"___Bearing - Superstr.", per each.

The unit Contract price per each for "___Bearing - Superstr." shall be full pay for performing the Work as specified in Section 6-02.3(19), including design, testing, and inspection.

"Modular Expansion Joint System___", lump sum.

The lump sum Contract price for "Modular Expansion Joint System___" shall be full pay for performing the Work as specified in Section 6-02.3(13)C.

"Prestressed Conc. Girder ___", per linear foot.

"Bridge Approach Slab", per square yard.

The unit Contract price per square yard for "Bridge Approach Slab" shall be full pay for providing, placing, and compacting the crushed surfacing base course, furnishing and placing Class 4000A concrete, and furnishing and installing compression seal, anchors, and reinforcing steel.

"Permeon Treatment", per square yard.

The unit contract price per square yard for "Permeon Treatment" shall be full pay for performing the work as specified.

6-03 Steel Structures

6-03.1 Description

This Work consists of furnishing, fabricating, erecting, cleaning, and painting steel Structures and the structural steel parts of nonsteel Structures

6-03.2 Materials

Materials shall meet the requirements of the following sections:

Structural Steel and Related Materials	9-06
Paints and Related Materials	9-08
Grout	9-20.3

Structural steel shall be classified as:

1. Structural carbon steel (to be used whenever the Plans do not specify another classification),
2. Structural low alloy steel, and
3. Structural high-strength steel.

Unless the Plans or Special Provisions state otherwise, the following shall be classified as structural carbon steel: shims; ladders; stairways; anchor bolts and sleeves; pipe, fittings, and fastenings used in handrails; and other metal parts, even if made of other materials, for which payment is not specified.

All AASHTO M270 material used in what the Plans show as main load-carrying tension members or as tension components of flexural members shall meet the Charpy V-notch requirements of AASHTO M270 temperature zone 2. All AASHTO M270 material used in what the Plans show as fracture critical members shall meet the Charpy V-notch requirements of AASHTO M270, Fracture Critical Impact Test Requirements, temperature zone 2. Charpy V-notch requirements for other steel materials shall be as specified in the Plans and Special Provisions.

The Contractor shall submit Type 1 Working Drawings describing the methods for visibly marking the material so that it can be traced. These marks shall remain visible at least through the fit-up of the main load-carrying tension members. The marking method shall permit the Engineer to verify: (1) material Specification designation, (2) heat number, and (3) material test reports to meet any special requirements.

For steel in main load-carrying tension members and in tension components of flexural members, the Contractor shall include the heat numbers on the reproducible copies of the as-built shop plans.

6-03.3 Construction Requirements

Structural steel fabricators of plate and box girders, floorbeams, truss members, stringers, cross frames, diaphragms, and laterals shall be certified under the AISC Certification Program for Steel Bridge Fabricators, Advanced Bridges Category. When fracture critical members are specified in the Contract, structural steel fabricators shall also meet the supplemental requirements F, Fracture Critical, under the AISC Quality Certification Program for Steel Bridge Fabricators.

6-03.3(1) Vacant

6-03.3(2) Facilities for Inspection

The Contractor shall provide all facilities the Inspector requires to inspect material and workmanship. Inspectors shall be given safe and free access to all areas in the mill and shop.

6-03.3(3) Inspector's Authority

The Inspector may reject materials or workmanship that does not comply with these Specifications. In any dispute, the Contractor may appeal to the Engineer whose decision shall be final.

By its inspection at the mill and shop, the Contracting Agency intends only to facilitate the Work and prevent errors. This inspection shall not relieve the Contractor of any responsibility for identifying and replacing defective material or workmanship.

6-03.3(4) Rejections

Even if the Inspector accepts materials or finished members, the Contracting Agency may later reject them if defective. The Contractor shall promptly replace or make good any rejected materials or workmanship.

6-03.3(5) Mill Orders and Shipping Statements

The Contractor shall furnish as many copies of mill orders and shipping statements as the Engineer requires.

6-03.3(6) Weighing

Structural steel need not be weighed unless the Plans or Special Provisions require it. When a weight is required, it may either be calculated or obtained by scales. The Contractor shall furnish as many copies of the calculations or weight slips as the Engineer requires. If scale weights are used, the Contractor shall record separately the weights of all tools, erection material, and dunnage.

6-03.3(7) Shop Plans

The Contractor shall submit all shop detail plans for fabricating the steel as Type 2 Working Drawings.

If these plans will be submitted directly from the fabricator, the Contractor shall so notify the Engineer in writing.

No material shall be fabricated until: (1) the Working Drawing review is complete, and (2) the Engineer has accepted the materials source.

Before physical completion of the project, the Contractor shall furnish the Engineer one set of reproducible copies of the as built shop plans. The reproducible copies shall be clear, suitable for microfilming, and on permanent sheets that measure no smaller than 11 by 17 inches. Alternatively, the shop drawings may be provided in an electronic format with the approval of the Engineer.

6-03.3(7)A Erection Methods

Before beginning to erect any steel Structure, the Contractor shall submit Type 2E Working Drawings consisting of the erection plan and procedure describing the methods the Contractor intends to use.

The erection plan and procedure shall provide complete details of the erection process including, at a minimum, the following:

1. Temporary falsework support, bracing, guys, deadmen, and attachments to other Structure components or objects;
2. Procedure and sequence of operation;
3. Girder stresses during progressive stages of erection;
4. Girder masses, lift points, and lifting devices, spreaders, glommers, etc.;
5. Crane(s) make and model, mass, geometry, lift capacity, outrigger size and reactions;
6. Girder launcher or trolley details and capacity (if intended for use); and
7. Locations of cranes, barges, trucks delivering girders, and the location of cranes and outriggers relative to other Structures, including retaining walls and wing walls.

As part of the erection plan Working Drawings, the Contractor may submit details of an engineered and fabricated lifting bracket bolted to the girder top flanges providing the following requirements are satisfied:

1. The lifting bracket shall be engineered and supporting calculations shall be submitted with the erection plan;
2. The calculations shall include critical stresses in the girder including local stresses in the flanges at lifting bracket locations;
3. The calculations shall include computation of the lifting bracket and associated bolt hole locations and the expected orientation of the girder during picking operation;

4. The lifting bracket shall be load tested and certified for a load at least 2 times the working load and at all angles it will be used (angle of load or rigging). Certification documentation from a previous project may be submitted;
5. Bolt holes in girders added for the lifting bracket connections shall be shown in the shop plans and shall be drilled in the shop. Field drilling of bolt holes for lifting brackets will not be permitted;
6. Bolt holes in girder top flanges shall be filled with high strength bolts after erection in accordance with Section 6-02.3(17)K.

The erection plan shall include drawings, notes, catalog cuts, and calculations clearly showing the above listed details, assumptions, and dimensions. Material properties, Specifications, structural analysis, and any other data used shall also be included.

6-03.3(8) Substitutions

The Contractor shall not substitute sections that differ from Plan dimensions unless the Engineer approves in writing. If the Contractor requests and receives approval to substitute heavier members, the Contracting Agency shall not pay any added cost.

6-03.3(9) Handling, Storing, and Shipping of Materials

Markings applied at the mill shall distinguish structural low alloy steel from structural carbon steel. The fabricator shall keep the two classes of steel carefully separated.

Before fabrication, all material stored at the fabricating plant shall be protected from rust, dirt, oil, and other foreign matter. The Contracting Agency will accept no rust-pitted material.

After fabrication, all material awaiting shipment shall be subject to the same storage requirements as unfabricated material.

All structural steel shall arrive at the job in good condition. As the Engineer requires, steel damaged by salt water shipment shall be thoroughly cleaned by high pressure water flushing, chemical cleaning, or sandblasting, and repainted with the specified shop coat.

All material shall be stored so as to prevent rust and loss of small parts. Piled material shall not rest on the ground or in water but on skids or platforms.

The loading, transporting, unloading, and piling of the structural steel material shall be so conducted that the metal will be kept clean and free from injury from rough handling.

In field assembly of structural parts, the Contractor shall use methods and equipment not likely to twist, bend, deform, or otherwise injure the metal. Any member slightly bent or twisted shall be corrected before it is placed. The Contracting Agency will reject any member with serious handling damage.

Girder sections shall be handled so as to prevent damage to the girders. If necessary, the Contractor shall provide temporary stiffeners to prevent buckling during erection.

6-03.3(10) Straightening Bent Material

If the Engineer permits in writing, plates, angles, other shapes, and built-up members may be straightened. Straightening methods shall not fracture or injure the metal. Distorted members shall be straightened mechanically. A limited amount of localized heat may be applied only if carefully planned and supervised, and only in accordance with the heat-straightening procedure Working Drawing submittal.

Parts to be heat-straightened shall be nearly free from all stress and external forces except those that result from the mechanical pressure used with the heat.

After straightening, the Contractor shall inspect the member for fractures using a method proposed by the Contractor and accepted by the Contracting Agency.

The Contracting Agency will reject metal showing sharp kinks and bends.

The procedure for heat straightening of universal mill (UM) plates by the mill or the fabricator shall be submitted as a Type 2 Working Drawing.

6-03.3(11) Workmanship and Finish

Workmanship and finish shall be first-class, equaling the best practice in modern bridge fabrication shops. Welding, shearing, burning, chipping, and grinding shall be done neatly and accurately. All parts of the Work exposed to view shall be neatly finished.

Wherever the Plans show a surface finish symbol, the surface shall be machined.

6-03.3(12) Falsework

All falsework shall meet the requirements of Section 6-02.

6-03.3(13) Fabricating Tension Members

Plates for main load-carrying tension members or tension components of flexural members shall be:

1. Blast cleaned entirely or blast cleaned on all areas within 2 inches of welds to SSPC-SP6, Commercial Blast Cleaning; and
2. Fabricated from plate stock with the primary rolling direction of the stock parallel to the length of the member, or as shown in the Plans.

6-03.3(14) Edge Finishing

All rolled, sheared, and thermal cut edges shall be true to line and free of rough corners and projections. Corners along exposed sheared or cut edges shall be broken by light grinding or another method acceptable to the Engineer to achieve an approximate 1/16-inch chamfer or rounding.

Sheared edges on plates more than 5/8 inch thick shall be planed, milled, ground, or thermal cut to a depth of at least 1/8 inch.

Re-entrant corners or cuts shall be filleted to a minimum radius of 1 inch.

Exposed edges of main load-carrying tension members or tension components of flexural members shall have a surface roughness no greater than 250-micro inches as defined by the American National Standards Institute, ANSI B46.1, Surface Texture. Exposed edges of other members shall have surface roughness no greater than 1,000-micro inches.

The Rockwell hardness of thermal-cut edges of structural low alloy or high-strength steel flanges, as specified in Sections 9-06.2 and 9-06.3, for main load-carrying tension members or tension components of flexural members shall not exceed RHC 30. The fabricator shall prevent excessive hardening of flange edges through preheating, post heating, or control of the burning process as recommended by the steel manufacturer.

Hardness testing shall consist of testing thermal-cut edges with a portable hardness tester. The hardness tester, and its operating test procedures, shall be submitted as a Type 1 Working Drawing. The hardness tester shall be convertible to Rockwell C scale values.

At two locations, two tests shall be performed on each thermal-cut edge, one each within ¼ inch of the top and bottom surfaces. The tests shall be located ¼ the length of each thermal-cut edge from each end of the cut. If one or more readings are greater than RHC 30, the entire length of the edge shall be ground or machined to a depth sufficient to provide acceptable readings upon further retests. If thermal-cutting operations conform to procedures established by the steel manufacturer, and hardness testing results are consistently within acceptable limits, the Engineer may authorize a reduction in the testing frequency.

6-03.3(15) Planing of Bearing Surfaces

Ends of columns that bear on base and cap plates shall be milled to true surfaces and accurate bevels.

When assembled, caps and base plates of columns and the sole plates of girders and trusses shall have a fit tolerance within 1/32 inch for 75 percent of the contact area. If warped or deformed, the plates shall be heat straightened, planed, or corrected in some other way to produce accurate, even contact. If necessary for proper contact, bearing surfaces that will contact other metal surfaces shall be planed or milled. Surfaces of warped or deformed base and sole plates that will contact masonry shall be rough finished.

On the surface of expansion bearings, the cut of the planer shall be in the direction of expansion.

Where mill to bear is specified in the Plans, the bearing end of the stiffener shall be flush and square with the flange and shall have at least 75 percent of this area in contact with the flange.

6-03.3(16) Abutting Joints

Abutting ends of compression members shall be faced accurately so that they bear evenly when in the Structure. On built-up members, the ends shall be faced or milled after fabrication.

Ends of tension members at splices shall be rough finished to produce neat, close joints. A contact fit is not required.

6-03.3(17) End Connection Angles

On floorbeams and stringers, end connection angles shall be flush with each other and set accurately in relationship to the position and length of the member. Unless the Plans require it, end connection angles shall not be finished. If, however, faulty assembly requires them to be milled, milling shall not reduce thickness by more than 1/16 inch.

6-03.3(18) Built Members

The various pieces forming one built member shall be straight and close fitting, true to detailed dimensions, and free from twists, bends, open joints, or other defects.

When fabricating curved girders, localized heat or the use of mechanical force shall not be used to bend the girder flanges about an axis parallel to girder webs.

6-03.3(19) Hand Holes

Hand holes, whether punched or cut with burning torches, shall be true to sizes and shapes shown in the Plans. Edges shall be true to line and ground smooth.

6-03.3(20) Lacing Bars

Unless the Plans state otherwise, ends of lacing bars shall be neatly rounded.

6-03.3(21) Plate Girders

6-03.3(21)A Web Plates

If web plates are spliced, gaps between plate ends shall be set at shop assembly to measure ¼ inch, and shall not exceed ⅜ inch.

6-03.3(21)B Vacant

6-03.3(21)C Web Splices and Fillers

Web splice plates and fillers under stiffeners shall fit within ⅛ inch at each end. In lieu of the steel material specified in the Plans or Special Provisions, the Contractor may substitute ASTM A1008 or ASTM A1011 steel for all filler plates less than ¼ inch thickness, provided that the grade of filler plate steel meets or exceeds that of the splice plates.

6-03.3(22) Eyebars

Eyebars shall be straight, true to size, and free from twists or folds in the neck or head and from any other defect that would reduce their strength. Heads shall be formed by upsetting, rolling, or forging. Dies in use by the manufacturer may determine the shape of bar heads if the Engineer approves. Head and neck thickness shall not overrun by more than 1/16 inch. Welds shall not be made in the body or head of any bar.

Each eyebar shall be properly annealed and carefully straightened before it is bored. Pinholes shall be located on the centerline of each bar and in the center of its head. Holes in bar ends shall be so precisely located that in a pile of bars for the same truss panel the pins may be inserted completely without driving. All eyebars made for the same locations in trusses shall be interchangeable.

6-03.3(23) Annealing

All eyebars shall be annealed by being heated uniformly to the proper temperature, then cooled slowly and evenly in the furnace. At all stages, the temperature of the bars shall be under full control.

Slight bends on secondary steel members may be made without heat. Crimped web stiffeners need no annealing.

6-03.3(24) Pins and Rollers

Pins and rollers shall be made of the class of forged steel the Plans specify. They shall be turned accurately to detailed dimensions, smooth, straight, and flawless. The final surface shall be produced by a finishing cut.

Pins and rollers 9 inches or less in diameter may either be forged and annealed or made of cold-finished carbon steel shafting.

Pins more than 9 inches in diameter shall have holes at least 2 inches in diameter bored longitudinally through their centers. Pins with inner defects will be rejected.

The Contractor shall provide pilot and driving nuts for each size of pin unless the Plans state otherwise.

6-03.3(24)A Boring Pin Holes

Pin holes shall be bored true to detailed dimensions, smooth and straight, and at right angles to the axis of the member. Holes shall be parallel with each other unless the Plans state otherwise. A finishing cut shall always be made.

The distance between holes shall not vary from detailed dimensions by more than 1/32 inch. In tension members, this distance shall be measured from outside to outside of holes; in compression members, inside to inside.

6-03.3(24)B Pin Clearances

Each pin shall be 1/50 inch smaller in diameter than its hole. All pins shall be numbered after being fitted into their holes in the assembled member.

6-03.3(25) Welding and Repair Welding

Welding and repair welding of all steel bridges, including pedestrian Structures, shall comply with the AASHTO/AWS D1.5M/D1.5, latest edition, Bridge Welding Code. Welding and repair welding for all other steel fabrication shall comply with the AWS D1.1/D1.1M, latest edition, Structural Welding Code. The requirements described in the remainder of this section shall prevail whenever they differ from either of the above welding codes.

The Contractor shall weld structural steel only to the extent shown in the Plans. No welding, including tack and temporary welds shall be done in the shop or field unless the location of the welds is shown on the approved shop drawings reviewed and accepted by the Engineer.

Welding procedures shall accompany the shop drawing Working Drawing submittal. The procedures shall specify the type of equipment to be used, electrode selection, preheat requirements, base materials, and joint details. When the procedures are not prequalified by AWS or AASHTO, evidence of qualification tests shall be submitted. Steel bridge elements not subject to live load tensile stress and not welded to main members in tension areas, such as steel expansion dams, bearings, handrail, drainage components, and curb plates, may follow the requirements of AASHTO/AWS D1.5M/D1.5, latest edition, Bridge Welding Code for Welding of Ancillary Products whereby qualification of welding procedures is not required.

Welding shall not begin until completion of the shop plan Working Drawing review as required in Section 6-03.3(7). These plans shall include procedures for welding, assembly, and any heat-straightening or heat-curving.

Any welded shear connector longer than 8 inches may be made of two shorter shear connectors joined with full-penetration welds.

In shielded metal-arc welding, the Contractor shall use low-hydrogen electrodes.

In submerged-arc welding of main load-carrying tension members and tension components of flexural members, flux shall be oven-dried at 550°F for at least 2 hours, then stored in ovens held at 250°F or more. If not used within 4 hours after removal from a drying or storage oven, flux shall be redried before use.

Preheat and interpass temperatures shall conform to the applicable welding code as specified in this section. When welding main members of steel bridges, the minimum preheat shall not be less than 100°F.

If groove welds (web-to-web or flange-to-flange) have been rejected, they may be repaired no more than twice. If a third failure occurs, the Contractor shall:

1. Trim the members, if the Engineer concurs, at least ½ inch on each side of the weld; or
2. Replace the members at no expense to the Contracting Agency.

By using extension bars and runoff plates, the Contractor shall terminate groove welds in a way that ensures the soundness of each weld to its ends. The bars and plates shall be removed after the weld is finished and cooled. The weld ends shall then be ground smooth and flush with the edges of abutting parts.

The Contractor shall not:

1. Weld with electrogas or electroslag methods unless shown in the Plans or allowed by the Engineer,
2. Weld nor flame cut when the ambient temperature is below 20°F, or
3. Use coped holes in the web for welding butt splices in the flanges unless the Plans show them.

6-03.3(25)A Welding Inspection

The Contractor's inspection procedures, techniques, methods, acceptance criteria, and inspector qualifications for welding of steel bridges, including pedestrian Structures, shall be in accordance with the AASHTO/AWS D1.5M/D1.5, latest edition, Bridge Welding Code. The Contractor's inspection procedures, techniques, methods, acceptance criteria, and inspector qualifications for welding of steel Structures other than steel bridges, including pedestrian Structures, shall be in accordance with AWS D1.1/D1.1M, latest edition, Structural Welding Code. The requirements described in the remainder of this section shall prevail whenever they differ from either of the above welding codes.

Nondestructive testing in addition to visual inspection shall be performed by the Contractor. Unless otherwise shown in the Plans or specified in the Special Provisions, the extent of inspection shall be as specified in this section. Testing and inspection shall apply to welding performed in the shop and in the field.

After the Contractor's welding inspection is complete, the Contractor shall allow the Engineer sufficient time to perform quality assurance ultrasonic welding inspection.

6-03.3(25)A1 Visual Inspection

All welds shall be 100 percent visually inspected. Visual inspection shall be performed before, during, and after the completion of welding.

6-03.3(25)A2 Radiographic Inspection

Complete penetration tension groove welds in Highway bridges and pedestrian Structures shall be 100 percent radiographically inspected. These welds include those in the tension area of webs, where inspection shall cover the greater of these two distances: (a) 15 inches from the tension flange, or (b) ⅓ of the web depth. In addition, edge blocks conforming to the requirements of AASHTO/AWS D1.5M/D1.5, latest edition, Bridge Welding Code Section 6.10.14 shall be used for radiographic inspection.

The Contractor shall maintain the radiographs and the radiographic inspection report in the shop until the last joint to be radiographed in that member is accepted by the radiographer representing the Contractor. Within 2 working days following this acceptance, the Contractor shall submit the film, or electronic version with associated viewing program, and one copy of the radiographic inspection report to the Materials Engineer, Department of Transportation, PO Box 47365, Olympia, WA 98504-7365.

6-03.3(25)A3 Ultrasonic Inspection

Complete penetration groove welds on plates 5⁄16 inch and thicker in the following welded assemblies or Structures shall be 100 percent ultrasonically inspected:

1. Welded connections and splices in Highway bridges, including pedestrian Structures, and earth retaining Structures, excluding longitudinal butt joint welds in beam or girder webs.
2. Bridge bearings and modular expansion joints.
3. Sign bridges, cantilever sign Structures, and bridge mounted sign brackets excluding longitudinal butt joint welds in beams.
4. Light, signal, and strain pole standards, as defined in Section 9-29.6.
5. Washington State Ferries steel terminal Structures.

A minimum of 30 percent of complete penetration vertical welds on steel column jackets 5⁄16-inch and thicker, within 1.50 column jacket diameters of the top and bottom of each column, shall be inspected. If any rejectable flaws are found, 100 percent of the weld within the specified limits shall be inspected. The largest column cross section diameter for tapered column jackets shall constitute one column jacket diameter.

The testing procedure and acceptance criteria for tubular members shall conform to the requirements of the AWS D1.1/D1.1M latest edition, Structural Welding Code.

6-03.3(25)A4 Magnetic Particle Inspection

1. Fillet and partial penetration groove welds:

   At least 30 percent of each size and type of fillet welds (excluding intermittent fillet welds) and partial penetration groove welds in the following welded assemblies or Structures shall be tested by the magnetic particle method:

   a. Flange-to-web connections in Highway bridges and pedestrian Structures.

b. End and intermediate pier diaphragms in Highway bridges and pedestrian Structures.

c. Stiffeners and connection plates in Highway bridges and pedestrian Structures.

d. Welded connections and splices in earth retaining Structures.

e. Boxed members of trusses.

f. Bridge bearings and modular expansion joints.

g. Sign bridges, cantilever sign Structures, and bridge mounted sign brackets.

h. Light, signal, and strain pole standards, as defined in Section 9-29.6.

i. Washington State Ferries steel terminal Structures.

2. Longitudinal butt joint welds in beam and girder webs:

   At least 30 percent of each longitudinal butt joint weld in the beam and girder webs shall be tested by the magnetic particle method.

3. Complete penetration groove welds on plates less than 5/16 inch (excluding steel column jackets) shall be 100 percent tested by the magnetic particle method. Testing shall apply to both sides of the weld, if backing plate is not used. The ends of each complete penetration groove weld at plate edges shall be tested by the magnetic particle method.

4. A minimum of 30 percent of complete penetration vertical welds on steel column jackets less than 5/16 inch, within 1.50 column jacket diameters of the top and bottom of each column, shall be magnetic particle inspected. The largest column cross section diameter for tapered column jackets shall constitute one column jacket diameter.

Where 100 percent testing is not required, the Engineer reserves the right to select the location(s) for testing.

If rejectable flaws are found in any test length of weld in item 1 or 2 above, the full length of the weld or 5 feet on each side of the test length, whichever is less, shall be tested. If any rejectable flaws are found in any test length of item 4 above, 100 percent of the weld within the specified limits shall be inspected.

6-03.3(26) Screw Threads

Screw threads shall be U.S. Standard and shall fit closely in the nuts.

6-03.3(27) High-Strength Bolt Holes

At the Contractor's option under the conditions described in this section, holes may be punched or subpunched and reamed, drilled or subdrilled and reamed, or formed by numerically controlled drilling operations.

The hole for each high-strength bolt shall be 1/16 inch larger than the nominal diameter of the bolt.

In fabricating any connection, the Contractor may subdrill or subpunch the holes then ream full size after assembly or drill holes full size from the solid with all thicknesses of material shop assembled in the proper position. If the Contractor chooses not to use either of these methods, then the following shall apply:

1. Drill bolt holes in steel splice plates full size using steel templates.
2. Drill bolt holes in the main members of trusses, arches, continuous beam spans, bents, towers, plate girders, box girders, and rigid frames at all connections as follows:
    a. A minimum of 30 percent of the holes in one side of the connection shall be made full size using steel templates.
    b. A minimum of 30 percent of the holes in the second side shall be made full size assembled in the shop.
    c. All remaining holes may be made full size in unassembled members using steel templates.
3. Drill bolt holes in crossframes, gussets, lateral braces, and other secondary members full size using steel templates.

The Contractor shall submit Type 2 Working Drawings consisting of a detailed outline of the procedures proposed to accomplish the Work from initial drilling through shop assembly.

6-03.3(27)A Punched Holes

For punched holes, die diameter shall not exceed punch diameter by more than $\frac{1}{16}$ inch. Any hole requiring enlargement to admit the bolt shall be reamed. All holes shall be cut clean with no torn or ragged edges. The Contracting Agency will reject components having poorly matched holes.

6-03.3(27)B Reamed and Drilled Holes

Reaming and drilling shall be done with short taper reamers or twist drills, producing cylindrical holes perpendicular to the member. Reamers and drills shall be directed mechanically, not hand-held , except hand-held reamers may be used under the following conditions:

1. For preparing existing holes to accept bolts during rivet replacement on existing steel bridge painting and retrofit projects
2. Hand-held reamers shall be power driven with tapered bridge reamers as accepted by the Engineer
3. Unless otherwise shown in the Plans, holes shall be 1/16 inch larger than the bolt diameter specified in the Plans

Connecting parts that require reamed or drilled holes shall be assembled and held securely as the holes are formed, then match-marked before disassembly. The Contractor shall provide the Engineer a diagram showing these match-marks. The Contracting Agency will reject components having poorly matched holes.

Burrs on outside surfaces shall be removed. If the Engineer requires, the Contractor shall disassemble parts to remove burrs.

If templates are used to ream or drill full-size connection holes, the templates shall be positioned and angled with extreme care and bolted firmly in place. Templates for reaming or drilling matching members or the opposite faces of one member shall be duplicates. All splice components shall be match-marked unless otherwise approved by the Engineer.

6-03.3(27)C Numerically Controlled Drilled Connections

In forming any hole described in Section 6-03.3(27), the fabricator may use numerically controlled (N/C) drilling or punching equipment if it meets the requirements in this Subsection.

The Contractor shall submit Type 1 Working Drawings consisting of a detailed outline of proposed N/C procedures. This outline shall:

1. Cover all steps from initial drilling or punching through check assembly;
2. Include the specific members of the Structure to be drilled or punched, hole sizes, locations of the common index and other reference points, makeup of check assemblies, and all other information needed to describe the process fully.

N/C holes may be drilled or punched to size through individual pieces, or may be drilled through any combination of tightly clamped pieces.

When the Engineer requires, the Contractor shall demonstrate that the N/C procedure consistently produces holes and connections meeting the requirements of these Specifications.

6-03.3(27)D Accuracy of Punched, Subpunched, and Subdrilled Holes

After shop assembly and before reaming, all punched, subpunched, and subdrilled holes shall meet the following standard of accuracy. At least 75 percent of the holes in each connection shall permit the passage of a cylindrical pin ⅛ inch smaller in diameter than nominal hole size. This pin shall pass through at right angles to the face of the member without drifting. All holes shall permit passage of a pin 3/16 inch smaller in diameter than nominal hole size. The Contracting Agency will reject any pieces that fail to meet these standards.

6-03.3(27)E Accuracy of Reamed and Drilled Holes

At least 85 percent of all holes in a connection of reamed or drilled holes shall show no offset greater than 1/32 inch between adjacent thicknesses of metal. No hole shall have an offset greater than 1/16 inch.

Centerlines from the connection shall be inscribed on the template and holes shall be located from these centerlines. Centerlines shall also be used for accurately locating the template relative to the milled or scribed ends of the members.

Templates shall have hardened steel bushing inserted into each hole. These bushings may be omitted, however, if the fabricator satisfies the Engineer (1) that the template will be used no more than five times, and (2) that use will produce no template wear.

Each template shall be at least ½ inch thick. If necessary, thicker templates shall be used to prevent buckling and misalignment as holes are formed.

6-03.3(27)F Fitting for Bolting

Before drilling, reaming, and bolting begins, all parts of a member shall be assembled, well pinned, and drawn firmly together. If necessary, assembled pieces shall be taken apart to permit removal of any burrs or shavings produced as the holes are formed. The member shall be free from twists, bends, and other deformation.

In shop-bolted connections, contacting metal surfaces shall be sandblasted clean before assembly. Sandblasting shall meet the requirements of the SSPC Specifications for Commercial Blast Cleaning (SSPC-SP 6).

Any drifting done during assembly shall be no more than enough to bring the parts into place. Drifting shall not enlarge the holes or distort the metal.

6-03.3(28) Shop Assembly

6-03.3(28)A Method of Shop Assembly

Unless the Contract states otherwise, the Contractor shall choose one of the five shop assembly methods described below that will best fit the proposed erection method. The Contractor shall obtain the Engineer's approval of both the shop assembly and the erection methods before Work begins.

1. **Full Truss or Girder Assembly** – Each truss or girder is completely assembled over the full length of the Superstructure.
2. **Progressive Truss or Girder Assembly** – Each truss or girder is assembled in stages longitudinally over the full length of the Superstructure.
    a. **For Trusses** – The first stage shall include at least three adjacent truss panels. Each truss panel shall include all of the truss members in the space bounded by the top and bottom chords and the horizontal distance between adjacent bottom chord Joints.
    b. **For Girders** – The first stage shall include at least three adjacent girder shop sections. Shop sections are measured from the end of the girder to the first field splice or from field splice to field splice.
    c. **For Trusses and Girders** – After the first stage has been completed, each subsequent stage shall be assembled to include: at least one truss panel or girder shop section of the previous stage and two or more truss panels or girder shop sections added at the advancing end. The previous stages shall be repositioned if necessary, and pinned to ensure accurate alignment. For straight sections of bridges without skews or tapers, girders in each subsequent stage

may be assembled to include one girder shop section from the previous stage and one or more girder shop sections at the advancing end.

If the bridge is longer than 150 feet, each longitudinal stage shall be at least 150 feet long, regardless of the length of individual continuous truss panels or girder shop sections.

The Contractor may begin the assembly sequence at any point on the bridge and proceed in either or both directions from that point.

Unless the Engineer approves otherwise, no assembly shall have less than three truss panels or girder shop sections.

3. **Full Chord Assembly** – The full length of each chord for each truss is assembled with geometric angles at the joints. Chord connection bolt holes are drilled/reamed while members are assembled. The truss web member connections are drilled/reamed to steel templates set by relating geometric angles to the chord lines.

   At least one end of each web member shall be milled or scribed at right angles to its long axis. The templates at both ends of the member shall be positioned accurately from the milled end or scribed line.

4. **Progressive Chord Assembly** – Adjacent chord sections are assembled in the same way as specified for Full Chord Assembly, using the procedure specified for Progressive Truss or Girder Assembly.

5. **Special Complete Structure Assembly** – All structural steel members (Superstructure and Substructure, including all secondary members) are assembled at one time.

6-03.3(28)B Check of Shop Assembly

The Contractor shall check each assembly for alignment, accuracy of holes, fit of milled joints, and other assembly techniques. Drilling or reaming shall not begin until the Engineer has given approval. If the Contractor uses N/C drilling, this approval must be obtained before the assembly or stage is dismantled.

6-03.3(29) Welded Shear Connectors

Installation, production control, and inspection of welded shear connectors shall conform to Chapter 7 of the AASHTO/AWS D1.5M/D1.5, latest edition, Bridge Welding Code. If welded shear connectors are installed in the shop, installation shall be completed prior to applying the shop primer coat in accordance with Section 6-07.3(9)G. If welded shear connectors are installed in the field, the steel surface to be welded shall be prepared to SSPC-SP 11, power tool cleaning, just prior to welding.

6-03.3(30) Painting

All painting shall be in accordance with Section 6-07.

6-03.3(30)A Vacant

6-03.3(30)B Vacant

6-03.3(30)C Erection Marks

Erection marks to permit identification of members in the field shall be painted on previously painted surfaces.

6-03.3(30)D Machine Finished Surfaces

As soon as possible and before they leave the shop, machine-finished surfaces on abutting chord splices, column splices, and column bases shall be covered with grease. After erection, the steel shall be cleaned and painted as specified.

All surfaces of iron and steel castings milled to smooth the surface shall be painted with the primer called for in the specified paint system.

While still in the shop, machine-finished surfaces and inaccessible surfaces of rocker or pin-type bearings shall receive the full paint system. Surfaces of pins and holes machine-finished to specific tolerances shall not be painted. But as soon as possible and before they leave the shop, they shall be coated with grease.

6-03.3(31) Alignment and Camber

Before beginning field bolting, the Contractor shall:

1. Adjust the Structure to correct grade and alignment,
2. Regulate elevations of panel points (ends of floorbeams), and
3. Delay bolting at compression joints until adjusting the blocking to provide full and even bearing over the whole joint.

On truss spans, a slight excess camber will be permitted as the bottom chords are bolted. But camber and relative elevations of panel points shall be correct before the top chord joints, top lateral system, and sway braces are bolted.

6-03.3(31)A Measuring Camber

The Contractor shall provide the Engineer with a diagram for each truss that shows camber at each panel point. This diagram shall display actual measurements taken as the truss is being assembled.

6-03.3(32) Assembling and Bolting

To begin bolting any field connection or splice, the Contractor shall install and tighten to snug tight enough bolts to bring all parts into full contact with each other prior to tightening these bolts to the specified minimum tension. “Snug tight” means either the tightness reached by (l) a few blows from an impact wrench or (2) the full effort of a person using a spud wrench.

As erection proceeds, all field connections and splices for each member shall be securely drift pinned and bolted in accordance with 1 or 2 below before the weight of the member can be released or the next member is added. Field erection drawings shall specify pinning and bolting requirements that meet or exceed the following minimums:

1. **Joints in Normal Structures** – Fifty percent of the holes in a single field connection and 50 percent of the holes on each side of a single joint in a splice plate shall be filled with drift pins and bolts. Thirty percent of the filled holes shall be pinned. Seventy percent of the filled holes shall be bolted and tightened to snug tight. Once all these bolts are snug tight, each bolt shall be systematically tightened to the specified minimum tension. "Systematically tightened" means beginning with bolts in the most rigid part, which is usually the center of the joint, and working out to its free edges. The fully tensioned bolts shall be located near the middle of a single field connection or a single splice plate.
2. **Joints in Cantilevered Structures** – Seventy-five percent of the holes in a single field connection and 75 percent of the holes on each side of a single joint in a splice plate shall be filled with drift pins and bolts. Fifty percent of the filled holes shall be pinned. Fifty percent of the filled holes shall be bolted and tightened to snug tight. Once all these bolts are snug tight, each bolt shall be systematically tightened to the specified minimum tension. The fully tensioned bolts shall be located near the middle of a single field connection or a single splice plate.

Cylindrical erection pins (drift pins) shall be placed throughout each field connection and each field joint with the greatest concentration in the outer edges of a splice plate or member being bolted. Drift pins shall be double-tapered barrel pins of hardened steel. The diameter of the drift pins shall be at least 1/32 inch larger than the diameter of the bolts in the connection or the full hole diameter.

To complete a joint following one of the methods listed above, the Contractor shall fill all remaining holes of the field connection or splice plate with bolts and tighten to snug tight. Once all of these bolts are snug tight, each bolt shall be systematically tightened to the specified minimum tension. After these bolts are tightened to the specified minimum tension, the Contractor shall replace the drift pins with bolts tightened to the specified minimum tension.

The Contractor shall complete the joint or connection within ten calendar days of installing the first bolt or within a duration approved by the Engineer. Any bolts inserted in an incomplete connection, either loose or tightened snug-tight, which exceed the specified duration for completing the connection, shall be subject to the following requirements:

1. Three assemblies for each size and length shall be removed from connection(s) that are to be tensioned. Rotational capacity tests shall be performed on the removed assemblies to demonstrate the assembly has sufficient lubricant to be tensioned satisfactorily.
2. Five assemblies shall be removed from the connection to establish the inspection torque.

3. In the case of tension controlled bolts, three assemblies shall be removed and tested in accordance with Section 6-03.3(33)A to verify the minimum specified tension can be achieved prior to shearing of the spline.

Assemblies removed for the purpose of rotational capacity testing, determination of the inspection torques, or verification of tension controlled bolt performance shall be replaced with new bolts at no additional expense to the Contracting Agency. To minimize the number of removed assemblies, the Contractor may combine rotational capacity testing and inspection torque determination as approved by the Engineer.

The Contractor may complete a field bolted connection or splice in a continuous operation before releasing the mass of the member or adding the next member. The Contractor shall utilize drift pins to align the connection. The alignment drift pins shall fill between 15 and 30 percent of the holes in a single field connection and between 15 and 30 percent of the holes on each side of a single joint in a splice plate. Once the alignment drift pins are in place, all remaining holes shall be filled with bolts and tightened to snug tight starting from near the middle and proceeding toward the outer gage lines. Once all of these bolts are snug tight, the Contractor shall systematically tighten all these bolts to the specified minimum tension. The Contractor shall then replace the drift pins with bolts. Each of these bolts shall be tightened to the specified minimum tension.

All bolts shall be placed with heads toward the outside and underside of the bridge. All high-strength bolts shall be installed and tightened before the falsework is removed.

The Contractor may erect metal railings as erection proceeds. But railings shall not be bolted or adjusted permanently until the falsework is released and the deck placed.

The Contractor shall not begin painting until the Engineer has inspected and accepted field bolting.

6-03.3(33) Bolted Connections

Fastener components shall consist of bolts, nuts, washers, tension control bolt assemblies, and direct tension indicators. Fastener components shall meet the requirements of Section 9-06.5(3). After final tightening of the fastener components, the threads of the bolts shall at a minimum be flush with the end of the nut.

The Contractor shall submit Type 1 Working Drawings providing documentation of the bolt tension calibrator, including brand, capacity, model, date of last calibration, and manufacturer's instructions for use. The Contractor shall supply the bolt tension calibrator and all accompanying hardware and calibrated torque wrenches to conduct all testing and inspections described herein. Use of the bolt tension calibrator shall comply with manufacturer's recommendations.

Fastener components shall be protected from dirt and moisture in closed containers at the site of installation. Only as many fastener components as are anticipated to be installed during the Work shift shall be taken from protected storage. Fastener components that are not incorporated into the Work shall be returned to protected storage at the end of the Work shift. Fastener components shall not be cleaned or modified from the

as-delivered condition. Fastener components that accumulate rust or dirt shall not be incorporated into the Work. Tension control bolt assemblies shall not be relubricated, except by the manufacturer.

All bolted connections are slip critical. Painted structures require either Type 1 or Type 3 bolts. Bolts shall not be galvanized unless specified in the Contract documents. When galvanized bolts are specified, tension-control galvanized bolts are not permitted. Unpainted structures require Type 3 bolts. ASTM F3125 Grade A490 bolts shall not be galvanized and shall not be used in contact with galvanized metal.

Washers are required under turned elements for bolted connections and as required in the following:

1. Washers shall be used under both the head and the nut when ASTM F3125 Grade A490 bolts are to be installed in structural carbon steel, as specified in Section 9-06.1.
2. Where the outer face of the bolted parts has a slope greater than 1:20 with respect to a plane normal to the bolt axis, a beveled washer shall be used.
3. Washers shall not be stacked unless otherwise specified by the Engineer.
4. It is acceptable to place a washer under the unturned element.

All galvanized nuts shall be lubricated by the manufacturer with a lubricant containing a visible dye so a visual check for the lubricant can be made at the time of field installation. Black bolts shall be lubricated by the manufacturer and shall be “oily” to the touch when installed.

After assembly, bolted parts shall fit solidly together. They shall not be separated by washers, gaskets, or any other material. Assembled joint surfaces, including those next to bolt heads, nuts, and washers, shall be free of loose mill scale, burrs, dirt, and other foreign material that would prevent solid seating.

When all bolts in a joint are tight, each bolt shall carry at least the proof load shown in Table 1 below:

Table 1 Minimum Bolt Tension

Bolt Size (inches)	ASTM F3125 Grade A325 and Grade F1852 (pounds)	ASTM F3125 Grade A490 (pounds)
½	12,050	14,900
⅝	19,200	23,700
¾	28,400	35,100
⅞	39,250	48,500
1	51,500	63,600
1⅛	56,450	80,100
1¼	71,700	101,800
1⅜	85,450	121,300
1½	104,000	147,500

Prior to final tightening of any bolts in a bolted connection, the connection shall be compacted to a snug tight condition. Snug tight shall include bringing all plies of the connection into firm contact and snug tightening all bolts in accordance with Section 6-03.3(32).

Final tightening may be done by the Turn-of-Nut Method, the direct-tension indicator method, or the twist off-type tension control structural bolt/nut/washer assembly method. Preferably, the nut shall be turned tight while the bolt is prevented from rotating. However, if required by either turn-of-nut or direct-tension-indicator methods because of bolt entering and/or wrench operational clearances, tightening may be done by turning the bolt while the nut is prevented from rotating.

1. **Turn-of-Nut Method** – After all specified bolting conditions are satisfied, and before final tightening, the Contractor shall match-mark with crayon or paint the outer face of each nut and the protruding part of the bolt. Each bolt shall be final tightened to the specified minimum tension by rotating the amount specified in Table 2. To ensure this tightening method is followed, the Engineer will (1) observe as the Contractor installs, snug tightens, and final tightens all bolts and (2) inspect each match-mark.

Table 2 Turn-of-Nut Tightening Method Nut Rotational From Snug Tight Condition

Bolt Length	Disposition of Outer Faces of Bolted Parts		
	Condition 1	Condition 2	Condition 3
L <= 4D	⅓-turn	½-turn	⅔-turn
4D < L<= 8D	½-turn (*)	⅔-turn	⅚-turn
8D < L<= 12D	⅔-turn (*)	⅚-turn	1-turn

(*) When performing rotational capacity testing in accordance with Section 6-03.3(33)A, the total of two times the turns specified in Table 2 may be reduced by 15% for ASTM F3125 GR A490 bolts when allowed by the Engineer.

Bolt length measured from underside of head to top of nut.

Condition 1 – Both faces at right angles to bolt axis.

Condition 2 – One face at right angle to bolt axis, one face sloped no more than 1:20, without bevel washer.

Condition 3 – Both faces sloped no more than 1:20 from right angle to bolt axis, without bevel washer.

Nut rotation is relative to the bolt regardless of which element (nut or bolt) is being turned. Tolerances permitted plus or minus 30 degrees (1/12-turn) for final turns of ½-turn or less; plus or minus 45 degrees (⅛-turn) for final turns of ⅔-turn or more.

D = nominal bolt diameter of bolt being tightened.

When bolt length exceeds 12D, the rotation shall be determined by actual tests in which a suitable tension device simulates actual conditions.

2. **Direct Tension Indicator Method (DTIs)**. DTIs shall be placed under the bolt head with the protrusions facing the bolt head when the nut is turned. DTIs shall be placed under the nut with the protrusions facing the nut when the bolt is turned. DTIs may be placed under the turned element only if a hardened washer is used to separate the turned element from the DTI.

   Gap refusal shall be measured with a 0.005 inch tapered feeler gage. After all specified bolting conditions are satisfied, the snug tightened gaps shall meet Table 3 snug tight limits.

   Each bolt shall be final-tightened to meet Table 3 final-tighten limits. If the bolt is tensioned so that no visible gap in any space remains, the bolt and DTI shall be removed and replaced by a new properly tensioned bolt and DTI.

   The Contractor shall tension all bolts, inspecting all DTIs with a feeler gage, in the presence of the Engineer. DTIs shall be installed by two-person (or more) crews, with one individual (1) preventing the element at the DTI from turning and (2) measuring the gap of the DTI to determine the proper tension of the bolt.

   If a bolt, that has had its DTI brought to full load, loosens during the course of bolting the connection, it shall be rejected. Reuse of the bolt and nut are subject to the provisions of this section. The used DTI shall not be reinstalled.

Table 3 Direct Tension Indicator Requirements

Bolt Size (inches)	DTI Spaces		Maximum Snug Tight Refusals		Minimum Final Tighten Refusals	
	ASTM F3125 Grade A 325	ASTM F3125 Grade A490	ASTM F3125 Grade A 325	ASTM F3125 Grade A490	ASTM F3125 Grade A 325	ASTM F3125 Grade A490
½	4	5	1	2	2	3
⅝	4	5	1	2	2	3
¾	5	6	2	2	3	3
⅞	5	6	2	2	3	3
1	6	7	2	3	3	4
1⅛	6	7	2	3	3	4
1¼	7	8	3	3	4	4
1⅜	7	8	3	3	4	4
1½	8	9	3	4	4	5

3. **Twist Off-Type Tension Control Structural Bolt/Nut/Washer Assembly Method (Tension Control Bolt Assembly)** – Tension control bolt assemblies shall include the bolt, nut, and washer(s) packaged and shipped as a single assembly. Unless otherwise accepted by the Engineer, tension control bolt assembly components shall not be interchanged for testing or installation and shall comply with all provisions of ASTM F3125 Grade F1852. If accepted by the Engineer, the tension control bolt assembly components may be interchanged within the same component lot for girder web splices or other locations where access to both sides of the connection is restricted.

The tension control bolts shall incorporate a design feature intended to either indirectly indicate, or to automatically provide, the minimum tension specified in Table 1.

The Contractor shall submit Type 1 Working Drawings of the tension control bolt assembly, including bolt capacities; type of bolt, nut, and washer lubricant; method of packaging and protection of the lubricated bolt; installation equipment; calibration equipment; and installation procedures.

The tension control bolt manufacturer's installation procedure shall be followed for installation of bolts in the verification testing device, in all calibration devices, and in all structure connections.

In some cases, proper tensioning of the bolts may require more than one cycle of systematic partial tightening prior to final yield or fracture of the tension control element of each bolt. If yield or fracture of the tension control element of a bolt occurs prior to the final tightening cycle, that bolt shall be replaced with a new one.

Additional field verification testing shall be performed as requested by the Engineer.

All bolts and connecting hardware shall be stored and handled in a manner to prevent corrosion and loss of lubricant. Bolts that are installed without the same lubricant coating as tested under the verification test will be rejected, and they shall be removed from the joint and be replaced with new lubricated bolts at no additional cost to the Contracting Agency.

ASTM F3125 Grade A490 bolts, galvanized ASTM F3125 Grade A325 bolts, and ASTM F3125 Grade F1852 tension control bolt assemblies shall not be reused. Black ASTM F3125 Grade A325 bolts may be reused once if accepted by the Engineer. All bolts to be reused shall have their threads inspected for distortion by reinstalling the used nut on the bolt and turning the nut for the full length of the bolt threads by hand. Bolts to be reused shall be relubricated in accordance with the manufacturer's recommendation. Used bolts shall be subject to a rotational capacity test as specified in Section 6-03.3(33)A Pre-Erection Testing. Touching up or retightening bolts previously tightened by the Turn-of-Nut Method, which may have been loosened by the tightening of adjacent bolts shall not be considered as reuse, provided the snugging up continues from the initial position and does not require greater rotation, including the tolerance, than that required by Table 2.

6-03.3(33)A Pre-Erection Testing

High-strength bolt assemblies (bolt, nut, direct tension indicator, and washer), both black and galvanized, shall be subjected to a field rotational capacity test, as outlined below, prior to any permanent fastener installation. For field installations, the rotational capacity test shall be conducted at the jobsite. Each combination of bolt production lot, nut production lot, washer production lot, and direct tension indicator production lot shall be tested as an assembly, except tension control bolt assemblies, which shall be tested as supplied by the manufacturer. Each rotational capacity test shall include three assemblies. Once an assembly passes the rotational capacity test, it is accepted for use for the remainder of the project unless the Engineer deems further testing is necessary. All tests shall be performed in a bolt tension calibrator by the Contractor

in the presence of the Engineer. High-strength bolt assemblies used in this test shall not be reused. The bolt assemblies shall meet the following requirements after being pretensioned to 15 percent of the minimum bolt tension in Table 1. The assembly shall be considered as nonconforming if the assembly fails to pass any one of the following specified requirements:

1. The measured torque to produce the minimum bolt tension shall not exceed the maximum allowed torque value obtained by the following equation:

   $$\text{Torque} = 0.25\ PD$$

   Where:

   Torque = Calculated Torque (foot-pounds)
   P = Measured Bolt Tension (pounds)
   D = Normal Bolt Diameter (feet)

2. After placing the assembly through two cycles of the required number of turns, where turns are measured from the 15 percent pretension condition, as indicated in Table 2,

   a. The maximum recorded tension after the two turns shall be equal to or greater than 1.15 times the minimum bolt tension listed in Table 1.

   b. Each assembly shall be successfully installed to the specified number of turns.

   c. The fastener components in the assembly shall not exhibit shear failure or stripping of the threads as determined by visual examination of bolt and nut threads following removal.

   d. The bolts in the assembly shall not exhibit torsional or torsional/tension failure.

3. If any specimen fails, the assembly will be rejected. Elongation of the bolt between the bolt head and the nut is not considered to be a failure.

Bolts that are too short to test in the bolt tension calibrator shall be tested in a steel joint. The Contractor shall (1) install the high-strength bolt assemblies (bolt, nut, direct tension indicator, and washer) in a steel joint of the proper thickness; (2) tighten to the snug tight condition; (3) match-mark the outer face of each nut and the protruding part of the bolt with crayon or paint; (4) rotate to the requirements of Table 2; and (5) record the torque that is required to achieve the required amount of rotation. The assembly shall be considered as nonconforming if the assembly fails to pass any one of the following specified requirements:

1. The recorded torque to produce the minimum rotation shall not exceed the maximum allowed torque value obtained by the following equation:

   $$\text{Torque} = 0.25\ PD$$

   Where:

   Torque = Calculated Maximum Allowed Torque (foot-pounds)
   P = Specified Bolt Tension per Table 1, multiplied by a factor of 1.15 (pounds)
   D = Normal Bolt Diameter (feet)

2. After placing the assembly through two cycles of the required number of turns, where turns are measured from the snug tight condition specified in Section 6-03.3(32):
   a. Each assembly shall be successfully installed to the specified number of turns.
   b. The fastener components in the assembly shall not exhibit shear failure or stripping of the threads as determined by visual examination of bolt and nut threads following removal.
   c. The bolts in the assembly shall not exhibit torsional or torsional/tension failure.
3. If any specimen fails, the assembly will be rejected. Elongation of the bolt between the bolt head and the nut is not considered to be a failure.

The Contractor shall submit Type 1 Working Drawings consisting of the manufacturer's detailed procedure for pre-erection (rotational capacity) testing of tension control bolt assemblies.

Three DTIs, per lot, shall be tested in a bolt tension calibrator. The bolts shall be tensioned to 105 percent of the tension shown in Table 1. If all of the DTI protrusions are completely crushed (all five openings with zero gap), this lot of DTIs is rejected.

Three twist off-type tension controlled bolt assemblies, per assembly lot, shall be tested in a bolt tension calibrator. The bolts shall first be tensioned to a snug tight condition. Tensioning shall then be completed by tightening the assembly nut in a continuous operation using a spline drive installation tool until the spline shears from the bolt. The bolt assembly tension shall meet the requirements of Table 1. If any specimen fails, the assembly lot is rejected.

6-03.3(33)B Bolting Inspection

The Contractor, in the presence of the Engineer, shall inspect the tightened bolt using a calibrated inspection torque wrench, regardless of bolting method. The Contractor shall supply the inspection torque wrench. Inspection shall be performed within seven calendar days from the completion of each bolted connection or as specified by the Engineer.

If the bolts to be installed are not long enough to fit in the bolt tension calibrator, five bolts of the same grade, size, and condition as those under inspection shall be tested using Direct-Tension-Indicators (DTIs) to measure bolt tension. This tension measurement test shall be done at least once each inspection day. The Contractor shall supply the necessary DTIs. The DTI shall be placed under the bolt head. A washer shall be placed under the nut, which shall be the element turned during the performance of this tension measurement test. Each bolt shall be tightened by any convenient means to the specified minimum tension as indicated by the DTI. The inspecting wrench shall then be applied to the tightened bolt to determine the torque required to turn the nut 5 degrees (approximately 1 inch at a 12-inch radius) in the tightening direction. The job inspection torque shall be taken as the average of three values thus determined after rejecting the high and low values.

Five representative bolts/nuts/washers and DTIs if used (provided by the Contractor) of the same grade, size, and condition as those under inspection shall be placed individually in a bolt tension calibrator to measure bolt tension. This calibration operation shall be done at least once each inspection day. There shall be a washer under the part turned in tightening each bolt if washers are used on the Structure. In the bolt tension calibrator, each bolt shall be tightened by any convenient means to the specified tension. The inspection torque wrench shall then be applied to the tightened bolt to determine the torque required to turn the nut or head 5 degrees (approximately 1 inch at a 12-inch radius) in the tightening direction. The job-inspection torque shall be taken as the average of three values thus determined after rejecting the high and low values.

Ten percent (at least two), or as specified by the Engineer, of the tightened bolts on the Structure represented by the test bolts shall be selected at random in each connection. The job-inspection torque shall then be applied to each with the inspecting wrench turned in the tightening direction, with no restraint applied to the opposite end of the bolt. If this torque turns no bolt head or nut, the Contracting Agency will accept the connection as being properly tightened. If the torque turns one or more bolt heads or nuts, the job-inspection torque shall then be applied to all bolts in the connection. Except for tension control bolt assemblies and DTIs with zero gap at all protrusion spaces, any bolt whose head or nut turns at this stage shall be tightened and reinspected. Any tension control bolt assemblies or DTIs that have zero gap at all protrusion spaces shall be replaced if the head or nut turns at this stage.

The Contractor shall submit Type 1 Working Drawings consisting of the manufacturer's detailed procedure for routine observation to ensure proper use of the tension control bolt assemblies.

6-03.3(34) Adjusting Pin Nuts

All pin nuts shall be tightened thoroughly. The pins shall be placed so that members bear fully and evenly on the nuts. The pins shall have enough thread to allow burring after the nuts are tightened.

6-03.3(35) Setting Anchor Bolts

Anchor bolts shall be set in masonry as required in Section 6-02.3(18). Anchor bolts shall be grouted in after the shoes, masonry plates, and keeper plates have been set and the span or series of continuous spans are completely erected and adjusted to line and camber.

6-03.3(36) Setting and Grouting Masonry Plates

The following procedure applies to masonry plates for all steel spans, including shoes, keeper plates, and turning racks on movable bridges.

To set masonry plates, the Contractor shall:

1. Set masonry plates on the anchor bolts;
2. Place steel shims under the masonry plates to position pin centers or bearings to line and grade and in relationship to each other. Steel shims shall be the size and be placed at the locations shown in the Plans;
3. Level the bases of all masonry plates;
4. Draw anchor bolt nuts down tight;
5. Recheck pin centers or bearings for alignment; and
6. Leave at least ¾ inch of space under each masonry plate for grout.

After the masonry plates have been set and the span or series of continuous spans are completely erected and swung free, the space between the top of the masonry and the top of the concrete bearing seat shall be filled with grout. Main masonry plates for cantilever spans shall be set and grouted in before any steel Work is erected.

Grout shall conform to Section 9-20.3(2) and placement shall be as required in Section 6-02.3(20).

6-03.3(37) Setting Steel Bridge Bearings

Masonry plates, shoes, and keeper plates of expansion bearings shall be set and adjusted to center at a normal temperature of 64°F. Adjustment for an inaccuracy in fabricated length shall be made after dead-load camber is out.

6-03.3(38) Placing Superstructure

The concrete in piers and crossbeams shall reach at least 80 percent of design strength before girders are placed on them.

6-03.3(39) Swinging the Span

Forms weighing less than 5 pounds per square foot of bridge deck area and uniformly distributed along the steel spans may be placed before the spans swing free on their supports. Steel reinforcing bars or concrete bridge deck shall not be placed on steel spans until the spans swing free on their supports and elevations are recorded. No simple span or any series of continuous spans will be considered as swinging free until all temporary supports have been released. Reinforcing steel or concrete bridge decks shall not be placed on any simple or continuous span steel girder bridge until all its spans are adjusted and its masonry plates, shoes, and keeper plates grouted. For this specification, the structure shall be considered as continuous across hinged joints.

After the falsework is released (spans swung free), the masonry plates, shoes, and keeper plates are grouted, and before any load is applied, the Contractor (or the Engineer if the Contracting Agency is responsible for surveying) shall survey elevations at the tenth points along the centerline on top of all girders and floorbeams. The Contractor shall calculate the theoretical top of girder or floorbeam flange elevations and compare the calculated elevations to the surveyed elevations. The theoretical pad or haunch depth shown in the Plans shall be increased or decreased by the difference between the theoretical and surveyed top of girder or floorbeam elevations. The soffit (deck formwork) shall be set based on the Plan bridge deck thickness and the adjusted pad or haunch depth.

The Contractor shall submit all survey data and calculations to the Engineer for review ten working days prior to placing any load, beyond the maximum five pounds per square foot of form weight allowed, on the Structure.

6-03.3(40) Draining Pockets

The Contractor shall provide enough holes to drain all water from pockets in trusses, girders, and other members. Unless shown on approved shop plans, drain holes shall not be drilled without the written approval of the Engineer.

All costs related to providing drain holes shall be included in the unit Contract prices for structural or cast steel.

6-03.3(41) Vacant

6-03.3(42) Surface Condition

As the Structure is erected, the Contractor shall keep all steel surfaces clean and free from dirt, concrete, mortar, oil, paint, grease, and other stain-producing foreign matter. Any surfaces that become stained shall be cleaned as follows:

Painted steel surfaces shall be cleaned by methods required for the type of staining. The Contract shall submit a Type 1 Working Drawing of the cleaning method.

Unpainted steel surfaces shall be cleaned by sandblasting. Sandblasting to remove stains on publicly visible surfaces shall be done to the extent that, in the Engineers opinion, the uniform weathering characteristics of the Structure are preserved.

6-03.3(43) Castings, Steel Forgings, and Miscellaneous Metals

Castings, steel forgings, and miscellaneous metals shall be built to comply with Section 9-06.

6-03.3(43)A Shop Construction, Castings, Steel Forgings, and Miscellaneous Metals

This section's requirements for structural steel (including painting requirements) shall also apply to castings, steel forgings, and miscellaneous metals.

Castings shall be:

1. True to pattern in form and dimensions;
2. Free from pouring faults, sponginess, cracks, blow holes, and other defects in places that would affect strength, appearance, or value;
3. Clean and uniform in appearance;
4. Filleted boldly at angles; and
5. Formed with sharp and perfect arises.

Iron and steel castings and forgings shall be annealed before any machining, unless the Plans state otherwise.

6-03.4 Measurement

Cast or forged metal (kind) shown in the Plans will be measured by the pound or will be paid for on a lump sum basis, whichever is shown on the Proposal.

6-03.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Structural Carbon Steel", lump sum.

The lump sum Contract price for "Structural Carbon Steel" shall be full pay for all costs in connection with furnishing all materials, labor, tools, and equipment necessary for the manufacture, fabrication, transportation, erection, and painting of all structural carbon steel used in the completed Structure, including the providing of such other protective coatings or treatment as may be shown in the Plans or specified in the Special Provisions.

For steel Structures, the estimated weight of the structural carbon steel in the project will be shown in the Plans or in the Special Provisions. In the event any change in the Plans is made which will affect the weight of materials to be furnished, payment for the additional structural carbon steel required as a result of the change in the Plans will be made at a unit price per pound obtained by dividing the Contractor's lump sum Bid for structural carbon steel by the total estimated weight of structural carbon steel shown in the Plans or in the Special Provisions.

Reductions in weight due to a change in the Plans will be made at the same rate as determined above and will be deducted from payments due the Contractor.

Prospective Bidders shall verify the estimated weight of structural carbon steel before submitting a Bid. No adjustment other than for approved changes shall be made in the lump sum Bid even though the actual weight may deviate from the stated estimated weight.

For concrete and timber Structures, where the structural carbon steel is a minor item, no estimated weight will be given for the structural carbon steel. In the event any change in the Plans is necessary which will affect the weight of material to be furnished for this type of Structure, the payment or reduction for the revision in quantity will be made at a unit price per pound obtained by dividing the Contractor's lump sum Bid for the structural carbon steel by the calculated weight of the original material. The calculated weight will be established by the Engineer and will be based on an estimated weight of 490 pounds per cubic foot for steel.

Any change in the Plans which affects the weight of material to be furnished as provided herein will be subject to the provisions of Section 1-04.4.

"Structural Low Alloy Steel", lump sum.

"Structural High Strength Steel", lump sum.

Payment for "Structural Low Alloy Steel" and "Structural High Strength Steel" shall be made on the same lump sum basis as specified for structural carbon steel.

"(Cast or Forged) Steel", lump sum or per pound.

"(Cast, Malleable, or Ductile) Iron", lump sum or per pound.

"Cast Bronze", lump sum or per pound.

Payment for "(Cast or Forged) Steel", "(Cast, Malleable or Ductile) Iron", and "Cast Bronze" will be made at the lump sum or per pound Contract prices as included in the Proposal.

For the purpose of payment, such minor items as bearing plates, pedestals, forged steel pins, anchor bolts, field bolts, shear connectors, etc., unless otherwise provided, shall be considered as structural carbon steel even though made of other materials.

When no Bid item is included in the Proposal and payment is not otherwise provided, the castings, forgings, miscellaneous metal, and painting shall be considered as incidental to the construction, and all costs therefore shall be included in the unit Contract prices for the payment items involved and shown.

6-04 Timber Structures

6-04.1 Description

This Work is the building of any Structure or parts of Structures (except piling) made of treated timber, untreated timber, or both. The Contractor shall erect timber Structures on prepared foundations. The Structures shall conform to the dimensions, lines, and grades required by the Plans, the Engineer, and these Specifications.

Any part of a timber Structure made of nontimber materials shall comply with the sections of these Specifications that govern those materials.

6-04.2 Materials

Materials shall meet the requirements of the following sections:

Structural Steel and Related Material	9-06
Bolts, Washers, Other Hardware	9-06.22
Paints	9-08
Timber and Lumber	9-09

6-04.3 Construction Requirements

6-04.3(1) Storing and Handling Material

At the Work site, the Contractor shall store all timber and lumber in piles. Weeds and rubbish under and around these piles shall have been removed before the lumber is stacked.

Untreated lumber shall be open stacked at least 12 inches above the ground. It shall be piled to shed water and prevent warping.

Treated timber shall be:

1. Cut, framed, and bored (whenever possible) before treatment;
2. Close stacked and piled to prevent warping;
3. Covered against the weather if the Engineer requires it;
4. Handled carefully to avoid sudden drops, broken outer fibers, and surface penetration or bruising with tools; and
5. Lifted and moved with rope or chain slings (without use of cant dogs, peaveys, hooks, or pike poles).

6-04.3(2) Workmanship

The Contractor shall employ only competent bridge carpenters. All their Work shall be true and exact. Nails and spikes shall be driven with just enough force to leave heads flush with wood surfaces. The Contractor shall discharge any worker who displays poor workmanship by leaving deep hammer marks in wood surfaces. Workmanship on metal parts shall comply with requirements for steel Structures.

6-04.3(3) Shop Details

The Contractor shall submit Type 2 Working Drawings consisting of shop detail plans for all treated timber. These plans shall show dimensions for all cut, framed, or bored timbers.

6-04.3(4) Field Treatment of Cut Surfaces, Bolt Holes, and Contact Surfaces

All cut surfaces, bolt holes, and contact surfaces shall be treated in accordance with Section 9-09.3 for all timber and lumber requiring preservative treatment.

All cuts and abrasions in treated piles or timbers shall be trimmed carefully and treated in accordance with Section 9-09.3.

6-04.3(5) Holes for Bolts, Dowels, Rods, and Lag Screws

Holes shall be bored:

1. For drift pins and dowels – with a bit 1⁄16 inch smaller in diameter than the pins and dowels.
2. For truss rods or bolts – with a bit the same diameter as the rods or bolts.
3. For lag screws – in two parts: (a) with the shank lead hole the same diameter as the shank and as deep as the unthreaded shank is long; and (b) with the lead hole for the threaded part approximately ⅔ of the shank diameter.

6-04.3(6) Bolts, Washers, and Other Hardware

Bolts, dowels, washers, and other hardware, including nails, shall be black or galvanized as specified in the Plans, but if not so specified shall be galvanized when used in treated timber Structures.

Washers of the size and type specified shall be used under all bolt heads and nuts that would otherwise contact wood.

All bolts shall be checked by burring the threads after the nuts have been finally tightened. Vertical bolts shall have nuts on the lower ends.

Wherever bolts fasten timber to timber, to concrete, or to steel, the members shall be bolted tightly together at installation and retightened just before the Contracting Agency accepts the Work. These bolts shall have surplus threading of at least ⅜ inch per foot of timber thickness to permit future tightening.

6-04.3(7) Countersinking

Countersinking shall be done wherever smooth faces are required. Each recess shall be treated in accordance with Section 9-09.3.

6-04.3(8) Framing

The Contractor shall cut and frame lumber and timber to produce close-fitting, full-contact joints. Each mortise shall be true to size for its full depth, and its tenon shall fit it snugly. Neither shimmed nor open joints are permitted.

6-04.3(9) Framed Bents

Mudsills shall be of pressure-treated timber, firmly and evenly bedded to solid bearing, and tamped in place.

Concrete pedestals that support framed bents shall be finished so that sills will bear evenly on them. To anchor the sills, the Contractor shall set dowels in the pedestals when they are cast. The dowels shall be at least ¾ inch in diameter and protrude at least 6 inches above the pedestal tops. Pedestal concrete shall comply with Section 6-02.

Each sill shall rest squarely on mudsills, piles, or pedestals. It shall be drift-bolted to mudsills or piles with ¾-inch diameter or larger bolts that extend at least 6 inches into them. When possible, the Contractor shall remove any earth touching the sills to permit free air circulation around them.

Each post shall be fastened to sills with ¾-inch diameter or larger dowels that extend at least 6 inches into the post.

6-04.3(10) Caps

Timber caps shall rest uniformly across the tops of posts or piles and cap ends shall be aligned evenly. Each cap shall be fastened with a drift bolt ¾ inch in diameter or larger that penetrates the post or pile at least 9 inches. The bolt shall be approximately in the center of the pile or post.

If the Roadway grade exceeds 2 percent, each cap shall be beveled to match the grade.

6-04.3(11) Bracing

When pile bents are taller than 10 feet, each shall be braced transversely and every other pair shall be braced longitudinally. No single cross-bracing shall brace more than 20 feet of vertical distance on the piles. If the vertical distance exceeds 20 feet, more than one cross-bracing shall be used. Each brace end shall be bolted through the pile, post, or cap with a bolt ¾ inch in diameter or larger. Other brace/pile intersections shall be bolted or boat-spiked as the Plans require. Cross-bracing shall lap both upper or lower caps and shall be bolted to the caps or sills at each end.

6-04.3(12) Stringers

All stringers that carry laminated decking or vary more than ⅛ inch in depth shall be sized to an even depth at bearing points. Outside stringers shall be butt jointed and spliced. Interior stringers shall be lapped so that each rests over the full width of the cap or floorbeam at each end. Except on sharp horizontal and vertical curves, stringers may cover two spans. In this case, joints shall be staggered and the stringers either toenailed or drift bolted as the Plans require. To permit air circulation on untreated timber Structures, the ends of lapped stringers shall be separated. This separation shall be done by fastening across the lapping face a 1 by 3-inch wood strip cut 2 inches shorter than the depth of the stringer.

Any cross-bridging or solid bridging shall be neatly and accurately framed, then securely toenailed at each end (with two nails for cross-bridging and four nails for solid bridging). The Plans show bridging size and spacing.

6-04.3(13) Wheel Guards and Railings

Wheel guards and railings shall be built as Section 6-06.3(1) requires.

6-04.3(14) Single-Plank Floors

Single-plank floors shall be made of a single thickness of plank on stringers or joists. Unless the Engineer directs otherwise, the planks shall be:

1. Laid heart side down with tight joints,
2. Spiked to each joist or nailing strip with at least two spikes that are at least 4 inches longer than the plank thickness,
3. Spiked at least 2½ inches from the edges,
4. Cut off on a straight line parallel to the centerline of the Roadway,
5. Arranged so that no adjacent planks vary in thickness by no more than 1⁄16 inch, and
6. Surfaced on one side and one edge (S1S1E) unless otherwise specified.

6-04.3(15) Laminated Floors

The strips shall be placed on edge and shall be drawn down tightly against the stringer or nailing strip and the adjacent strip and, while held in place, shall be spiked. Each strip shall extend the full width of the deck, unless some other arrangement is shown in the Plans or permitted by the Engineer.

Each strip shall be spiked to the adjacent strip at intervals of not more than 2 feet, the spikes being staggered 8 inches in adjacent strips. The spikes shall be of sufficient length to pass through two strips and at least halfway through the third. In addition, unless bolting is specified in the Plans, each strip shall be toenailed to alternate stringers with 40d common nails and adjacent strips shall be nailed to every alternate stringer. The ends of all pieces shall be toenailed to the outside stringer. The ends of the strips shall be cut off on a true line parallel to the centerline of the Roadway. When bolts are used to fasten laminated floors to stringers, the bolts shall be placed at the spacing shown in the Plans, and the pieces shall be drawn down tightly to the bolting strips. The bolt heads shall be driven flush with the surface of the deck. Double nuts or single nuts and lock nuts shall be used on all bolts. The strips shall be spiked together in the same manner as specified above.

6-04.3(16) Plank Subfloors for Concrete Decks

Any plank subfloor shall be laid surfaced side down with close joints at right angles to the centerline of the Roadway. Planks shall be spiked in place as required in Section 6-04.3(14).

Floor planks shall be treated in accordance with Section 9-09.3.

6-04.3(17) Trusses

Completed trusses shall show no irregularities of line. From end to end, chords shall be straight and true in horizontal projection. In vertical projection they shall show a smooth curve through panel points that conforms to the correct camber. The Engineer will reject any pieces cut unevenly or roughly at bearing points. Before placement of the hand railing, the Contractor shall complete all trusses, swing them free of their falsework, and adjust them for line and camber (unless the Engineer directs otherwise).

6-04.3(18) Painting

Section 6-07.3(13) governs painting of timber Structures.

6-04.4 Measurement

The criteria in Section 6-03.4 will be used to determine the weight of structural metal other than hardware.

Timber and lumber (treated or untreated) will be measured by the 1,000-board feet (MBM), using nominal thicknesses and widths. Lengths will be actual lengths of individual pieces in the finished Structure with no deduction for daps, cuts, or splices. To measure laminated timber decking, the Contracting Agency will use the number and after-dressing sizes of pieces required in the Plans. The length of each lamination shall be the length remaining in the finished Structure.

6-04.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

1. “Timber and Lumber (untreated or name treatment)”, per MBM.
2. “Structural Metal”, lump sum.

Where no item for structural metal is included in the Proposal, full pay for furnishing and placing metal parts shall be included in the unit Contract price per MBM for “Timber and Lumber”.

When no Bid item is included in the Proposal and is not otherwise provided, painting shall be considered as incidental to the construction, and all costs therefore shall be included in the unit Contract prices for the payment items involved and shown.

6-05 Piling

6-05.1 Description

This Work consists of furnishing and driving piles (timber, precast concrete, cast-in-place concrete, and steel) of the sizes and types the Contract or the Engineer require. This Work also includes cutting off or building up piles when required. In furnishing and driving piles, the Contractor shall comply with the requirements of this Section, the Contract, and the Engineer.

6-05.2 Materials

Materials shall meet the requirements of the following sections:

Reinforcing Steel	9-07
Prestressing Steel	9-07.10
Timber Piling	9-10.1
Concrete Piling	9-10.2
Cast-In-Place Concrete Piling	9-10.3
Steel Pile Tips and Shoes	9-10.4
Steel Piling	9-10.5
Mortar	9-20.4

6-05.3 Construction Requirements

6-05.3(1) Piling Terms

Concrete Piles – Concrete piling may be precast or precast-prestressed concrete, or steel casings driven to the ultimate bearing resistance called for in the Contract which are filled with concrete (cast-in-place) after driving.

Steel Piles – Steel piles may be open-ended or closed-ended pipe piles, or H-piles.

Overdriving – Over-driving of piles occurs when the ultimate bearing resistance calculated from the equation in Section 6-05.3(12), or the wave equation driving criteria if applicable, exceeds the ultimate bearing resistance required in the Contract in order to reach the minimum tip elevation specified in the Contract, or as required by the Engineer.

Maximum Driving Resistance – The maximum driving resistance is either the pile ultimate bearing resistance, or ultimate bearing resistance plus overdriving to reach minimum tip elevation as specified in the Contract, whichever is greater.

Wave Equation Analysis – Wave equation analysis is an analysis performed using the wave equation analysis program (WEAP) with a version dated 1987 or later. The wave equation may be used as specified herein to verify the Contractor's proposed pile driving system. The pile driving system includes, but is not necessarily limited to, the pile, the hammer, the helmet, and any cushion. The wave equation may also be used by the Engineer to determine pile driving criteria as may be required in the Contract.

Ultimate Bearing Resistance – Ultimate bearing resistance refers to the vertical load carrying resistance (in units of force) of a pile as determined by the equation in Section 6-05.3(12), the wave equation analysis, pile driving analyzer and CAPWAP, static load test, or any other means as may be required by the Contract, or the Engineer.

Allowable Bearing Resistance – Allowable bearing resistance is the ultimate bearing resistance divided by a factor of safety. The Contract may state the factor of safety to be used in calculating the allowable bearing resistance from the ultimate bearing resistance. In the absence of a specified factor of safety, a value of three shall be used.

Rated Hammer Energy – The rated energy represents the theoretical maximum amount of gross energy that a pile driving hammer can generate. The rated energy of a pile driving hammer will be stated in the hammer manufacturer's catalog or Specifications for that pile driving hammer.

Developed Hammer Energy – The developed hammer energy is the actual amount of gross energy produced by the hammer for a given blow. This value will never exceed the rated hammer energy. The developed energy may be calculated as the ram weight times the drop (or stroke) for drop, single acting hydraulic, single acting air/steam, and open-ended diesel hammers. For double acting hydraulic and air/steam hammers, the developed hammer energy shall be calculated from ram impact velocity measurements or other means approved by the Engineer. For closed-ended diesel hammers, the developed energy shall be calculated from the measured bounce chamber pressure for a given blow. Hammer manufacturer calibration data may be used to correlate bounce chamber pressure to developed hammer energy. For a single acting diesel hammer the developed energy is determined using the blows per minute.

Transferred Hammer Energy – The transferred hammer energy is the amount of energy transferred to the pile for a given blow. This value will never exceed the developed hammer energy. Factors that cause transferred hammer energy to be lower than the developed hammer energy include friction during the ram down stroke, energy retained in the ram and helmet during rebound, and other impact losses. The transferred energy can only be measured directly by use of sensors attached to the pile. A pile driving analyzer (PDA) may be used to measure transferred energy.

Pile Driving Analyzer – A pile driving analyzer (PDA) is a device which can measure the transferred energy of a pile driving system, the compressive and tensile stresses induced in the pile due to driving, the bending stresses induced by hammer misalignment with the pile, and estimate the ultimate resistance of a pile at a given blow.

Pile Driving System – The pile driving system includes, but is not necessarily limited to, the hammer, leads, helmet or cap, cushion and pile.

Helmet – The helmet, also termed the cap, drive cap, or driving head, is used to transmit impact forces from the hammer ram to the pile top as uniformly as possible across the pile top such that the impact force of the ram is transmitted axially to the pile. The term helmet can refer to the complete impact force transfer system, which includes the anvil or striker plate, hammer cushion and cushion block, and a pile cushion if used, or just the single piece unit into which these other components (anvil, hammer cushion, etc.) fit. The helmet does not include a follower, if one is used. For hydraulic hammers, the helmet is sometimes referred to as the anvil.

Hammer Cushion – The hammer cushion is a disk of material placed on top of the helmet but below the anvil or striker plate to relieve impact shock, thus protecting the hammer and the pile.

Pile Cushion – The pile cushion is a disk of material placed between the helmet and the pile top to relieve impact shock, primarily to protect the pile.

Follower – A follower is a structural member placed between the hammer assembly, which includes the helmet, and the pile top when the pile head is below the reach of the hammer.

Pile Driving Refusal – Pile driving refusal is defined as 15 blows per inch for the last 4 inches of driving. This is the maximum blow count allowed during overdriving.

Minimum Tip Elevation – The minimum tip elevation is the elevation to which the pile tip shall be driven. Driving deeper in order to obtain the required ultimate bearing resistance may be required.

6-05.3(2) Ordering Piling

The Contractor shall order all piling (except cast-in-place concrete and steel piles) from an itemized list the Engineer will provide. This list, showing the number and lengths of piles required, will be based on test-pile driving (or other) data. The list will show lengths below the cutoff point. The Contractor shall supply (and bear the cost of supplying) any additional length required for handling or driving.

The Contractor shall assume all responsibility for buying more or longer piles than those shown on the list provided by the Engineer. All piles purchased on the basis of the Engineer's list but not used in the finished Structure shall become the property of the Contracting Agency. The Contractor shall deliver these as the Engineer directs. The Contractor shall keep pile cutoffs that are 8 feet or under and any longer ones the Contracting Agency does not require.

When ordering steel casings for cast-in-place concrete and steel piling, the Contractor shall base lengths on information derived from driving test piles and from subsurface data. The Contractor shall also select the wall thickness of steel piles or steel casings for cast-in-place piles which will be necessary to prevent damage during driving and handling. The selection of wall thickness for steel piles or steel casings shall also consider the effects of lateral pressures from the soil or due to driving of adjacent piles. Steel piles and steel casings must be strong and rigid enough to resist these pressures without deforming

or distorting. The Contractor shall select the wall thickness based on information derived from test piles, subsurface data and/or wave equation analysis. Wave equation analysis is required prior to ordering piling for piles with specified ultimate bearing resistances of 300 tons or greater. If a wave equation analysis is performed, the Contractor shall base the selection of wall thickness on the maximum driving resistance identified in the Contract to reach the minimum tip elevation, if the maximum driving resistance is greater than the specified ultimate bearing resistance and if a minimum tip elevation is specified. The wave equation analysis shall be submitted by the Contractor as required in Section 6-05.3(9)A. The Engineer will not supply any list for piling of these types.

6-05.3(3) Manufacture of Precast Concrete Piling

Precast concrete piles shall consist of concrete sections reinforced to withstand handling and driving stresses. These may be reinforced with deformed steel bars or prestressed with steel strands. The Plans show dimensions and details. If the Plans require piles with square cross-sections, the corners shall be chamfered 1 inch.

Precast or prestressed piles shall meet the requirements of the *Standard Plans*.

Temporary stress in the prestressing reinforcement of prestressed piles (before loss from creep and shrinkage) shall be 75 percent of the minimum ultimate tensile strength. (For short periods during manufacture, the reinforcement may be overstressed to 80 percent of ultimate tensile strength if stress after transfer to concrete does not exceed 75 percent of that strength.)

Prestressed concrete piles shall have a final (effective) prestress of at least 1,000 psi.

Unless the Engineer approves splices, all piles shall be full length.

The Contracting Agency intends to perform Quality Assurance Inspection. By its inspection, the Contracting Agency intends only to facilitate the Work and verify the quality of that Work. This inspection shall not relieve the Contractor of any responsibility for identifying and replacing defective material and workmanship.

6-05.3(3)A Casting and Stressing

Precast concrete piles shall be constructed in accordance with 6-02.3(9), except as modified in this Section.

Reinforcing bars, hoops, shoes, etc., shall be placed as shown in the Contract, with all parts securely tied together and placed to the specified spacing. No concrete shall be cast until all reinforcement is in place in the forms.

In casting concrete piles, the Contractor shall:

1. Cast them either vertically or horizontally;
2. Use metal forms (unless the Engineer approves otherwise) with smooth joints and inside surfaces that can be reached for cleaning after each use;

3. Brace and stiffen the forms to prevent distortion;
4. Place concrete continuously in each pile, guarding against horizontal or diagonal cleavage planes;
5. Ensure that the reinforcement is properly embedded;
6. Use internal vibration around the reinforcement during concrete placement to prevent rock pockets from forming; and
7. Cast test cylinders with each set of piles as concrete is placed.

Forms shall be metal and shall be braced and stiffened to retain their shape under pressure of wet concrete. Forms shall have smooth joints and inside surfaces easy to reach and clean after each use. That part of a form which will shape the end surface of the pile shall be a true plane at right angles to the pile axis.

Each pile shall contain a cage of nonprestressed reinforcing steel. The Contractor shall follow the Contract in the size and location of this cage, and shall secure it in position during concrete placement. Spiral steel reinforcing shall be covered by at least 1½ inches of concrete measured from the outside pile surface.

Prestressing steel shall be tensioned as required in Section 6-02.3(25)C.

The Plans specify tensioning stress for strands or wires. Tension shall be measured by jack pressure as described in Section 6-02.3(25)C. Mechanical locks or anchors shall temporarily maintain cable tension. All jacks shall have hydraulic pressure gauges (accurately calibrated and accompanied by a certified calibration curve no more than 180 days old) that will permit stress calculations at all times.

All tensioned piles shall be pretensioned. Post-tensioning is not allowed.

The Contractor shall not stress any pile until test cylinders made with it reach a compressive strength of at least 3,300 psi.

6-05.3(3)B Finishing

As soon as the forms for precast concrete piles are removed, the Contractor shall fill all holes and irregularities with mortar conforming to Section 9-20.4(2) mixed at a 1:2 cement/aggregate ratio. That part of any pile that will be underground or below the low-water line and all parts of any pile to be used in salt water or alkaline soil shall receive only this mortar treatment. That part of any pile that will show above the ground or water line shall be given a Class 2 finish as described in Section 6-02.3(14)B.

6-05.3(3)C Curing

Precast Concrete Piles – The Contractor:

1. Shall keep the concrete continuously wet with water after placement for at least 10 days with Type I or II portland cement or at least 3 days with Type III.
2. Shall remove side forms no sooner than 24 hours after concrete placement, and then only if the surrounding air remains at no less than 50°F for 5 days with Type I or II portland cement or 3 days with Type III.
3. May cure precast piles with saturated steam or hot air, as described in Section 6-02.3(25)D, provided the piles are kept continuously wet until the concrete has reached a compressive strength of 3,300 psi.

Precast-Prestressed Concrete Piles – These piles shall be cured as required in Section 6-02.3(25)D.

6-05.3(4) Manufacture of Steel Casings for Cast-In-Place Concrete Piles

The diameter of steel casings shall be as specified in the Contract. A full-penetration groove weld between welded edges is required.

6-05.3(5) Manufacture of Steel Piles

Steel piles shall be made of rolled steel H-pile sections, steel pipe piles, or of other structural steel sections described in the Contract. A full penetration groove weld between welded edges is required.

At least 14-days prior to the start of production of the piling, the Contractor shall advise the Engineer of the production schedule. The Contractor shall give the Inspector safe and free access to the Work. If the Inspector observes any nonspecification Work or unacceptable quality control practices, the Inspector will advise the plant manager. If the corrective action is not acceptable to the Engineer, the piling(s) will be subject to rejection by the Engineer.

6-05.3(6) Splicing Steel Casings and Steel Piles

The Engineer will normally permit steel piles and steel casings for cast-in-place concrete piles to be spliced. But in each case, the Contractor shall submit Type 2 Working Drawings supporting the need and describing the method for splicing. Welded splices shall be spaced at a minimum distance of 10 feet. Only welded splices will be permitted.

Splice welds for steel piles shall comply with Section 6-03.3(25) and AWS D1.1/D1.1M, latest edition, Structural Welding Code. Splicing of steel piles shall be performed in accordance with an approved weld procedure. The Contractor shall submit a Type 2 Working Drawing consisting of the weld procedure. For ASTM A252 material, mill certification for each lot of pipe to be welded shall accompany the submittal. The ends of all steel pipe piling shall meet the fit-up requirements of AWS D1.1/D1.1M, latest edition, Structural Welding Code Section 5.22.3.1, “Girth Weld Alignment (Tubular),” when the material is spliced utilizing a girth weld.

Splice welds of steel casings for cast-in-place concrete piles shall be the Contractor's responsibility and shall be welded in accordance with AWS D1.1/D1.1M, latest edition, Structural Welding Code. A weld procedure submittal is not required for steel casings used for cast-in-place concrete piles. Casings that collapse or are not watertight, shall be replaced at the Contractor's expense.

6-05.3(7) Storage and Handling

The Contractor shall store and handle piles in ways that protect them from damage.

6-05.3(7)A Timber Piles

Timber piling shall be stacked closely and in a manner to prevent warping. The ground beneath and around stored piles shall be cleared of weeds, brush, and rubbish. Piling shall be covered against the weather if the Engineer requires it.

The Contractor shall take special care to avoid breaking the surface of treated piles. They shall be lifted and moved with equipment, tools, and lifting devices which do not penetrate or damage the piles. If timber piles are rafted, any attachments shall be within 3 feet of the butts or tips. Any surface cut or break shall be repaired in accordance with Section 9-09.3. The Engineer may reject any pile because of a cut or break.

6-05.3(7)B Precast Concrete Piles

The Contractor shall not handle any pile until test cylinders made with the same batch of concrete as the pile reach a compressive strength of at least 3,300 psi.

Storing and handling methods shall protect piles from fractures by impact and undue bending stresses. Handling methods shall never stress the reinforcement more than 12,000 psi. An allowance of twice the calculated load shall be made for impact and shock effects. The Contractor shall submit Type 2 Working Drawings consisting of the method of lifting the piles. The Contractor will take extra care to avoid damaging the surface of any pile to be used in seawater or alkaline soil.

6-05.3(7)C Steel Casings and Steel Piles

The Engineer will reject bent, deformed, or kinked piles that cannot be straightened without damaging the metal.

6-05.3(8) Pile Tips and Shoes

The Contracting Agency prefers that timber piles be driven with squared ends. But if conditions require, they may be shod with metal shoes. Pile tips and shoes shall be securely attached to the piles in accordance with the manufacturer's recommendations.

Where called for in the Contract, conical steel pile tips shall be used when driving steel casings. The tips shall be inside fit, flush-mounted such that the tip and/or weld bead does not protrude more than 1/16 inch beyond the nominal outside diameter of the steel casing.

If conical tips are not specified, the lower end of each casing shall have a steel driving plate that is thick enough to keep the casing watertight and free from distortion as it is driven. The diameter of the steel driving plate shall not be greater than the outside diameter of the steel casing.

Where called for in the Contract, inside-fit cutting shoes shall be used when driving open-ended steel piles. The cutting shoes shall be flush-mounted such that the shoe and/or weld bead does not protrude more than 1⁄16 inch beyond the nominal outside diameter of the steel pile. The cutting shoe shall be of an inside diameter at least ¾ inch less than the nominal inside diameter of the steel pile.

Pile tips or shoes shall be of a type denoted in the Qualified Products List. If pile tips or shoes other than those denoted in the Qualified Products List are proposed, the Contractor shall submit Type 2 Working Drawings consisting of shop drawings of the proposed pile tip along with design calculations, Specifications, material chemistry and installation requirements, along with evidence of a pile driving test demonstrating suitability of the proposed pile tip. The test shall be performed in the presence of the Engineer or an acceptable independent testing agency. The test shall consist of driving a pile fitted with the proposed tip. If the pile cannot be visually inspected (Section 6-05.3(11)F), a sacrificial pile fitted with the proposed tip shall be driven outside the proposed foundation limits. The pile shall be driven to a depth sufficient to develop the required ultimate bearing resistance as called for in the Contract, in ground conditions determined to be equivalent to the ground conditions at the project site. For closed-ended casings or piles, the pile need not be removed if, in the opinion of the Engineer, the pile can be inspected for evidence of damage to the pile or the tip. For open-ended steel casings or piles, timber piles or H-piles, the pile shall be removed for inspection.

6-05.3(9) Pile Driving Equipment

6-05.3(9)A Pile Driving Equipment Approval

Prior to driving any piles, the Contractor shall submit Type 2 Working Drawings consisting of details of each proposed pile driving system. The pile driving system shall meet the minimum requirements for the various combinations of hammer type and pile type specified in this section. These requirements are minimums and may need to be increased in order to ensure that the required ultimate bearing resistance can be achieved, that minimum tip elevations can be reached, and to prevent pile damage.

The Contractor shall submit Type 2E Working Drawings consisting of a wave equation analysis for all pile driving systems used to drive piling with required maximum driving resistances of greater than 300 tons. The wave equation analysis shall be performed in accordance with the requirements of this section and the user's manual for the program. The wave equation analysis shall verify that the pile driving system proposed does not produce stresses greater than 50,000 psi or 90 percent of the yield stress whichever is less, for steel piles, or steel casings for cast-in-place concrete piles. For prestressed concrete piles, the allowable driving stress in kips shall be $0.095\sqrt{f'_c}$ plus prestress in tension, and $0.85f'_c$ minus prestress in compression, where f'_c is the concrete compressive strength in kips per square inch. For precast concrete piles that are not prestressed, the

allowable driving stress shall be 70 percent of the yield stress of the steel reinforcement in tension, and 0. 85f'_c in compression. The wave equation shall also verify that the pile driving system does not exceed the refusal criteria at the depth of penetration anticipated for achieving the required ultimate bearing resistance and minimum tip elevation. Furthermore, the wave equation analysis shall verify that at the maximum driving resistance specified in the Contract, the driving resistance is 100 blows per foot or less. Unless otherwise specified in the Contract, or directed by the Engineer, the following default values shall be used as input to the wave equation analysis program:

Output option (IOUT)	0
Factor of safety applied to (R_{ult})	1.0
Type of damping	Smith
Residual stress option	No

R_{ult} is the resistance of the pile used in the wave equation analyses. If the ultimate bearing resistance equals the maximum driving resistance, a setup factor of 1.3 may be used in the wave equation analysis to account for pile setup. To use a setup factor in the wave equation analysis, R_{ult} in the analysis is the ultimate bearing resistance divided by 1.3. If the maximum driving resistance exceeds the ultimate bearing resistance, no setup factor should be used, and R_{ult} is equal to the maximum driving resistance of the pile.

Hammer Efficiencies	For Analysis of Driving Resistance	For Analysis of Driving Stresses
Single acting diesel hammers	0.72	0.84
Closed-ended diesel hammers	0.72	0.84
Single acting air/steam hammers	0.60	0.70
Double acting air/steam hammers	0.45	0.53
Hydraulic hammers or other external combustion hammers having ram velocity monitors that may be used to assign an equivalent stroke.	0.85	1.00

Changes to the pile driving system after completion of the Working Drawing review require a revised Working Drawing Submittal.

6-05.3(9)B Pile Driving Equipment Minimum Requirements

For each drop hammer used, the Contractor shall weigh it in the Engineer's presence or submit a Type 1 Working Drawing consisting of a certificate of its weight. The exact weight shall be stamped on the hammer. Drop hammers shall weigh not less than:

1. 3,000 pounds for piles under 50 feet long that have an ultimate bearing resistance of not more than 60 tons, and
2. 4,000 pounds for piles 50 feet and longer or that have an ultimate bearing resistance of 60 to 90 tons.

If a drop hammer is used for timber piles, it is preferable to use a heavy hammer and operate with a short drop.

For each diesel, hydraulic, steam, or air-driven hammer used, the Contractor shall submit a Type 1 Working Drawing consisting of the manufacturer's Specifications and catalog. These shall show all data needed to calculate the developed energy of the hammer used.

Underwater hammers may be used only with permission of the Engineer.

Drop hammers on timber piles shall have a maximum drop of 10 feet. Drop hammers shall not be used to drive timber piles that have ultimate bearing resistance of more than 60 tons.

When used on timber piles, diesel, hydraulic, steam, or air-driven hammers shall provide at least 13,000 foot-pounds of developed energy per blow. The ram of any diesel hammer shall weigh at least 2,700 pounds.

Precast concrete and precast-prestressed concrete piles shall be driven with a single-acting steam, air, hydraulic, or diesel hammer with a ram weight of at least half as much as the weight of the pile, but never less than the minimums stated below. The ratio of developed hammer energy to ram weight shall not exceed 6. Steel casings for cast-in-place concrete, steel pipe, and steel H-piles shall also be driven with diesel, hydraulic, steam, or air hammers. These hammers shall provide at least the following developed energy per blow:

Minimum Developed Energy per Blow (ft-lbs)				
Maximum Driving Resistance (Tons)	Air or Steam Hammers	Open Ended Diesel Hammers	Closed Ended Diesel Hammers	Hydraulic Hammers
Up to 165	21,500	23,000	30,000	18,500
166 to 210	27,500	29,500	38,000	23,500
211 to 300	39,000	41,500	54,000	33,500
301 to 450	59,000	63,000	81,000	50,500

In addition, the ram of any diesel or hydraulic hammer shall have the following minimum weights:

Maximum Driving Resistance (Tons)	Minimum Ram Weight (lbs)
Up to 165	2,700
166 to 210	4,000
211 to 300	5,000
301 to 450	6,500

These requirements for minimum hammer size may be waived if a Type 2E Working Drawing is submitted consisting of a wave equation analysis demonstrating the ability of the hammer to obtain the required bearing resistance and minimum tip elevation without damage to the pile.

Vibratory hammers may be used to drive piles provided the location and plumbness requirements of this section are met. The required bearing resistance for all piles driven with vibratory hammers will be determined according to Section 6-05.3(12) by driving the pile at least an additional 2 feet using an impact hammer. This method of determining bearing resistance will be accepted provided the blows per inch are either constant or increasing. If the pile cannot be driven 2 feet, the pile will be considered acceptable for bearing if the pile is driven to refusal.

If water jets are used, the number of jets and water volume and pressure shall be enough to erode the material next to the pile at the tip. The equipment shall include a minimum of two water-jet pipes and two ¾ inch jet nozzles. The pump shall produce a constant pressure of at least 100 psi at each nozzle.

6-05.3(9)C Pile Driving Leads

All piles shall be driven with fixed-lead drivers. The leads shall be fixed on the top and bottom during the pile driving operation. Leads shall be long enough to eliminate the need for any follower (except for timber piles as specified in Section 6-05.3(11)E). To avoid bruising or breaking the surface of treated timber piles, the Contractor shall use spuds and chocks as little as possible. In building a trestle or foundation with inclined piles, leads shall be adapted for driving batter piles.

A helmet of the right size for the hammer shall distribute the blow and protect the top of steel piling or casings from driving damage. The helmet shall be positioned symmetrically below the hammer's striking parts, so that the impact forces are applied concentric to the pile top.

Pile driving leads other than those fixed at the top and bottom may be used to complete driving, if permitted by the Engineer, when all of the following criteria are met:

1. Each plumb and battered pile is located and initially driven at least 20 feet in true alignment using fixed leads or other approved means.
2. The pile driving system (hammer, cushion and pile) will be analyzed by Pile Driving Analyzer (PDA) to verify driving stresses in the pile are not increased due to eccentric loading during driving, and transferred hammer energy is not reduced due to eccentric loading during driving, for all test piles and at least one production pile per pier. Unless otherwise specified, the cost of PDA testing shall be incidental to the various unit Contract prices for driving piles.

6-05.3(10) Test Piles

If the Contract or the Engineer call for it, the Contractor shall drive test piles to determine pile lengths required to reach the required ultimate bearing resistance, penetration, or both. Test piles shall be:

1. Made of the same material and have the same tip diameter as the permanent piles (although test piles for treated timber piles may be either treated or untreated);
2. Driven with pile tips if the permanent piles will have tips;
3. Prebored when preboring is specified for the permanent piles;
4. Identical in cross-section and other characteristics to the permanent piles when the test piles are steel casings for cast-in-place concrete piles, precast concrete, precast-prestressed concrete or steel pipe or H-pile;
5. Long enough to accommodate any soil condition;
6. Driven with equipment and methods identical to those to be used for the permanent piles;
7. Located as the Engineer directs; and
8. Driven before permanent piles in a given pier.

Test piles may also be driven by the Contractor (at no cost to the Contracting Agency) as evidence that the pile driving system selected will not damage the pile or result in refusal prior to reaching any specified minimum tip elevation.

Timber test piles shall be driven outside the footing and cut off 1 foot below the finished ground line. Timber test piles shall not be used in place of permanent piles.

Steel and all types of concrete test piles shall become permanent piles. The Contracting Agency has reduced the number of permanent piles by the number of test piles.

The Contractor shall base test pile length on test-hole data in the Contract. Any test piles that prove to be too short shall be replaced (or spliced if the Contract allows splicing) at the Contractor's expense.

In foundations and trestles, test piles shall be driven to at least 15 percent more than the ultimate bearing resistance required for the permanent piles, except where pile driving criteria is determined by the wave equation. When pile driving criteria is specified to be determined by the wave equation, the test piles shall be driven to the same ultimate bearing resistance as the production piles. Test piles shall penetrate at least to any minimum tip elevation specified in the Contract. If no minimum tip elevation is specified, test piles shall extend at least 10 feet below the bottom of the concrete footing or ground line, and 15 feet below the bottom of the concrete seal.

When any test pile to be left as a permanent pile has been so damaged by handling or driving that the Engineer believes it unfit for use, the Contractor shall remove and replace the pile at no additional cost to the Contracting Agency. The Engineer may direct the Contractor to overdrive the test pile to more than 15 percent above the ultimate bearing

resistance for permanent piles, or if the wave equation is used to determine driving criteria, the Engineer may direct the Contractor to overdrive the test pile above the ultimate bearing resistance. In these cases, the overdriving shall be at the Contractor's expense. But if pile damage results from this overdriving, any removal and replacement will be at the Contracting Agency's expense.

6-05.3(11) Driving Piles

6-05.3(11)A Tolerances

For elevated pier caps, the tops of piles at cut-off elevation shall be within 2 inches of the horizontal locations indicated in the Contract. For piles capped below final grade, the tops of piles at cut-off elevation shall be within 6 inches of the horizontal locations indicated in the Contract. No pile edge shall be nearer than 4 inches from the edge of any footing or cap. Piles shall be installed such that the axial alignment of the top 10 feet of the pile is within 4 percent of the specified alignment. No misaligned steel or concrete piles shall be pulled laterally. A properly aligned section shall not be spliced onto a misaligned section for any type of pile. Unless the Contract shows otherwise, all piles shall be driven vertically.

6-05.3(11)B Foundation Pit Preparation

The Contractor shall replace (and bear the cost of replacing) any pile damaged or destroyed before or during driving.

The Contractor shall completely dig all foundation pits (and build any required cofferdams or cribs) before driving foundation piles. The Contractor shall adjust pit depths to allow for upheaval caused by pile-driving, judging the amount of adjustment by the nature of the soil. Before constructing the footing or pile cap, the Contractor shall restore the pit bottom to correct elevation by removing material or by backfilling with granular material.

6-05.3(11)C Preparation for Driving

Treated and untreated timber piles shall be freshly cut square on the butt ends just before they are driven. If piles will be driven into hard material, caps, collars, or bands shall be placed on the butt ends to prevent crushing or brooming. If the head area of the pile is larger than that of the hammer face, the head shall be snipped or chamfered to fit the hammer. On treated piles, the heads shall be snipped or chamfered to at least the depth of the sapwood to avoid splitting the sapwood from the pile body.

The Contractor shall match timber pile sizes in any single bent to prevent sway braces from undue bending or distorting.

When driven, pile faces shall be turned as shown in the Plans or as the Engineer directs.

No precast-prestressed pile shall be driven until test cylinders poured with it reach at least the specified compressive strength shown in the Contract. On all other precast piles, the cylinders must reach a compressive strength of at least 4,000 psi before the piles are driven.

Helmets of approved design shall protect the heads of all precast concrete piles as they are driven. Each helmet shall have fitted into it a cushion next to the pile head. The bottom side of the helmet shall be recessed sufficiently to accommodate the required pile cushion and hold the pile in place during positioning and driving. The inside helmet diameter shall be determined before casting the pile, and the head of the pile shall be formed to fit loosely inside the helmet.

Steel Casing, steel pipe or H-piles shall have square-cut ends.

6-05.3(11)D Achieving Minimum Tip Elevation and Bearing

Once pile driving has started, each pile shall be driven continuously until the required ultimate bearing resistance shown in the Contract has been achieved. Pauses during pile driving, except for splicing, mechanical breakdown, or other unforeseen events, shall not be allowed.

If the Contract specifies a minimum tip elevation, the pile shall be driven to at least the minimum tip elevation, even if the ultimate bearing resistance has been achieved, unless the Engineer directs otherwise. If a pile does not develop the required ultimate bearing resistance at the minimum tip elevation, the Contractor shall continue driving the pile until the required bearing resistance is achieved. If no minimum tip elevation is specified, then the piles shall be driven to the ultimate bearing resistance shown in the Contract and the following minimum penetrations:

Pile supporting cross-beams, bents, elevated pile caps elevation	10 feet below final top of ground
Piles supporting foundations	10 feet below bottom of foundation
Piles with a concrete seal	15 feet below bottom of seal

If overdriving is required in order to reach a specified minimum tip elevation, the Contractor shall provide a pile driving system which will not result in damage to the pile or refusal before the minimum tip elevation is reached. The cost of overdriving shall be incidental to the various unit Contract prices for furnishing and driving piles.

So long as the pile is not damaged and the embankment or foundation material being driven through is not permanently damaged, the Contractor shall use normal means necessary to:

1. Secure the minimum depth specified,
2. Penetrate hard material that lies under a soft upper layer,
3. Penetrate through hard material to obtain the specified minimum tip elevation, or
4. Penetrate through a previously placed embankment.

Normal means refer to methods such as preboring, spudding, or jetting piles. Blasting or drilling through obstructions are not considered normal means.

Prebored holes and pile spuds shall have a diameter no larger than the least outside dimension of the pile. After the pile is driven, the Contractor shall fill all open spaces between the pile and the soil caused by the preboring or spudding with dry sand, or pea gravel, or controlled density fill as approved by the Engineer.

If water jets are used, the jets shall be withdrawn before the pile reaches its final penetration, and the pile shall then be driven to its final penetration and ultimate bearing resistance. The pile shall be driven a minimum of 2 feet to obtain the ultimate bearing resistance after the jets are withdrawn, or to refusal, whichever occurs first. If the water jets loosen a pile previously driven, it shall be redriven in place or pulled and replaced by a new pile. To check on pile loosening, the Contractor shall attempt to redrive at least one in every five piles, but no less than one pile per bent or pier.

The various unit Contract prices for driving piles shall cover all costs related to the use of water jets, preboring, or spudding. The Contracting Agency will not pay any costs the Contractor incurs in redriving piles loosened as a result of using water jets, preboring, or spudding.

If the Engineer requires, the Contractor shall overdrive the pile beyond the ultimate bearing resistance and minimum tip elevation shown in the Contract. In this case, the Contractor will not be required to:

1. Use other than normal means to achieve the additional penetration,
2. Bear the expense of removing or replacing any pile damaged by overdriving, or
3. Bear the expense of overdriving the pile more than 3 feet as specified in Section 6-05.5.

In driving piles for footings with seals, the Contractor shall use no method (such as jetting or preboring) that might reduce friction resistance.

6-05.3(11)E Use of Followers for Driving

Followers shall not be used to drive concrete or steel piles. On timber piles, the Contractor may use steel (not wooden) followers if the follower fits snugly over the pile head. If a follower is used, the Contractor shall, in every group of 10 piles, drive one long pile without a follower, but no less than one pile per bent or pier, to the required ultimate bearing resistance and minimum tip elevation. This long pile shall be used to test the bearing resistance of the piles driven with a follower in the group. The tip elevation of the long pile shall be similar to the elevation of the piles driven with the follower. If the tip elevations are significantly different, as determined by the Engineer, the Contractor shall redrive the remaining piles in the group to the tip elevation of the longer pile.

6-05.3(11)F Pile Damage

The Contractor shall remove and replace (and bear the cost of doing so) any pile that is damaged as determined by the Engineer.

After driving a steel casing for a cast-in-place concrete pile, the Contractor shall leave it empty until the Engineer has inspected and accepted it. The Contractor shall make available to the Engineer a light suitable for inspecting the entire length of its interior. The Engineer will reject any casing that is improperly driven, that shows partial collapse that would reduce its ultimate bearing resistance, or that has been reduced in diameter, or that will not keep out water. The Contractor shall replace (and bear the cost of replacing) any rejected casing.

Pile heads which have been broomed, rolled, or otherwise significantly damaged as determined by the Engineer shall be cut back to undamaged material before proceeding with driving as well as final acceptance of the pile.

6-05.3(11)G Pile Cutoff

The Contractor shall trim the tops of all piles to the true plane shown in the Contract and to the elevation the Engineer requires. If a pile is driven below cutoff elevation without the Engineer's permission, the Contractor shall remove and replace it (and bear the costs of doing so), even if this requires a longer pile. Any pile that rises as nearby piles are driven, shall be driven down again if the Engineer requires.

Any piles under timber caps or grillages shall be sawed to the exact plane of the Structure above them and fit it exactly. No shimming on top of timber piles to adjust for inaccurate pile top elevations will be permitted. If a timber pile is driven out of line, it shall be straightened without damage before it is cut off or braced.

Steel casing shall be cut off at least 6 inches below the finished ground line or at the low water line if the casing will be visible as determined by the Engineer.

6-05.3(11)H Pile Driving From or Near Adjacent Structures

The Contractor shall not drive piling from an existing Structure unless all of the following conditions are met:

1. The existing Structure will be demolished within the Contract;
2. The existing Structure is permanently closed to traffic; and
3. Type 2E Working Drawings are submitted in accordance with Sections 1-05.3 and 6-02.3(16), showing the structural adequacy of the existing Structure to safely support all of the construction loads.

Freshly placed concrete in the vicinity of the pile driving operation shall be protected against vibration in accordance with Section 6-02.3(6)D.

6-05.3(12) Determination of Bearing Values

The following formula shall be used to determine ultimate bearing resistances:

$$P = F \times E \times Ln(10N)$$

Where:

P	=	ultimate bearing resistance, in tons
F	=	1.8 for air/steam hammers
	=	1.2 for open ended diesel hammers and precast concrete or timber piles
	=	1.6 for open ended diesel hammers and steel piles
	=	1.2 for closed ended diesel hammers
	=	1.9 for hydraulic hammers
	=	0.9 for drop hammers
E	=	developed energy, equal to W times H[1], in ft-kips
W	=	weight of ram, in kips
H	=	vertical drop of hammer or stroke of ram, in feet
N	=	average penetration resistance in blows per inch for the last 4 inches of driving
Ln	=	the natural logarithm, in base “e”

[1]For closed-end diesel hammers (double-acting), the developed hammer energy (E) is to be determined from the bounce chamber reading. Hammer manufacturer calibration data may be used to correlate bounce chamber pressure to developed hammer energy. For double acting hammer hydraulic and air/steam hammers, the developed hammer energy shall be calculated from ram impact velocity measurements or other means acceptable to the Engineer. For open ended diesel hammers (single-acting) use the blows per minute to determine the developed energy (E).

The above formula applies only when:

1. The hammer is in good condition and operating in a satisfactory manner.
2. A follower is not used.
3. The pile top is not damaged.
4. The pile head is free from broomed or crushed wood fiber.
5. The penetration occurs at a reasonably quick, uniform rate; and the pile has been driven at least 2 feet after any interruption in driving greater than 1 hour in length.
6. There is no perceptible bounce after the blow. If a significant bounce cannot be avoided, twice the height of the bounce shall be deducted from “H” to determine its true value in the formula.
7. For timber piles, bearing resistances calculated by the formula above shall be considered effective only when it is less than the crushing strength of the piles.
8. If “N” is greater than or equal to 1.0 blow/inch.

If “N” required to achieve the required ultimate bearing resistance using the above formula is less than 1.0 blow/inch, the pile shall be driven until the penetration resistance is a minimum of 1.0 blow/inch for the last 2 feet of driving.

The Engineer may require the Contractor to install a pressure gauge on the inboard end of the hose to check pressure at the hammer.

If water jets are used in driving, bearing resistances shall be determined either: (1) by calculating it with the driving data and the formula above after the jets have been withdrawn and the pile is driven at least 2 feet, or (2) by applying a test load.

6-05.3(13) Treatment of Timber Pile Heads

After cutting timber piles to correct elevation, the Contractor shall thoroughly coat the heads of all untreated piles with two coats of an approved preservative that meets the requirements of Section 9-09 (except concrete-encased piles).

After cutting treated timber piles to correct elevation, the Contractor shall brush three coats of a preservative that meets the requirements of Section 9-09 on all pile heads (except those to be covered with concrete footings or concrete caps). The pile heads shall then be capped with alternate layers of an approved roofing asphalt and a waterproofing fabric that conforms to Section 9-11.2. The cap shall be made of four layers of an approved roofing asphalt and three layers of fabric. The fabric shall be cut large enough to cover the pile top and fold down at least 6 inches along all sides of the pile. After the fabric cover is bent down over the pile, its edges shall be fastened with large-head galvanized nails or with three turns of galvanized wire. The edges of the cover shall be neatly trimmed.

On any treated timber pile encased in concrete, the cut end shall receive two coats of an approved preservative that meets the requirements of Section 9-09 and then a heavy coat of an approved roofing asphalt.

6-05.3(14) Extensions and Buildups of Precast Concrete Piles

The Contractor shall add extensions, or buildups (if necessary) on precast concrete piles after they are driven to the required ultimate bearing resistance and minimum tip elevation.

Before adding extensions or buildups to precast-prestressed piles, the Contractor shall remove any spalled concrete, leaving the pile fresh-headed and with a top surface perpendicular to the axis of the pile. The concrete in the buildup shall be Class 5000.

Before adding to non-prestressed precast concrete piles, the Contractor shall cut the pile head away to a depth 40 times the diameter of the vertical reinforcing bar. The final cut shall be perpendicular to the axis of the pile. Reinforcement of the same density and configuration as used in the pile shall be used in the buildup and shall be fastened firmly to the projecting steel. Forms shall be placed to prevent concrete from leaking along the pile. The concrete in the buildup shall be Class 4000.

Just before placing the concrete for extensions or buildups to precast or precast-prestressed concrete piles, the Contractor shall thoroughly wet the top of the pile. Forms shall remain in place at least 3 days.

6-05.3(15) Completion of Cast-In-Place Concrete Piles

After acceptance by the Engineer, driven casings shall be cut off horizontally at the required elevation. They shall be clean and free of water when concrete and reinforcing steel are placed.

These piles shall consist of steel casings driven into the ground, reinforced as specified, and filled with Class 4000P concrete.

6-05.3(15)A Reinforcement

All bars shall be fastened rigidly into a single unit, then lowered into the casing before the concrete is placed. Loose bars shall not be used.

Spiral hooping reinforcement shall be deformed steel bar, plain steel bar, cold-drawn wire, or deformed wire.

6-05.3(15)B Placing Concrete

Before placing concrete, the Contractor shall remove all debris and water from the casing. If the water cannot be removed, the casing shall be removed (or cut off 2 feet below the ground and filled with sand) and a new one driven.

The Contractor shall place concrete continuously through a 5-foot rigid conduit directing the concrete down the center of the pile casing, ensuring that every part of the pile is filled and the concrete is worked around the reinforcement. The top 5 feet of concrete shall be placed with the tip of the conduit below the top of fresh concrete. The Contractor shall vibrate, as a minimum, the top 10 feet of concrete. In all cases, the concrete shall be vibrated to a point at least 5 feet below the original ground line.

6-05.4 Measurement

Measurement for driving (type) pile will be the number of piles driven in place.

In these categories, measurement will be the longer of either the number of linear feet driven below cutoff or as shown in the Engineer's order list:

1. Furnishing timber piling (untreated or name of treatment).
2. Precast concrete and precast-prestressed concrete piling.

In these categories, measurement will be the number of linear feet driven below cutoff, but no Engineer's order list will be provided:

1. Cast-in-place concrete piling.
2. Furnishing steel piling.

Measurement for furnishing and driving test piles will be the number actually furnished and driven as the Contract requires.

Measurement for steel pile tips or shoes will be by the number of tips or shoes actually installed and driven in place on steel casings or steel piles.

6-05.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Furnishing and Driving (type) Test Pile", per each.

The unit Contract price per each for "Furnishing and Driving (type) Test Pile" shall be full pay for furnishing and driving test piles to the ultimate bearing resistance or penetration required by the Engineer, furnishing and installing a pile tip when pile tips are specified for the permanent piles, preboring when preboring is specified for the permanent piles, for pulling the piles or cutting them off as required, and for removing them from the site or for delivery to the Contracting Agency for salvage when ordered by the Engineer. For cast-in-place concrete test piles, this price shall include furnishing, fabricating, and installing the steel reinforcing bar cage, and furnishing, casting, and curing the concrete. This price shall also include all costs in connection with moving all pile driving equipment or other necessary equipment to the site of the Work and for removing all such equipment from the site after the piles have been driven. If, after the test piles have been driven, it is found necessary to eliminate the piling from all or any part of the Structure, no additional pay will be allowed for moving the pile driving equipment to and from the site of the Work.

"Driving Timber Pile (untreated or name treatment)", per each.

The unit Contract price per each for "Driving Timber (type) Pile" shall include any metal shoes which the Contractor has determined to be beneficial to the pile driving.

"Driving Conc. Pile (size)", per each.

"Driving St. Pile", per each.

The unit Contract price per each for "Driving (type) Pile (____)" shall be full pay for driving the pile to the ultimate bearing and/or penetration specified.

"Furnishing Timber Piling (untreated or name treatment)", per linear foot.

"Furnishing Conc. Piling (size)", per linear foot.

"Furnishing St. Piling", per linear foot.

The unit Contract price per linear foot for "Furnishing (type) Piling (____)" shall be full pay for furnishing the piling specified, including furnishing, fabricating, and installing the steel reinforcing bar cage, and furnishing casting, and curing the concrete, as required for concrete piling. Such price shall also be full pay, for furnishing timber, precast concrete, or precast-prestressed concrete piling length ordered from an Engineer's order sheet but not driven.

"Precast Concrete Pile Buildup", by force account.

Payment for buildups of precast or precast-prestressed concrete piles will be made on the basis of force account Work as covered in Section 1-09.6. No payment will be made for buildups or additional lengths of buildup made necessary because of damage to the piling during driving. The length of splice for precast concrete piles includes the length cut off to expose reinforcing steel for the splice. The length of splice for precast-prestressed piles includes the length in which holes are drilled and reinforcing bars are grouted.

For the purpose of providing a common Proposal for all Bidders, the Contracting Agency entered an amount for "Precast Concrete Pile Buildup" in the Proposal to become part of the total Bid by the Contractor.

"Furnishing Steel Pile Tip or Shoe (size)", per each.

6-06 Bridge Railings

6-06.1 Description

This Work consists of providing and building bridge railings that meet the requirements of the Plans, these Specifications, and the Engineer.

6-06.2 Materials

Materials shall meet the requirements of the following sections:

Timber Railing	9-09
Metal Railing	9-06.18

6-06.3 Construction Requirements

6-06.3(1) Timber Railings

Wheel guards and railings shall be true to line and grade and framed accurately. The Contractor shall follow Section 6-04 whenever this Subsection does not specify a construction method.

Unless the Plans show otherwise, wheel guards shall be:

1. Beveled and surfaced on the Roadway side and surfaced on the top edge. They may be surfaced on four sides (S4S).
2. Laid in sections at least 12 feet long.
3. Bolted through the floor plank and outside stringer (or nailing piece) with ¾ inch diameter bolts spaced no more than 4 feet apart.

All rails and rail post material shall be S4S and painted as required in Section 6-07. Railing members shall be fastened securely together, with the bolts tightened once at installation and again just before the Contracting Agency's final acceptance of the Contract.

6-06.3(2) Metal Railings

Metal railing includes posts, web members, and horizontal members of the sidewalk and Roadway railing. Unless the Plans or Special Provisions show otherwise, these shall be made of aluminum alloy or steel.

Before fabricating the railing, the Contractor shall submit Type 2 Working Drawings of the shop plans. The Contractor may substitute other rail connection details for those shown in the Plans if details of these changes show in the shop plans and if the Engineer accepts them in the Working Drawing response comments. In reviewing the shop plans, the Engineer indicates only that they are adequate and complete enough. The review does not indicate a check on dimensions.

Anchor bolts shall be positioned with a template to ensure that bolts match the hole spacing of the bottom channels or anchorage plates.

Where specified, cover plates shall fit the bottom channel tightly after being snapped into position.

Metal railings shall be installed true to line and grade (or camber). After first setting the railing, the Contractor shall readjust all or part of it, if necessary, to create an overall line and grade pleasing to the eye.

6-06.4 Measurement

Timber railing will be measured by the thousand board feet (MBM) as shown in Section 6-04.

Metal railing will be measured by the linear foot along the line and slope at the base of the completed railing.

6-06.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Timber and Lumber (untreated or name treatment)", per MBM.

"Bridge Railing Type ____", per linear foot.

In case no item is included in the Contract for "Bridge Railing Type ____" and payment is not otherwise provided, all metal railings shall be included in the lump sum Contract price for "Structural Carbon St". as specified in Section 6-03.

6-07 Painting

6-07.1 Description

This work consists of containment, surface preparation, shielding adjacent areas from work, testing and disposing of debris, furnishing and applying paint, and cleaning up after painting is completed. The work shall comply with all requirements of the Plans, these Specifications, and the Engineer. Terminology used herein is in accordance with the definitions used in Volume 2, Systems and Specifications, of the SSPC *Steel Structures Painting Manual*.

6-07.2 Materials

Materials shall meet the requirements of the following sections:

Paints and Related Materials	9-08
Powder Coating Materials for Coating Galvanized Surfaces	9-08.2
Abrasive Blast Media	9-08.4(1)
Lead Abatement Additive	9-08.4(2)
Bird Guano Treatment	9-08.5(1)
Fungicide Treatment	9-08.5(2)
Water	9-08.5(3)
Filter Fabric	9-08.6
Single Component Polyurethane Sealant	9-08.7
Foam Backer Rod	9-08.8

6-07.3 Construction Requirements

6-07.3(1) Work Force Qualifications

6-07.3(1)A Work Force Qualifications for Shop Application of Paint

Facilities for shop application of paint shall either be selected from one of the facilities listed in the WSDOT Qualified Products List as an approved coating facility for new steel structures or shall be approved through the WSDOT Request for Approval of Material process. The work force may be accepted based on the approved facility.

6-07.3(1)B Work Force Qualifications for Field Application of Paint

The Contractor preparing the surface and applying the paint shall be certified under SSPC-QP 1 or NACE International Institute Contractor Accreditation Program (NIICAP) AS 1.

The Contractor removing and otherwise disturbing existing paint containing lead and other hazardous materials shall be certified under SSPC-QP 2, Category A or NIICAP AS 2.

In lieu of the above SSPC or NIICAP certifications, the Contractor performing the specified work shall complete both of the following actions:

1. The Contractor may substitute documentation of successful completion of two bridge painting projects in the past ten years involving complete paint removal, including paint containing lead and other hazardous materials, with reapplication of a three-component moisture-cured polyurethane paint system. The documentation shall include the name and size of the project, the dates of the work, the owner's name, and name and contact information for an owner's contact person.
2. The Contractor's quality control inspector(s) for the project shall be NACE-certified CIP Level 3 or SSPC Protective Coating Inspector (PCI) Level 3.

6-07.3(2) Submittals

The Contractor shall submit a painting plan consisting of one comprehensive submittal including all components described in this section. The Contractor shall submit Type 2 Working Drawings of the painting plan components, except containment system and support and platform plans shall be Type 2E Working Drawings. Each component of the plan shall identify the specification section it represents.

For shop application of paint, the painting plan shall include the documents and samples listed in Sections 6-07.3(2)B, 6-07.3(2)C, and 6-07.3(2)E.

For field application of paint, the painting plan shall include the documents and samples listed in Section 6-07.3(2)A through 6-07.3(2)F.

6-07.3(2)A Work Force Qualifications Submittal Component

The work force qualifications submittal component of the painting plan shall include the following:

1. Documentation of the Contractor's workforce qualifications as specified in Section 6-07.3(1).
2. Resumé of qualifications and contact information for the Contractor's on-site supervisors. Each on-site supervisor shall have 3 years' minimum of industrial painting field experience with 1 year minimum of field supervisory or management experience in bridge painting projects.

6-07.3(2)B Contractor's Quality Control Program Submittal Component

The Contractor's quality control program submittal component of the painting plan shall include the following:

1. Description of the inspection procedures, tools, techniques and the acceptance criteria for all phases of work.
2. Procedure for implementation of corrective action for non-conformance work.
3. The paint system manufacturer's recommended methods of preventing defects.
4. The Contractor's frequency of quality control inspection for each phase of work.

5. Example of each completed form(s) of the daily quality control report used to document the inspection work and tests performed by the Contractor's quality control personnel.

6-07.3(2)C Paint System Manufacturer and Paint System Information Submittal Component

The paint system manufacturer and paint system information submittal component of the painting plan shall include the following:

1. Product data sheets and Safety Data Sheets (SDS) on the paint materials, paint preparation, and paint application, as specified by the paint manufacturer, including:
   a. All application instructions, including the mixing and thinning directions.
   b. Recommended spray nozzles and pressures.
   c. Minimum and maximum drying time between coats.
   d. Restrictions on temperature and humidity.
   e. Repair procedures for shop and field applied coatings.
   f. Maximum dry film thickness for each coat.
   g. Minimum wet film thickness for each coat to achieve the specified minimum dry film thickness.
2. Identification of, and contact information for, the paint system manufacturer's technical representative.
3. For painting of new steel, the friction coefficient of the faying surface, including test results and the paint manufacturer's Certificate of Compliance in support of the friction coefficient.

6-07.3(2)D Hazardous Waste Containment, Collection, Testing, and Disposal Submittal Component

The hazardous waste containment, collection, testing, and disposal shall meet all Federal and State requirements, and the submittal component of the painting plan shall include the following:

1. Abrasive blasting containment system attachment and support in accordance with Section 6-07.3(10)A, with a complete description of each attachment device.
2. Details of jobsite material storage facilities and containment waste storage facilities, including location, security, and environmental control.
3. Methods and materials used to contain, collect, and dispose of all containment waste and all construction-related waste, including transportation of waste.
4. Details of the containment waste sampling plan conforming to WAC 173-303 for waste designated as dangerous waste or extremely hazardous waste.

5. The name of, and contact information for, the accredited analytical laboratory performing the testing of the containment waste samples in accordance with Section 6-07.3(10)F.
6. Process for tracking the disposal of hazardous waste, including a sample form of the tracking documentation.
7. When a wind speed threshold is specified, a description of the method to lower or withdraw tarps, plastic exterior, and other containment components presenting an exposed face to wind, and the estimated time required to accomplish this action.
8. Provisions for dust and debris collection, ventilation, and auxiliary lighting within the containment system.

6-07.3(2)E Cleaning and Surface Preparation Submittal Component

The cleaning and surface preparation submittal component of the painting plan shall include the following:

1. Details of the abrasive blast cleaning operation, including:
   a. Description of the abrasive blast cleaning procedure.
   b. Type, manufacturer, and brand of abrasive blast material and all associated additives, including Safety Data Sheets (SDS).
   c. Description of the abrasive blast cleaning equipment to be used.

6-07.3(2)F Paint Application Equipment and Operations Submittal Component

The paint application equipment and operations submittal component of the painting plan shall include the following:

1. Description of the equipment used for paint application operations.
2. Details of jobsite material storage facilities, including location, security, and environmental control.
3. Description of the supports and platforms used to support equipment, materials, and workers, including scaffolds, platforms, accordion lifts, and barges, and the methods used to attach, moor, and anchor these supports and platforms.
4. Drip tarps in accordance with Section 6-07.3(10)O.
5. Methods and materials used to protect surrounding structures, equipment, and property from exposure to, and damage from, painting operations.
6. Details of paint application operations for areas of limited and restricted access.
7. Description of the method for the removal of any accidental spills or drips on traffic that occur during the normal painting operations, and provisions for providing a vehicle-cleaning station.

6-07.3(2)G Painting Plan Meeting

At the option of the Contracting Agency, a painting plan meeting may be scheduled following review of the Contractor's initial submittal of the plan. The Contractor shall be represented by the superintendent, on-site supervisors, and quality control inspectors.

6-07.3(3) Quality Control and Quality Assurance

6-07.3(3)A Quality Control and Quality Assurance for Shop Application of Paint

For shop application of paint, quality control procedures shall be as accepted by the Engineer.

6-07.3(3)B Quality Control and Quality Assurance for Field Application of Paint

For field application of paint, the Contractor shall conduct quality control inspections as required by SSPC-PA 1, using the personnel and the processes outlined in the painting plan. The Contractor shall maintain current copies of the SSPC *Painting Manual*, Volumes 1 and 2, at the project site at all times. The Contractor's quality control operations shall include at a minimum monitoring and documenting the following for each working day:

1. Equipment, personnel, and materials used.
2. Environmental conditions (ambient air temperature and humidity, steel surface temperature, dew point, wind direction, and velocity).
3. Steel surface condition, profile, and preparation.
4. Paint application and film thickness.

A Type 1 Working Drawing consisting of the Contractor's daily quality control report, signed and dated by the Contractor's quality control inspector, accompanied by copies of the test results of quality control tests performed on the work covered by the daily quality control report, shall be submitted to the Engineer before the end of the next day's work shift.

The Contractor shall provide the Engineer time and access to perform quality assurance testing. Each painting operation phase shall be considered a hold point, from which the Contractor shall not proceed with continuing work until receiving the Engineer's acceptance.

The Engineer may perform quality assurance testing at each of the following phases of painting operations:

1. After SSPC-SP 1 cleaning.
2. After abrasive blast cleaning, hand and power tool surface cleaning, and compressed air surface cleaning.
3. After applying each coat when dry.
4. During final inspection of all work at the end of the project.

Quality assurance testing may include the following tests:

1. Environmental conditions for painting in accordance with ASTM E337.
2. Cleanness of abrasive blasting media and ionic contamination of abrasive blasting media in accordance with ASTM D4940.
3. Cleanness of compressed air in accordance with ASTM D4285.
4. Pictorial of surface preparation guides in accordance with SSPC-VIS 1, 3, 4, and 5.
5. Surface profile by Keanne-Tator comparator in accordance with ASTM D4417 and SSPC PA17.
6. Surface profile by replica tape in accordance with ASTM D4417.
7. Wet film thickness in accordance with ASTM D4414.
8. Dry film thickness by magnetic gage in accordance with SSPC-PA 2 modified.
9. Dry film thickness by Tooke gage in accordance with ASTM D4138.

The Contractor shall repair all damage to paint resulting from Contracting Agency's quality assurance inspections at no additional cost or time to the Contracting Agency.

6-07.3(4) Paint System Manufacturer's Technical Representative

The paint system manufacturer's technical representative shall be present at the jobsite for the pre-painting conference and for the first day of paint application, and shall be available to the Contractor and Contracting Agency for consultation for the full project duration.

6-07.3(5) Pre-Painting Conference

A pre-painting conference shall be held 5 to 10 working days before beginning painting operations to discuss the painting plan, construction operations, personnel, and equipment to be used. Those attending shall include:

1. (Representing the Contractor) The superintendent, on-site supervisors, and all crew members in charge of cleaning and preparing the surfaces, containing, collecting and disposing of all removed materials, applying the paint, and performing all quality control inspections, measurements and tests; and the paint system manufacturer's technical representative; and
2. (Representing the Contracting Agency) The Engineer, key inspection assistants, and representatives of the WSDOT HQ Construction Office.

If the Contractor's key personnel change between any work operations, an additional conference shall be held if requested by the Engineer.

For projects that include painting of multiple structures, a separate conference may be held for each structure, at the discretion of the Engineer.

6-07.3(6) Paint Containers, Storage, and Handling

6-07.3(6)A Paint Containers

Paint container labels shall include the following information:

1. Manufacturer's name and product name, with batch number and date of manufacture.
2. Color name and SAE AMS Standard 595 color number, where applicable.
3. Shelf life of the product, from date of batch manufacture.
4. Storage requirements and temperature limits.

Paint containers shall conform to U.S. DOT hazardous material shipping regulations. Paint shall be delivered to the jobsite in the manufacturer's original unopened containers with the original manufacturer's label legible and intact. Paint will be rejected if the container has a puncture or if the lid shows signs of paint leakage. Each container shall be filled with paint and sealed airtight. Each container shall be filled with the amount of paint required to yield the specified quantity when measured at 70°F. All paint shall be shipped in new suitable containers having a capacity not greater than 5 gallons.

6-07.3(6)B Paint Storage

Paint materials shall not be used or stored on-site after the shelf life expiration date.

Paint material shipping, handling, and storage shall conform to Sections 1-06.4 and 9-08.1(4) and the following requirements:

1. Paint materials shall be stored in the manufacturer's original containers in a weather-tight space where the temperature is maintained within the storage temperature range recommended by the paint manufacturer, but in no case where the temperature is lower than 40°F or greater than 100°F.
2. The Contractor shall monitor and document daily the paint material storage facility with a high-low recording thermometer device.
3. The paint material storage facility shall be separate from the storage facilities used for storing painting equipment and used for storing containment waste and construction-generated waste.

6-07.3(7) Paint Sampling and Testing

The Contractor shall provide the Engineer 1 quart of each paint representing each lot. Samples shall be accompanied with a Safety Data Sheet.

If the quantity of paint required for each component of the paint system for the entire project is 20 gallons or less, then the paint system components will be accepted as specified in Section 9-08.1(7).

Sampling and testing performed by the Contracting Agency shall not be construed as determining or predicting the performance or compatibility of the individual paint or the completed paint system.

6-07.3(8) Equipment

6-07.3(8)A Paint Film Thickness Measurement Gages

Paint dry film thickness measurements shall be performed with either a Type 1 pull-off gage or a Type 2 electronic gage as specified in SSPC Paint Application Specification No. 2, Procedure for Determining Conformance to Dry Coating Thickness Requirements.

Paint wet film thickness measurement gages shall be stainless steel with notches graduated in 1-mil increments.

6-07.3(9) Painting New Steel Structures

All materials classified as nongalvanized structural steel shall be painted with a four-coat paint system as specified in Section 6-07.3(9)A. The primer coat shall be shop-applied. The intermediate, intermediate stripe, and top coats shall be field-applied after erection and following any primer coating repair operations.

Steel surfaces embedded in concrete, and faying (contact) surfaces of bolted connections (including all surfaces internal to the connection and all filler plates) shall receive the primer coat only. Stainless steel surfaces are not required to be painted. Welded shear connectors are not required to be painted.

Temporary attachments or supports for scaffolding, containment or forms shall not damage the paint system.

6-07.3(9)A Paint System

The paint system applied to new steel surfaces shall consist of the following:

Option 1 (component based paint system):	
Primer Coat - Inorganic Zinc Rich	9-08.1(2)C
Intermediate Coat - Moisture Cured Polyurethane	9-08.1(2)G
Intermediate Stripe Coat - Moisture Cured Polyurethane	9-08.1(2)G
Top Coat - Moisture Cured Polyurethane	9-08.1(2)H
Option 2 (performance based paint system):	
Primer Coat - Inorganic Zinc Rich	9-08.1(2)M
Intermediate Coat - Epoxy	9-08.1(2)M
Intermediate Stripe Coat - Epoxy	9-08.1(2)M
Top Coat - Polyurethane	9-08.1(2)M

Paints and related materials shall be products listed in the current WSDOT Qualified Products List (QPL). Component based paint systems shall be listed on the QPL in the applicable sections of Section 9-08. Performance based systems shall be listed on the current Northeast Protective Coatings Committee (NEPCOAT) Qualified Products List “A” as listed on the WSDOT QPL in Section 9-08.1(2)M. If the paint and related materials for the component based system is not listed in the current WSDOT QPL, a sample shall be submitted to the State Materials Laboratory in Tumwater for evaluation and acceptance in accordance with Section 9-08.

All paint coating components of the selected paint system shall be produced by the same manufacturer. The paint system selected shall be used throughout the entire structure.

Paint formulations to be used on faying surfaces shall be Class B coatings with a mean slip coefficient not less than 0.50. The slip coefficient shall be determined by testing in accordance with "Test Method to Determine the Slip Coefficient for Coatings Used in Bolted Joints" as adopted by the Research Council on Structural Connections.

6-07.3(9)B Paint Color

Each successive coat shall be a contrasting color to the previously applied coat. The color of the top coat shall be as specified in the Plans or Special Provisions and shall conform to Section 9-08.1(8).

6-07.3(9)C Mixing and Thinning Paint

The Contractor shall thoroughly mix paint in accordance with the manufacturer's written recommendations and by mechanical means to ensure a uniform and lump free composition. Paint shall not be mixed by means of air stream bubbling or boxing. Paint shall be mixed in the original containers and mixing shall continue until all pigment or metallic powder is in suspension. Care shall be taken to ensure that the solid material that has settled to the bottom of the container is thoroughly dispersed. After mixing, the Contractor shall inspect the paint for uniformity and to ensure that no unmixed pigment or lumps are present.

Catalysts, curing agents, hardeners, initiators, or dry metallic powders that are packaged separately may be added to the base paint in accordance with the paint manufacturer's written recommendations and only after the paint is thoroughly mixed to achieve a uniform mixture with all particles wetted. The Contractor shall then add the proper volume of curing agent to the correct volume of base and mix thoroughly. The mixture shall be used within the pot life specified by the manufacturer. Unused portions shall be discarded at the end of each work day. Accelerants are not permitted except as allowed by the Engineer.

The Contractor shall not add additional thinner at the application site except as allowed by the Engineer. The amount and type of thinner, if allowed, shall conform to the manufacturer's specifications. If recommended by the manufacturer and allowed by the Engineer, a measuring cup shall be used for the addition of thinner to any paint with graduations in ounces. No unmeasured addition of thinner to paint will be allowed. Any paint found to be thinned by unacceptable methods will be rejected.

When recommended by the manufacturer, the Contractor shall constantly agitate paint during application by use of paint pots equipped with mechanical agitators.

The Contractor shall strain all paint after mixing to remove undesirable matter, but without removing the pigment or metallic powder.

Paint shall be stored and mixed in a secure, contained location to eliminate the potential for spills into State waters and onto the ground and highway surfaces.

6-07.3(9)D Coating Thickness

Dry film thickness shall be measured in accordance with SSPC Paint Application Specification No. 2, Procedure for Determining Conformance to Dry Coating Thickness Requirements.

The minimum dry film thickness of the primer coat shall not be less than 2.5 mils.

The minimum dry film thickness of each coat (combination of intermediate and intermediate stripe, and top) shall be not less than 3.0 mils.

The dry film thickness of each coat shall not be thicker than the paint manufacturer's recommended maximum thickness.

The minimum wet film thickness of each coat shall be specified by the paint manufacturer to achieve the minimum dry film thickness.

Film thickness, wet and dry, will be measured by gages conforming to Section 6-07.3(8)A.

Wet measurements will be taken immediately after the paint is applied in accordance with ASTM D4414. Dry measurements will be taken after the coating is dry and hard in accordance with SSPC Paint Application Specification No. 2.

Each painter shall be equipped with wet film thickness gages and shall be responsible for performing frequent checks of the paint film thickness throughout application.

Coating thickness measurements may be made by the Engineer after the application of each coat and before the application of the succeeding coat. In addition, the Engineer may inspect for uniform and complete coverage and appearance. One hundred percent of all thickness measurements shall meet or exceed the minimum wet film thickness. In areas where wet film thickness measurements are impractical, dry film thickness measurements may be made. If a question arises about an individual coat's thickness or coverage, it may be verified by the use of a Tooke gage in accordance with ASTM D4138.

If the specified number of coats does not produce a combined dry film thickness of at least the sum of the thicknesses required per coat, if an individual coat does not meet the minimum thickness, or if visual inspection shows incomplete coverage, the coating system will be rejected and the Contractor shall discontinue painting and surface preparation operations and shall submit a Type 2 Working Drawing of the repair proposal. The repair proposal shall include documentation demonstrating the cause of the less-than-minimum thickness, along with physical test results, as necessary, and modifications to Work methods to prevent similar results. The Contractor shall not resume painting or surface preparation operations until receiving the Engineer's acceptance of the completed repair.

6-07.3(9)E Environmental Condition Requirements Prior to Application of Paint

Paint shall be applied only during periods when:

1. Air and steel temperatures are in accordance with the paint manufacturer's recommendations but in no case less than 35°F nor greater than 115°F.

2. Steel surface temperature is a minimum of 5°F above the dew point.
3. Steel surface is not wet.
4. Relative humidity is within the manufacturer's recommended range.
5. The anticipated ambient temperature will remain above 35°F or the manufacturer's minimum temperature, whichever is greater, during the paint drying and curing period.

Application will not be allowed if conditions are not favorable for proper application and performance of the paint.

Paint shall not be applied when weather conditions are unfavorable to proper curing. If a paint system manufacturer's recommendations allow for application of a paint under environmental conditions other than those specified, the Contractor shall submit a Type 2 Working Drawing consisting of a letter from the paint manufacturer specifying the environmental conditions under which the paint can be applied. Application of paint under environmental conditions other than those specified in this section will not be allowed without the Engineer's concurrence.

6-07.3(9)F Shop Surface Cleaning and Preparation

A roughened surface profile shall be provided by an abrasive blasting procedure as accepted by the Engineer. The profile shall be 1-mil minimum or in accordance with the paint manufacturer's recommendations, whichever is greater. The entire steel surface to be painted, including surfaces specified in Section 6-07.3(9)G to receive a mist coat of primer, shall be cleaned to a near white condition in accordance with SSPC-SP 10, Near-white Metal Blast Cleaning, and shall be in this condition immediately prior to paint application.

6-07.3(9)G Application of Shop Primer Coat

After receiving the Engineer's acceptance of the prepared surface, the primer shall be applied so as to produce a uniform, even coating that has fully bonded with the metal. Primer shall be applied with the spray nozzles and pressures recommended by the manufacturer of the paint system, so as to attain the film thicknesses specified. Repairs of the shop primer coat shall be prepared in accordance with the painting plan. Shop primer coat repair paint shall be selected from the approved component based or performance based paint system in accordance with Section 6-07.3(10)H.

Steel girder top flanges and soldier pile flanges to be embedded in concrete shall be prepared in accordance with Section 6-07.3(9)F and shall then receive a mist coat of the specified primer with a dry film thickness of 0.5 to 1.0 mils.

The Contractor shall provide access to the steel to permit inspection by the Engineer. The access shall not mar or damage any freshly painted surfaces.

High-strength field bolts shall not be painted before erection.

6-07.3(9)H Containment for Field Coating

The Contractor shall use a containment system in accordance with Section 6-07.3(10)A for surface preparation and prime coating of all uncoated areas remaining, including bolts, nuts, washers, and splice plates.

During painting operations of the intermediate, stripe and top coats the Contractor shall furnish, install, and maintain drip tarps below the areas to be painted to contain all spilled paint, buckets, brushes, and other deleterious material, and prevent such materials from reaching the environment below or adjacent to the structure being painted. Drip tarps shall be absorbent material and hung to minimize puddling. The Contractor shall evaluate the project-specific conditions to determine the specific type and extent of containment needed to control the paint emissions and shall submit a containment plan in accordance with Section 6-07.3(2).

6-07.3(9)I Application of Field Coatings

An on-site supervisor shall be present for each work shift at the bridge site.

Upon completion of erection Work, all uncoated or damaged areas remaining, including bolts, nuts, washers, and splice plates, shall be prepared in accordance with Section 6-07.3(9)F, followed by a field primer coat of a zinc-rich primer and final coats of paint selected from the approved component or performance based paint system in accordance with Section 6-07.3(10)H. The intermediate, intermediate stripe, and top coats shall be applied in accordance with the manufacturer's written recommendations.

Upon completion of erection Work, welds for steel column jackets may be prepared in accordance with SSPC-SP 15, Commercial Grade Power Tool Cleaning.

The minimum drying time between coats shall be as shown in the product data sheets, but not less than 12 hours. The Contractor shall determine whether the paint has cured sufficiently for proper application of succeeding coats.

The maximum time between intermediate and top coats shall be in accordance with the manufacturer's written recommendations. If the maximum time between coats is exceeded, all newly coated surfaces shall be prepared to SSPC-SP 7, Brush-off Blast Cleaning, and shall be repainted with the same paint that was cleaned, at no additional cost to the Contracting Agency.

Each coat shall be applied in a uniform layer, completely covering the preceding coat. The Contractor shall correct runs, sags, skips, or other deficiencies before application of succeeding coats. Such corrective work may require re-cleaning, application of additional paint, or other means as determined by the Engineer, at no additional cost to the Contracting Agency.

Dry film thickness measurements will be made in accordance with Section 6-07.3(9)D.

All paint damage that occurs shall be repaired in accordance with the manufacturer's written recommendations. On bare areas or areas of insufficient primer thickness, the repair shall include field-applied zinc-rich primer, and the final coats of the paint selected

from the approved component or performance based paint system in accordance with Section 6-07.3(10)H. On areas where the primer is at least equal to the minimum required dry film thickness, the repair shall include the application of the final two coats of the paint system. All paint repair operations shall be performed by the Contractor at no additional cost or time to the Contracting Agency.

6-07.3(10) Painting Existing Steel Structures

Painting existing steel structures includes providing containment, cleaning, preparing the surface, painting metal surfaces, and disposal of generated waste. Painting of existing steel structures shall be done in the following sequence:

1. Containment.
2. Bird guano, fungus, and vegetation removal.
3. Dry cleaning.
4. Surface preparation.
5. Treatment of pack rust and gaps.
6. Paint system application.

6-07.3(10)A Containment

The containment system shall be in accordance with SSPC Technology Guide No. 6, *Guide for Containing Surface Preparation Debris Generated During Paint Removal Operations* Class 1. The containment system shall fully enclose the steel to be painted and not allow any material to escape the containment system. The Contractor shall protect the surrounding environment from all debris or damage resulting from the Contractor's operations.

Except as otherwise specified in the Contract, the containment length shall not exceed the length of a span (defined as pier to pier). The containment system shall not cause any damage to the existing structure. Attachment devices shall not mark or otherwise damage the steel member to which they are attached. Field-welding of attachments to the existing structure will not be allowed. The Contractor shall not drill holes into the existing structure or through existing structural members except as shown in the Contractor's painting plan Working Drawing submittal.

Emissions shall be assessed by Visible Emission Observations (Method A) in SSPC Technology Update No. 7, Conducting Ambient Air, Soil, and Water Sampling of Surface Preparation and Paint Disturbance Activities, Section 6.2 and shall be limited to the Level A Acceptance Criteria Option Level 0 Emissions standard. If visible emissions occur or if failure to the containment system occurs or if signs of failure to the containment system are present, the Contractor shall stop work immediately. Work shall not resume until the failure has been corrected to the satisfaction of the Engineer.

The containment system shall not be removed until all cleaned and painted surfaces have been inspected and accepted by the Engineer.

Prior to beginning work each day, all containment systems shall be inspected by the Contractor to verify they are in place and functioning properly. Any necessary maintenance to restore full function shall be completed prior to beginning work.

6-07.3(10)B Bird Guano, Fungus, and Vegetation Removal

Bird guano and bird nesting materials shall be removed in the dry. Following dry removal, the Contractor shall apply a treatment solution in accordance with Section 9-08.5(1), followed by hand-scrubbing and rinsing with water in accordance with Section 9-08.5(3). The bird guano, bird nesting materials, and treatment solution shall be contained and collected.

Vegetation, soil, and other waste debris either intertwined with or coating the steel members included in the painting limits shall be contained, collected, removed, and disposed of in accordance with this section and Section 6-01.12. When steel bearing assemblies are included within the painting limits, the Contractor shall also contain, collect, remove, and dispose of all vegetation, soil, and debris on the associated pier caps.

The Contractor shall treat all areas of fungus growth and vegetative growth. The Contractor shall apply a treatment solution in accordance with Section 9-08.5(2) to the fungus areas for a period recommended by the solution manufacturer or as specified by the Engineer, but in no case less than 5 minutes. The fungus, vegetative growth, and treatment solution shall be contained and collected.

Bird guano, bird nesting materials, fungus, and vegetative growth shall be disposed of at a land disposal site accepted by the Engineer. The Contractor shall submit a Type 1 Working Drawing consisting of one copy of the disposal receipt, which shall include a description of the disposed material.

6-07.3(10)C Dry Cleaning

Dry cleaning shall include removal of accumulated dirt and debris on the surfaces to be painted. Collected dirt and debris shall be disposed of at a land disposal site accepted by the Engineer. The Contractor shall submit a Type 1 Working Drawing consisting of a copy of the disposal receipt, which shall include a description of the disposed material.

6-07.3(10)D Surface Preparation Prior to Overcoat Painting

The Contractor shall remove any visible oil, grease, and road tar in accordance with SSPC-SP 1, Solvent Cleaning.

Following any preparation by SSPC-SP1, all steel surfaces to be painted shall be prepared in accordance with SSPC-SP 7, Brush-Off Blast Cleaning. Surfaces inaccessible to brush-off blast shall be prepared in accordance with SSPC-SP 3, Power Tool Cleaning, as allowed by the Engineer.

Following brush-off blast cleaning, the Contractor shall perform spot abrasive blast cleaning in accordance with SSPC-SP 6, Commercial Blast Cleaning. Spot abrasive blast cleaning shall be performed in such a manner that the adjacent areas of work are protected from damage. Areas exhibiting coating failure down to the steel substrate,

those exhibiting visible corrosion, and those areas needing treatment of pack rust and gaps shall be prepared down to clean bare steel in accordance with SSPC-SP 6. Exposed steel areas that have an average exposed diameter of less than 1½ inches and no other similar area closer than 4 inches do not require spot abrasive blast cleaning or edge feathering unless required by the Engineer. The Contractor shall provide a sharp angular surface profile by an abrasive blasting procedure as accepted by the Engineer. The profile shall be 1 mil minimum or in accordance with the paint manufacturer's recommendations, whichever is greater. For small areas, as allowed by the Engineer, the Contractor may substitute cleaning in accordance with SSPC-SP 15, Commercial Grade Power Tool Cleaning. The prepared area shall extend at least 2 inches into adjacent tightly adhering, intact coating.

Following spot abrasive blast cleaning of exposed steel surfaces, edges of tightly adherent coating remaining shall be feathered so that the recoated surface has a smooth appearance. Immediately prior to painting, the Contractor shall clean all steel surfaces and staging areas with dry, oil-free compressed air conforming to ASTM D4285.

6-07.3(10)E Surface Preparation – Full Paint Removal

For structures where full removal of existing paint is specified, the Contractor shall remove any visible oil, grease, and road tar in accordance with SSPC-SP 1.

Following preparation by SSPC-SP 1, all steel surfaces to be painted, and any areas needing treatment of pack rust and gaps, shall be prepared in accordance with SSPC-SP 10, Near-White Metal Blast Cleaning. Surfaces inaccessible to Near-White Metal Blast Cleaning shall be prepared in accordance with SSPC-SP 11, Power Tool Cleaning to Bare Metal, as allowed by the Engineer.

6-07.3(10)F Collecting, Testing, and Disposal of Containment Waste

The sealed waste containers shall be labeled as required by State and Federal laws. All confined materials shall be collected and secured in sealed containers at the end of each shift or daily at a minimum to prevent the weight of the confined materials from causing failure to the containment system. The sealed waste containers shall be stored in accordance with Section 1-06.4, the painting plan, and the following requirements:

1. The containers shall be stored on an impermeable surface that accommodates sweeping or vacuuming.
2. Landside storage of the containers shall be at an elevation above the ordinary high water level (OHWL) elevation. The container storage area shall not be in a stormwater runoff course and shall not be in an area of standing water.
3. The container storage area shall be a fenced, secured site, separate from the storage facilities for paint materials and paint equipment.
4. The containers shall not be stored at the on-site landside storage site for longer than 90 calendar days.

All material collected by and removed from the containment system shall be taken to a landside staging area, provided by the Contractor, for further processing and storage prior to transporting for disposal. Handling and storage of material collected by and removed from the containment system shall conform to Section 1-06.4. Storage of containment waste materials shall be in a facility separate from the storage facilities used for paint materials and paint equipment.

Containment waste is defined as all paint chips and debris removed from the steel surface and all abrasive blast media, as contained by the containment system. After all waste from the containment system has been collected, the Contractor shall collect representative samples of the components that field screening indicates are lead-contaminated material. The Contractor shall collect at least one representative sample from each container. The Contractor may choose to collect a composite sample of each container, but the composite sample must consist of several collection points (a minimum of 3 random samples) that are representative of the entire contents of the container and representative of the characteristics of the type of waste in the container. In accordance with WAC 173–303-040, a representative sample means "a sample which can be expected to exhibit the average properties of the sample source."

The debris shall be tested for metals using the Toxicity Characteristics Leaching Procedure (TCLP) and EPA Methods 1311 and 6010. At a minimum, the materials should be analyzed for the Resource Conservation and Recovery Act (RCRA) 8 Metals (arsenic, barium, cadmium, chromium, lead, mercury, selenium, and silver). Pursuant to the Dangerous Waste (DW) Regulations Chapter 173-303-90(8)(c) WAC, "Any waste that contains contaminants which occur at concentrations at or above the DW threshold must be designated as DW." All material within each individual container or containment system that designates as DW shall be disposed of at a legally permitted Subtitle C Hazardous Waste Landfill. All material within each individual container or containment system that designate below the DW threshold, will be designated as "Solid Waste" and shall be disposed of at a legally permitted Subtitle D Landfill. Disposal shall be in accordance with WAC 173-303 for waste designated "Dangerous Waste" and pursuant to WAC 173-350 for waste designated as "Solid Waste".

The Contractor shall submit a Type 1 Working Drawing consisting of two copies of the transmittal documents or bill of lading listing the waste material shipped from the construction site to the waste disposal site. One copy of the shipment list shall show the signature of the Engineer and shall have the waste site operator's confirmation for receipt of the waste.

In the event that the containment wastes are designated as "Dangerous Wastes" or "Extremely Hazardous Waste" under WAC 173-303, the Contracting Agency will provide to the Contractor the appropriate EPA identification number.

Unless noted otherwise, a waste site will not be provided by the Contracting Agency for the disposal of excess materials and debris.

The Contractor shall submit a Type 1 Working Drawing of all TCLP results.

The Contractor shall submit a Type 1 Working Drawing consisting of waste disposal documentation within 15 working days of each disposal. This documentation shall include the quantity and type of waste disposed of with each disposal shipment.

6-07.3(10)G Treatment of Pack Rust and Gaps

Pack rust is defined as the condition where two or more pieces of steel fastened together by rivets or bolts have been pressed apart by crevice corrosion caused by the buildup of corrosion products at the interface of the steel pieces.

Pack rust forming a gap between steel surfaces of 1/16 to 1/4 inch shall be cleaned to a depth of at least one half of the gap width. The gaps shall be cleaned and prepared in accordance with Section 6-07.3(10)D or 6-07.3(10)E as specified in the Contract. When cleaned and prepared in accordance with Section 6-07.3(10)D, the cleaned gap shall be treated with rust penetrating sealer, prime coated, and then caulked. When cleaned and prepared in accordance with Section 6-07.3(10)E, the cleaned gap shall be primed and then treated with rust penetrating sealer, and then caulked. The caulking shall be applied to form a watertight seal along the top edge and the two sides of the steel pieces involved, using the rust penetrating sealer and caulk as accepted by the Engineer. The bottom edge or lowest edge of the steel pieces involved shall not be caulked.

The type of rust penetrating sealer and caulk used shall be compatible with the paint system used and shall be applied in accordance with the rust penetrating sealer and caulk manufacturer's instructions. Caulk shall be a single-component polyurethane sealant conforming to Section 9-08.7.

When caulking joints where only one steel piece edge is exposed, a fillet of caulk shall be formed that is not less than 1/8 inch or the width of the pack rust gap. The fillet is not required where there is no separation of the steel pieces due to pack rust.

At locations where gaps between steel surfaces exceed 1/4 inch after cleaning, preparing, sealing and priming, the Contractor shall then fill the gap with foam backer rod material as accepted by the Engineer. The foam backer rod material shall be of sufficient diameter to fill the crevice or gap. The Contractor shall apply caulk over the foam backer rod material to form a watertight seal.

Caulk and backer rod, if needed, shall be placed prior to applying the top coat.

6-07.3(10)H Paint System

The paint system applied to existing steel surfaces shall consist of the following five-coat system:

Option 1 (component based system):	
Primer Coat - Zinc-rich Moisture Cured Polyurethane	9-08.1(2)F
Primer Stripe Coat - Moisture Cured Polyurethane	9-08.1(2)F
Intermediate Coat - Moisture Cured Polyurethane	9-08.1(2)G
Intermediate Stripe Coat - Moisture Cured Polyurethane	9-08.1(2)G
Top Coat - Moisture Cured Polyurethane	9-08.1(2)H
Option 2 (performance based system):	
Primer Coat - Zinc-rich Epoxy	9-08.1(2)N
Primer Stripe Coat - Epoxy	9-08.1(2)N
Intermediate Coat - Epoxy	9-08.1(2)N
Intermediate Stripe Coat - Epoxy	9-08.1(2)N
Top Coat - Polyurethane	9-08.1(2)N

Paints and related materials shall be a product listed in the current WSDOT Qualified Products List (QPL). Component based paint systems shall be listed on the QPL in the applicable sections of Section 9-08. Performance based systems shall be listed on the current Northeast Protective Coatings Committee (NEPCOAT) Qualified Products List “B” as listed on the WSDOT QPL in Section 9-08.1(2)N. If the paint and related material for the component based system is not listed in the current WSDOT QPL, a sample shall be submitted to the State Materials Laboratory in Tumwater for evaluation and acceptance in accordance with Section 9-08.

All paint coating components of the selected paint system shall be produced by the same manufacturer. Only one paint system from a singular manufacturer shall be used throughout the project unless otherwise allowed in writing by the Engineer. The Contractor shall not change to a different paint system once the initial paint system has been applied to any portion of the bridge unless otherwise allowed in writing by the Engineer.

6-07.3(10)I Paint Color

Each of the five coats shall be a contrasting color to the previously applied full coat. The color of the top coat shall be as specified in the Plans or Special Provisions and shall conform to Section 9-08.1(8). Tinting shall occur at the factory at the time of manufacture and placement in containers, prior to initial shipment. Application site tinting will not be allowed except as otherwise allowed by the Engineer.

6-07.3(10)J Mixing and Thinning Paint

Mixing and thinning paint shall be in accordance with Section 6-07.3(9)C.

6-07.3(10)K Coating Thickness

Coating thickness shall be in accordance with Section 6-07.3(9)D except the minimum dry film thickness of each coat (combination of primer and primer stripe, combination of intermediate and intermediate stripe, and top) shall not be less than 3.0 mils.

6-07.3(10)L Environmental Condition Requirements Prior to Application of Paint

Environmental conditions shall be in accordance with Section 6-07.3(9)E.

6-07.3(10)M Steel Surface Condition Requirements Prior to Application of Paint

The steel surface to be painted shall be free of moisture, dirt, dust, grease, oil, loose, peeling or, chalky paint, abrupt paint edges, salts, rust, mill scale, and other foreign matter and substances that would prevent the bond of the succeeding application. The Contractor shall protect freshly painted surfaces from contamination by abrasives, dust, or foreign materials from any other source. The Contractor shall prepare contaminated surfaces to the satisfaction of the Engineer before applying additional paint.

Prepared surfaces shall be kept clean at all times, before painting and between coats.

Edges of existing paint shall be feathered in accordance with SSPC-PA 1, Shop, Field, and Maintenance Coating of Metals, Note 15.20.

6-07.3(10)N Field Coating Application Methods

The Contractor shall apply paint materials in accordance with manufacturer's recommendations by air or airless spray, brush, roller, or any combination of these methods unless otherwise specified. Spray application of the paint shall be accomplished with spray nozzles and at pressures as recommended by the paint manufacturer to ensure application of paint at the specified film thickness. The Contractor may apply stripe coat paint using spray or brush but shall follow spray application using a brush to ensure complete coverage around structural geometric irregularities and to push the paint into gaps between existing steel surfaces and around rivets and bolts. All application techniques shall conform to Section 7, SSPC-PA 1. Painters using brushes shall work from pails containing a maximum of 2 gallons of paint. This is intended to minimize the impact of any spill.

6-07.3(10)O Applying Field Coatings

An on-site supervisor shall be present for each work shift at the bridge site.

The first coat shall be a primer coat applied to steel surfaces cleaned to bare metal. The second coat shall be a primer stripe coat applied to all steel surfaces cleaned to bare metal and defined to receive a stripe coat. The third coat shall be an intermediate coat. The fourth coat shall be an intermediate stripe coat applied to steel surfaces defined to receive a stripe coat. The fifth coat shall be the top coat. The intermediate (third) and top (fifth) coats shall encapsulate the entire surface area of the structure members specified to be painted.

Prior to the application of paint, the Contractor shall clean the bridge deck surface for the purpose of dust control.

During painting operations the Contractor shall furnish, install, and maintain drip tarps below the areas to be painted to contain all spilled paint, buckets, brushes, and other deleterious material, and prevent such materials from reaching the environment below or adjacent to the structure being painted. Drip tarps shall be absorbent material and hung to minimize puddling.

In addition to the requirements of the Specifications, paint application shall conform to:

1. The best practices of the trade.
2. The written recommendations of the paint manufacturer.
3. All applicable portions of the SSPC-PA 1.

No primer paint shall be applied to any surface until the surface has been inspected and accepted by the Engineer. Any area to which primer paint has been applied without the Engineer's inspection and acceptance will be considered improperly cleaned. The unauthorized application shall be completely removed and the entire area recleaned to the satisfaction of the Engineer. After the area has been recleaned, inspected, and approved, the Contractor may again initiate the painting sequence. No additional compensation or extension of time in accordance with Section 1-08.8 will be allowed for the removal of any unauthorized paint application and recleaning of the underlying surface.

All steel surfaces cleaned to bare metal by abrasive blast cleaning shall receive the primer coat within the same working day as the cleaning to bare metal and before any rust begins to form. Each successive coat shall be applied as soon as possible over the previous coat, accounting for drying time of the preceding coat, weather, atmospheric temperature and other environmental conditions, and the paint manufacturer's recommendations. Each coat shall be dry before recoating and shall be sufficiently cured so that succeeding or additional coats may be applied without causing damage to the previous coat. Recoat times shall be as shown in the paint manufacturer's recommendations, but not less than 12 hours. Revision of recoat times to other than recommended by the paint manufacturer requires the concurrence of the Engineer. If the maximum time between coats is exceeded, all affected areas shall be prepared to SSPC-SP 7, Brush-off Blast Cleaning,

and recoated with the Contract-specified system at no additional expense or time to the Contracting Agency.

Each coat shall be applied in a uniform layer, completely covering the preceding coat. The Contractor shall correct runs, sags, skips, or other deficiencies before application of succeeding coats. Such corrective work may require recleaning, application of additional paint, or other means as determined by the Engineer, at no additional cost to the Contracting Agency.

If fresh paint is damaged by the elements, the Contractor shall replace or repair the paint to the satisfaction of the Engineer at no additional cost to the Contracting Agency.

After applying the primer or intermediate coats, the Contractor shall apply a primer or intermediate stripe coat, respectively, on all edges, corners, seams, crevices, interior angles, junction of joint members, rivet or bolt heads, nuts and threads, weld lines, and any similar surface irregularities. The coverage of each stripe coat shall extend at least 1 inch beyond the irregular surface. The stripe coat shall be of sufficient thickness to completely hide the surface being covered and shall be followed as soon as feasible by the application of the subsequent coat to its specified thickness.

The Contractor shall correct paint deficiencies before application of succeeding coats. Such corrective work may require recleaning, application of additional paint, or other corrective measures in accordance with the paint manufacturer's recommendations and as specified by the Engineer. Such corrective work shall be completed at no additional expense or time to the Contracting Agency.

Each application of primer, primer stripe, intermediate, intermediate stripe, and top coat shall be considered as separately applied coats. The Contractor shall not use a preceding or subsequent coat to remedy a deficiency in another coat. The Contractor shall apply the top coat to at least the minimum specified top coat thickness, to provide a uniform appearance and consistent finish coverage.

If roadway or sidewalk planks lie so close to the metal that they prevent proper cleaning and painting, the Contractor shall remove or cut the planks to provide at least a 1-inch clearance. Any plank removal or cutting shall be done with the concurrence of the Engineer. The Contractor shall replace all planks after painting. If removal breaks or damages the planks and makes them unfit for reuse, the Contractor shall replace them at no expense to the Contracting Agency.

6-07.3(10)P Field Coating Repair

Paint repair shall conform to SSPC-PA 1. Repair areas shall be cleaned of all damaged paint and the system reapplied using all coats typical to the paint system and shall meet the minimum coating thickness. Each coat shall be thoroughly dry before applying subsequent coats. Paint repair shall be in accordance with the paint manufacturer's recommendations and as accepted by the Engineer.

6-07.3(10)Q Cleanup

Cleaning of equipment shall not be done in State waters nor shall resultant cleaning runoff be allowed to enter State waters. No paint cans, lids, brushes, or other debris shall be allowed to enter State waters. Solvents, paints, paint sludge, cans, buckets, rags, brushes, and other waste associated with this project shall be collected and disposed of off-site. Paint products, petroleum products, or other deleterious material shall not be wasted into, or otherwise enter, State waters as a result of project activities.

Cleanup of the project site shall conform to Sections 1-04.11 and 6-01.12

6-07.3(11) Painting or Powder Coating of Galvanized Surfaces

Galvanized surfaces specified to be coated after galvanizing shall receive either paint in accordance with Section 6-07.3(11)A or powder coating in accordance with Section 6-07.3(11)B. The color of the finish coat shall be as specified in the Special Provisions.

6-07.3(11)A Painting of Galvanized Surfaces

All galvanized surfaces receiving paint shall be prepared for painting in accordance with the ASTM D6386. The method of preparation shall be brush-off in accordance with SSPC-SP16 Brush-Off Blast Cleaning of Coated and Uncoated Galvanized Steel, Stainless Steels, and Non-Ferrous Metals or as otherwise allowed by the Engineer. The Contractor shall not begin painting until receiving the Engineer's acceptance of the prepared galvanized surface. For galvanized bolts used for replacement of deteriorated existing rivets, the Contractor, with the concurrence of the Engineer and after successful demonstration testing, may prepare galvanized surfaces in accordance with SSPC-SP1 followed by SSPC-SP2, Hand Tool Cleaning or SSPC-SP3, Power Tool Cleaning. The demonstration testing shall include adhesion testing of the first coat of paint over galvanized bolts, nuts, and washers or a representative galvanized surface. Adhesion testing shall be performed in accordance with ASTM D4541 for 600 psi minimum adhesion. A minimum of 3 successful tests shall be performed on the galvanized surface prepared and painted using the same methods and materials to be used on the galvanized bolts, nuts and washers in the field.

6-07.3(11)A1 Environmental Conditions

Steel surfaces shall be:

- Greater than 35°F, and
- Less than 115°F.

or in accordance with the manufacturer's recommendations, whichever is more stringent.

6-07.3(11)A2 Paint Coat Materials

The Contractor shall paint the dry surface as follows:

1. The first coat over a galvanized surface shall be an epoxy polyamide conforming to Section 9-08.1(2)E. In the case of galvanized bolts used for replacement of deteriorated existing rivets and for small surface areas less than or equal to one square foot, an intermediate moisture cured polyurethane conforming to Section 9-08.1(2)G may be used as a first coat. In both cases the first coat shall be compatible with galvanizing and as recommended by the top coat manufacturer.
2. The second coat shall be a top coat moisture cured aliphatic polyurethane conforming to Section 9-08.1(2)H or a top coat polyurethane conforming to Section 6-07.3(10)H Option 2 NEPCOAT performance based paint specification compatible with the first coat as recommended by the manufacturer.

Each coat shall be dry before the next coat is applied. All coats applied in the shop shall be dried hard before shipment.

6-07.3(11)B Powder Coating of Galvanized Surfaces

Powder coating of galvanized surfaces shall consist of the following coats:

1. The first coat shall be an epoxy powder primer coat conforming to Section 9-08.2.
2. The second coat shall be a polyester finish coat conforming to Section 9-08.2.

6-07.3(11)B1 Submittals

The Contractor shall submit Type 2 Working Drawings consisting of the following information:

1. The name, location, and contact information (mail address, phone, and email) for the firm performing the powder coating operation.
2. Quality control (QC) programs established and followed by the firm performing the powder coating operation. Forms to document inspection and testing of coatings as part of the QC program shall be included in the submittal.
3. Project-specific powder coating plan, including identification of the powder coating materials used (and manufacturer), and specific cleaning, surface preparation, preheating, powder coating application, curing, shop and field coating repair, handling, and storage processes to be taken for the assemblies being coated for this project.
4. Product data and MSDS sheets for all powder coating and coating repair materials.

6-07.3(11)B2 Galvanizing

Prior to the galvanizing operation, the Contractor shall identify to the galvanizer the specific assemblies and surfaces receiving the powder coating after galvanizing, to ensure that the galvanizing method used on these assemblies is compatible with subsequent application of a powder coating system. Specifically, such assemblies shall neither be water-quenched nor receive a chromate conversion coating as part of the galvanizing operation.

6-07.3(11)B3 Galvanized Surface Cleaning and Preparation

Galvanized surfaces receiving the powder coating shall be cleaned and prepared for coating in accordance with ASTM D6386, and the project-specific powder coating plan.

Assemblies conforming to the ASTM D7803 definition for newly galvanized steel shall receive surface smoothing and surface cleaning in accordance with ASTM D7803, Section 5, and surface preparation in accordance with ASTM D7803, Section 5.1.3.

Assemblies conforming to the ASTM D7803 definition for partially weathered galvanized steel shall be checked and prepared in accordance with ASTM D7803, Section 6, before then receiving surface smoothing and surface cleaning in accordance with ASTM D7803, Section 5, and surface preparation in accordance with ASTM D7803, Section 5.1.3.

Assemblies conforming to the ASTM D7803 definition for weathered galvanized steel shall be prepared in accordance with ASTM D7803, Section 7 before then receiving surface smoothing and surface cleaning in accordance with ASTM D7803, Section 5, and surface preparation in accordance with ASTM D7803, Section 5.3 except as follows:

1. Ferrous metal abrasives are prohibited as a blast media for surface preparation.
2. Surface preparation shall be accomplished using dry abrasive blasting through a blast nozzle with compressed air. Abrasive blasting with a centrifugal wheel is prohibited.

The Contractor shall notify the Engineer of all surface cleaning and preparation activities and shall provide the Engineer opportunity to perform quality assurance inspection, in accordance with Section 1-05.6, at the completion of surface cleaning and preparation activities prior to beginning powder coating application.

6-07.3(11)B4 Powder Coating Application and Curing

After surface preparation, the two-component powder coating shall be applied in accordance with the powder coating manufacturer's recommendations, the project-specific powder coating plan, and as follows:

1. Preheat. The preheat shall be sufficient to prevent pinholes from forming in the finished coating system.
2. Apply the epoxy primer coat, followed by a partial cure.
3. Apply the polyester finish coat, followed by the finish cure.

6-07.3(11)B5 Testing

The firm performing the powder coating operation shall conduct, or make arrangements for, QC testing on all assemblies receiving powder coating for this project, in accordance with the powder coating firm's QC program as documented in item 2 of the Submittal Subsection above. Testing may be performed on coated surfaces of production fabricated items, or on a representative test panel coated alongside the production fabricated items being coated. There shall be a minimum of one set of tests representing each cycle of production fabricated items coated and cured. Additional tests shall be performed at the request of the Engineer. Repair of damaged coatings on production fabricated items shall be the responsibility of the firm applying the powder coating, and shall be in accordance with the project-specific powder coating plan. At a minimum, the QC testing shall test for the following requirements:

1. Visual inspection for the presence of coating holidays and other unacceptable surface imperfections.
2. Coating thickness measurement in accordance with Section 6-07.3(5). The minimum thickness of the epoxy primer coating and polyester finish coating shall be 3 mils each.
3. Hardness testing in accordance with ASTM D3363, with the finish coat providing a minimum hardness value of H.
4. Adhesion testing in accordance with ASTM D4541 for 600 psi minimum adhesion for the complete two-component coating system.
5. Powder Coating Institute (PCI) #8 recommended procedure for solvent cure test.

The results of the QC testing shall be documented in a QC report and submitted as a Type 2 Working Drawing.

The Engineer shall be provided notice and access to all assemblies at the powder coating facility for the purposes of Contracting Agency acceptance inspection, including notice and access to witness all hardness and adhesion testing performed by the firm conducting the QC testing, in accordance with Section 1-05.6.

Assemblies not meeting the above requirements will be subject to rejection by the Engineer. Rejected assemblies shall be repaired or recoated by the Contractor, at no additional expense to the Contracting Agency, in accordance with the powder coating manufacturer's recommendation as detailed in the project-specific powder coating plan, until the assemblies satisfy the acceptance testing requirements.

Assemblies shall not be shipped from the powder coating firm's facility to the project site until the Contractor receives the Engineer's acceptance of the QC Report and assembly inspection performed by the Engineer.

6-07.3(11)B6 Coating Protection for Shipping, Storage, and Field Erection

After curing and acceptance, the Contractor shall protect the coated assemblies with multiple layers of bubble wrap or other protective wrapping materials specified in the project-specific powder coating plan.

During storage and shipping, each assembly shall be separated from other assemblies by expanded polystyrene spacers and other spacing materials specified in the project-specific powder coating plan.

After erection, all coating damage due to the Contractor's shipping, storage, handling, and erection operations shall be repaired by the Contractor in accordance with the project-specific powder coating plan. The Contractor shall provide the Engineer access to all locations of all powder-coated members for verification of coating conditions prior to and following all coating repairs.

6-07.3(12) Painting Ferry Terminal Structures

Painting of ferry terminal structures shall be in accordance with Section 6-07.3 as supplemented below.

6-07.3(12)A Painting New Steel Ferry Terminal Structures

Painting of new steel Structures shall be in accordance with Section 6-07.3(9) except that all coatings (primer, intermediate, intermediate stripe, and top) shall be applied in the shop with the following exceptions:

1. Steel surfaces to be field welded.
2. Steel surfaces to be greased.
3. The length of piles designated in the Plans not requiring painting.

The minimum drying time between coats shall be as shown in the product data sheets, but not less than 12 hours. The Contractor shall determine whether the paint has cured sufficiently for proper application of succeeding coats.

6-07.3(12)A1 Paint Systems

Paint systems for Structural Steel, which includes vehicle transfer spans and towers, pedestrian overhead loading structures and towers, upland structural steel and other elements as designated in the Special Provisions shall be as specified in Section 6-07.3(9)A.

Paint systems for Piling, Landing Aids and Life Ladders shall be as specified in the Special Provisions.

6-07.3(12)A2 Paint Color

Paint colors shall be as specified in the Special Provisions.

6-07.3(12)A3 Coating Thickness

Coating thicknesses shall be as specified in the Special Provisions.

6-07.3(12)A4 Application of Field Coatings

An on-site supervisor shall be present for each work shift at the project site.

Upon completion of erection Work, all uncoated or damaged areas remaining, including bolts, nuts, washers, splice plates, and field welds shall be prepared in accordance with SSPC-SP 1, Solvent Cleaning, followed by SSPC-SP 11, Power Tool Cleaning to Bare Metal. Surface preparation shall be measured according to SSPC-VIS 3. SSPC-SP 11 shall be performed for a minimum distance of 1 inch from the uncoated or damaged area. In addition, intact shop-applied coating surrounding the area shall be abraded or sanded for a distance of 6 inches out from the properly prepared clean/bare metal areas to provide adequate roughness for application of field coatings. All sanding dust and contamination shall be removed prior to application of field coatings.

Field applied paint for Structural Steel shall conform to Section 6-07.3(10)H, as applicable. Field applied paint for Piling, Landing Aids and Life Ladders shall be as specified in the Special Provisions.

For areas above the tidal zone, the minimum drying time between coats shall be as shown in the product data sheets, but not less than 12 hours. For areas within the tidal zone, the minimum drying time between coats shall be as recommended by the paint system manufacturer. The Contractor shall determine whether the paint has cured sufficiently for proper application of succeeding coats.

The maximum time between intermediate and top coats shall be in accordance with the manufacturer's written recommendations. If the maximum time between coats is exceeded, all newly coated surfaces shall be prepared to SSPC-SP 3, Power Tool Cleaning, and shall be repainted with the same paint that was cleaned, at no additional cost to the Contracting Agency.

Each coat shall be applied in a uniform layer, completely covering the preceding coat. The Contractor shall correct runs, sags, skips, or other deficiencies before application of succeeding coats. Such corrective work may require re-cleaning, application of additional paint, or other means as determined by the Engineer, at no additional cost to the Contracting Agency.

Surface preparation for underwater locations shall consist of removing all dirt, oil, grease, loose paint, loose rust, and marine growth from the area that is to be repaired. The sound paint surrounding the damaged area shall be roughened to meet the requirements of the manufacturer. Paint for underwater applications shall be as specified in the Special Provisions and shall be applied in accordance with the manufacturer's recommendations.

6-07.3(12)B Painting Existing Steel Ferry Terminal Structures

Painting of existing steel structures shall be in accordance with Section 6-07.3(10) as supplemented by the following.

6-07.3(12)B1 Containment

Containment for full removal shall be in accordance with Section 6-07.3(10)A. Containment for overcoat systems shall be in accordance with all applicable Permits as required in the Special Provisions.

Prior to cleaning the Contractor shall enclose all exposed electrical and mechanical equipment to seal out dust, water, and paint. Non-metallic surfaces shall not be abrasive blasted or painted. Unless otherwise specified, the following metallic surfaces shall not be painted and shall be protected from abrasive blasting and painting:

1. Galvanized and stainless steel surfaces not previously painted,
2. Non-skid surfaces,
3. Unpainted intentionally greased surfaces,
4. Equipment labels, identification plates, tags, etc.,
5. Fire and emergency containers or boxes,
6. Mechanical hardware such as hoist sheaves, hydraulic cylinders, gear boxes, wire rope, etc.

The Contractor shall submit a Type 2 Working Drawing consisting of materials and equipment used to shield components specified to not be cleaned and painted.

The Contractor shall shut off the power prior to working around electrical equipment. The Contractor shall follow the lock-out/tag-out safety provisions of the WAC 296-803 and all other applicable safety standards.

6-07.3(12)B2 Surface Preparation

For applications above high water and within the tidal zone, surface preparation for overcoat painting shall be in accordance with SSPC-SP 1, Solvent Cleaning, followed by SSPC-SP 3, Power Tool Cleaning. Use of wire brushes is not allowed. After SP 3 cleaning has been completed all surfaces exhibiting coating failure down to the steel substrate, and those exhibiting visible corrosion, shall be prepared down to clean bare steel in accordance with SSPC-SP 15, Commercial Grade Power Tool Cleaning. Surface preparation shall be measured according to SSPC-VIS 3. SSPC-SP 15 shall be performed for a minimum distance of 1 inch from the area exhibiting failure or visible corrosion. In addition, intact shop-applied coating surrounding the repair area shall be abraded or sanded for a distance of 6 inches out from the properly prepared clean/bare metal areas to provide adequate roughness for application of repair coatings. All sanding dust and contamination shall be removed prior to application of repair coatings. Surface preparation for full paint removal shall be in accordance with Section 6-07.3(10)E except SSPC-SP 11 will be permitted as detailed in the Contractor's painting plan and as allowed by the Engineer.

Surface preparation for underwater locations shall consist of removing all dirt, oil, grease, loose paint, loose rust, and marine growth from the area that is to be repaired. The

sound paint surrounding the damaged area shall be roughened as required by the coating manufacturer.

Removed marine growth may be released to state waters provided the marine growth is not mixed with contaminants (paint, oil, rust, etc.) and it shall not accumulate on the sea bed. All marine growth containing contaminants shall be collected for proper disposal.

Surface preparation for the underside of bridge decks (consisting of either a steel grid system of main bars or tees and a light gauge metal form, in-filled with concrete or a corrugated light gauge metal form, infilled with concrete) shall be in accordance with SSPC-SP 2, Hand Tool Cleaning or SSPC-SP 3, Power Tool Cleaning with the intent of not causing further damage to the light gauge metal form. Following removal of any pack rust and corroded sections from the underside of the bridge deck, cleaning and flushing to remove salts and prior to applying the primer coat, the Contractor shall seal the entire underside of the deck system with rust-penetrating sealer. Damage to galvanized metal forms and/or grids shall be repaired in accordance with ASTM A 780, with the preferred method of repair using paints containing zinc dust.

6-07.3(12)B3 Paint Systems

Paint systems for Structural Steel, which includes vehicle transfer spans and towers, pedestrian overhead loading structures and towers, upland structural steel and other elements as designated in the Special Provisions shall be as specified in Section 6-07.3(10)H.

Paint systems for Piling, Landing Aids, Life Ladders, underside of vehicle transfer span bridge decks, non-skid surface treated areas, and anti-graffiti coatings shall be as specified in the Special Provisions.

6-07.3(12)B4 Paint Color

Paint colors shall be as specified in the Special Provisions.

6-07.3(12)B5 Coating Thickness

Coating thicknesses shall be as specified in the Special Provisions.

6-07.3(12)B6 Application of Field Coatings

Application of field coatings shall be in accordance with Section 6-07.3(10)O and Section 6-07.3(12)A4 except for the following:

1. All coatings applied in the field shall be applied using a brush or roller. Spray application methods may be used if allowed by the Engineer.
2. Applied coatings shall not be immersed until the coating has been cured as required by the coating manufacturer.
3. Non-skid surface treatment products shall be applied in accordance with the manufacturer's recommendations.
4. Anti-graffiti coatings shall be applied in one coat following application of the top coat, where specified in the Plans.

6-07.3(13) Painting Timber Structures

Timber structures shall be painted as specified in the Special Provisions.

6-07.3(14) Metallic Coatings

6-07.3(14)A General Requirements

This specification covers the requirements for thermal spray metallic coatings, with and without additional paint coats, as a means to prevent corrosion.

The coating system consists of surface preparation by wash cleaning and abrasive blast cleaning, thermal spray application of a metallic coating using a material made specifically for that purpose, and, when specified, shop primer coat or shop primer coat plus top coat in accordance with Section 6-07.3(11)A. The system also includes inspection and acceptance requirements.

6-07.3(14)B Reference Standards

SSPC-SP 10/NACE No. 2	Near-White Blast Cleaning
SSPC CS 23.00	Specification for the Application of Thermal Spray Coatings (Metallizing) of Aluminum, Zinc, and Their Alloys and Composites for the Corrosion Protection of Steel
ASTM C633	Standard Test Method for Adhesion or Cohesion Strengths of Thermal Spray Coatings
ASTM D4417	Standard Test Methods for Field Measurement of Surface Profile of Blast-Cleaned Steel
ASTM D6386	Standard Practice for Preparation of Zinc (Hot-Dip Galvanized) Coated Iron and Steel Product and Hardware Surfaces for Painting
ASTM D4541	Standard Test Method for Pull-Off Strength of Coatings Using Portable Adhesion Testers
ANSI/AWS C2.18	Guide for the Protection of Steel with Thermal Sprayed Coatings of Aluminum, Zinc and their Alloys and Composites

6-07.3(14)C Quality Assurance

A representative sample of each lot of the coating material used shall be submitted to the Engineer for analysis prior to use. Zinc shall have a minimum purity of 99.9 percent. Zinc Aluminum 85/15 wire shall be 14 to 16 percent maximum aluminum.

The thermal sprayed coating shall have a uniform appearance. The coating shall not contain any blisters, cracks, chips or loosely adhering particles, oil or other surface contaminants, nodules, or pits exposing the substrate.

The thermal spray coating shall adhere to the substrate with a minimum bond of 700 psi. The Contractor's QA program shall include thermal spray coating bond testing.

The Engineer may cut through the coating with a knife or chisel. If upon doing so, any part of the coating lifts away from the base metal ¼ inch or more ahead of the cutting blade without cutting the metal, then the bond is considered not effective and is rejected.

Coated areas which have been rejected or damaged in the inspection procedure described shall have the defective sections blast cleaned to remove all of the thermal sprayed coating and shall then be recoated. Before resubmittal and inspection, those sections where coating has not reached the required thickness shall be sprayed with additional metal until that thickness is achieved.

6-07.3(14)D Submittals

The Contractor shall submit to the Engineer, prior to abrasive blast cleaning, a 12 inch square steel plate, of the same material and approximate thickness of the steel to be coated, blasted clean in accordance with Section 6-07.3(14)E. The sample plate will be checked for specified angular surface pattern, the abrasive grit size and type used, and the procedure used. This plate shall be used as the visual standard to determine the acceptability of the cleaned surface. In the event the Contractor's cleaning operation is inferior to the sample plate, the Contractor shall be required to correct the cleaning operation to do a job comparable to the specimen submitted.

At the same time as submitting the abrasive blast cleaned steel plate sample, the Contractor shall submit to the Engineer, a second 12 inch square steel plate of the same material and thickness, cleaned and thermal spray coated in accordance with the same processes and with the same equipment as intended for use in applying the thermal spray coatings. The Engineer may request additional cleaned and thermal spray coated samples to be produced and submitted coincident with thermal spray coating of the items specified in the Plans to receive thermal spray coatings.

6-07.3(14)E Surface Preparation

Surface irregularities (e.g., sharp edges and/or carburized edges, cracks, delaminations, pits, etc.) interfering with the application of the coating shall be removed or repaired, prior to wash cleaning. Thermal cut edges shall be ground to reduce hardness to attain the surface profile required from abrasive blast cleaning.

All dirt, oil, scaling, etc. shall be removed prior to blast cleaning. All surfaces shall be wash cleaned with either clean water at 8000 psi or water and detergent at 2000 psi with two rinses with clean water.

The surface shall be abrasive blast cleaned to near white metal (SSPC-SP 10). The surface profile shall be measured using a surface profile comparator, replica tape, or other method suitable for the abrasive being used in accordance with ASTM D4417.

Where zinc coatings up to and including 0.009 inch thick are to be applied, one of the following abrasive grits shall be used with pressure blast equipment to produce a 3.0 mils AA anchor tooth pattern:

1. Aluminum oxide or silicon carbide mesh size: SAE G-25 to SAE G-40
2. Hardened steel grit mesh size: SAE G-25 to SAE G-40

3. Garnet, flint, or crushed nickel or black beauty coal slag mesh size: SAE G-25 to SAE G-50

Where zinc coatings greater than 0.010 inch thick are to be applied, one of the following abrasive grits shall be used with pressure blast equipment to produce a 5.0 mils AA anchor tooth pattern:

1. Aluminum oxide or silicon carbide mesh size: SAE G-18 to SAE G-25
2. Hardened steel grit mesh size: SAE G-18 to SAE G-25
3. Garnet, flint, or crushed nickel or black beauty coal slag mesh size: SAE G-18 to SAE G-25

The pressure of the blast nozzle, as measured with a needle probe gauge, with pressure type blasting equipment shall be as follows:

1. With aluminum oxide, silicon carbide, flint, or slag - 50 psi minimum and 60 psi maximum.
2. With garnet or steel grit - 75 psi minimum.

The pressure at the blast nozzle, with siphon blasting (suction blasting), shall be as follows:

1. With aluminum oxide, silicon carbide, flint, or slag - 75 psi maximum.
2. With garnet or steel grit - 90 psi maximum.

The abrasive blast stream shall be directed onto the substrate surface at a spray angle of 75 to 90 degrees, and moved side to side. The nozzle to substrate distance shall be 4 to 12 inches.

6-07.3(14)F Application of Metallic Coating

No surface shall be sprayed which shows any sign of condensed moisture or which does not comply with Section 6-07.3(14)E. If rust bloom occurs within the holding time between abrasive blast cleaning and thermal spraying, the surface shall be reblasted at a blast angle as close to perpendicular to the surface as possible to achieve a 2.0 to 4.0 mil anchor tooth pattern. Thermal spraying shall not take place when the relative humidity is 90 percent or greater, when the steel temperature is less than 5F above the dew point, or when the air or steel temperature is less than 40F.

Clean, dry air shall be used with not less than 50 psi air pressure at the air regulator. Not more than 50 feet of ⅜ inch. ID hose shall be used between the air regulator and the metallizing gun. The metallizing gun shall be started and adjusted with the spray directed away from the work. During the spraying operation and depending upon the equipment being used, the gun shall be held as close to perpendicular as possible to the surface from 5 to 8 inches from the surface of the work.

Manual spraying shall be done in a block pattern, typically 2 feet by 2 feet square. The sprayed metal shall overlap on each pass to ensure uniform coverage. The specified

thickness of the coating shall be applied in multiple layers. In no case are fewer than two passes of thermal spraying, overlapping at right angles, acceptable.

At least one single layer of coating shall be applied within 4 hours of blasting and the surface shall be completely coated to the specified thickness within 8 hours of blasting.

The minimum coating thickness shall be 6 mils unless otherwise shown in the Plans.

6-07.3(14)G Applications of Shop Coats and Field Coats

The surface shall be wiped clean with solvent immediately before applying the wash primer. The wash primer shall have a low viscosity appropriate for absorption into the thermal spray coating, and shall be applied within 8 hours after completion of thermal spraying or before oxidation occurs. The dry film thickness of the wash primer shall not exceed 0.5 mils or be less than 0.3 mils. It shall be applied using an appropriate spray gun except in those areas where brush or roller application is necessary. The subsequent shop primer or field coats shall be applied no less than one-half hour after a wash primer.

The shop primer coat, when specified, shall be applied in accordance with Section 6-07.3(11)A and the paint manufacturer's recommendations.

All field coats, when specified, shall be applied in accordance with Section 6-07.3(11)A and the paint manufacturer's recommendations. The color of the top coat shall conform to Section 6-03.3(30) as supplemented in these Special Provisions.

6-07.4 Measurement

Sealing and caulking pack rust will be measured by the linear foot along the edge of the steel connection interface sealed and caulked.

Spot abrasive blast cleaning of steel surfaces in accordance with Section 6-07.3(10)D will be measured by the square foot of surface area to be cleaned to bare metal as specified by the Engineer.

6-07.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Cleaning and Painting - _____", lump sum.

The lump sum Contract price for "Cleaning and Painting – _____" shall be full pay for the Work as specified, including developing all submittals; arranging for and accommodating contact and on-site attendance by the paint manufacturer's technical representative; furnishing and placing all necessary staging and rigging; furnishing, operating, and mooring barges; furnishing and operating fixed and movable work platforms; accommodating Contracting Agency inspection access; conducting the Contractor's quality control inspection program; providing material, labor, tools, and equipment; furnishing containers for containment waste, collecting and storing containment waste; collecting, storing, testing, and disposing of all containment waste not conforming to the definition in Section 6-07.3(10)F;

performing all cleaning and preparation of surfaces to be painted, including removal of debris on pier caps supporting steel members and bearings included in the painting limits; cleaning and preparing areas needing treatment of pack rust and gaps; applying all coats of paint; correcting coating deficiencies; completing coating repairs; and completing project site cleanup.

When a weather station is specified, all costs in connection with furnishing, installing, operating, and removing the weather station, including furnishing mounting hardware and repeaters, accessories and wireless display console units, processing and submitting daily weather data reports, maintenance and upkeep, shall be included in the lump sum Contract price for "Cleaning And Painting – _____".

Progress payments for "Cleaning and Painting – _____" will be made on a monthly basis and will be based on the percentage of the total estimated area satisfactorily cleaned and coated as determined by the Engineer. Payment will not be made for areas that are otherwise complete but have repairs outstanding.

"Sealing and Caulking Pack Rust", per linear foot.

The unit contract price per linear foot for "Sealing and Caulking Pack Rust" shall be full pay for performing the work as specified, including applying the rust penetrating sealer, foam backer rod when applicable, and caulk.

"Spot Abrasive Blast Cleaning", per square foot.

The unit contract price per square foot for "Spot Abrasive Blast Cleaning" shall be full pay for performing the spot abrasive blast cleaning work in accordance with Section 6-07.3(10)D.

"Containment of Abrasives", lump sum.

The lump sum contract price for "Containment of Abrasives" shall be full payment for all costs incurred by the Contractor in complying with the requirements as specified in Section 6-07.3(10)A to design, construct, maintain, and remove containment systems for abrasive blasting operations.

"Testing and Disposal of Containment Waste", by force account as provided in Section 1-09.6.

All costs in connection with testing containment waste, transporting containment waste for disposal, and disposing of containment waste in accordance with Section 6-07.3(10)F will be paid by force account in accordance with Section 1-09.6. For the purpose of providing a common proposal for all bidders, the Contracting Agency has entered an amount for the item "Testing and Disposal of Containment Waste" in the bid proposal to become part of the total bid by the Contractor.

All costs in connection with producing the metallic coatings as specified shall be included in the unit contract price for the applicable item or items of work.

Payment for painting new steel structures and painting or powder coating of galvanized surfaces will be in accordance with Section 6-03.5. Painting of timber structures will be in accordance with Section 6-04.5.

6-08 Bituminous Surfacing on Structure Decks

6-08.1 Description

This Work consists of removing and placing Hot Mix Asphalt (HMA) or Bituminous Surface Treatment (BST) directly on or over a Structure. This Work also includes performing concrete bridge deck repair, applying waterproofing membrane, and sealing paving joints.

6-08.2 Materials

Materials shall meet the requirements of the following sections:

Bituminous Surface Treatment	5-02.2
Hot Mix Asphalt	5-04.2
Joint Sealants	9-04.2
Closed Cell Foam Backer Rod	9-04.2(3)A
Waterproofing Membrane (Deck Seal)	9-11
Bridge Deck Repair Material	9-20.5

6-08.3 Construction Requirements

6-08.3(1) Definitions

Adjusted Removal Depth – the Bituminous Pavement removal depth specified by the Engineer to supersede the Design Removal Depth after review of the Contractor survey of the existing Bituminous Pavement grade profile.

Bituminous Pavement – the surfacing material containing an asphalt binder.

Design Removal Depth – the value shown in the "pavement schedule" or elsewhere in the Plans to indicate the design thickness of Bituminous Pavement to be removed.

Final Grade Profile – the compacted finished grade surface of completed Bituminous Pavement surfacing consisting of a vertical profile and superelevation cross-slope, developed by the Engineer for Grade Controlled Structure Decks based on the Contractor survey.

Grade Controlled – a Structure Deck requiring restriction of Bituminous Pavement work, including restriction of pavement removal methods and restriction of overlay pavement thicknesses.

Structure Deck – the bridge deck (concrete or timber), bridge approach slab, top of concrete box culvert, or other concrete surfaces over or upon which existing Bituminous Pavement is removed and new Bituminous Pavement is applied.

6-08.3(2) Contractor Survey for Grade Controlled Structure Decks

Prior to removing existing Bituminous Pavement from a Grade Controlled Structure Deck, the Contractor shall complete a survey of the existing surface for use in establishing the existing cross section and grade profile elevations. When removal of Bituminous Pavement is to be achieved by rotary milling/planing, the Contractor's survey shall also include the depths of the existing surfacing at each survey point.

The Contractor is responsible for all calculations, surveying, installation of control points, and measuring required for setting, maintaining and resetting equipment and materials necessary for the construction of the overlay to the Final Grade Profile.

6-08.3(2)A Survey Requirements

The Contractor shall establish at least two primary survey control points for controlling actual Bituminous Pavement removal depth and the Final Grade Profile. Horizontal control shall be by station and offset which shall be tied to either the Roadway centerline or the Structure centerline. Vertical control may be an assumed datum established by the Contractor.

Primary control points shall be described by station or milepost and offset on the baseline selected by the Contractor. The Contractor may expand the survey control information to include secondary horizontal and vertical control points as needed for the project.

Survey information collected shall include station or milepost, offset, and elevation for each lane line and curb line. Survey information shall be collected at even 20 foot station intervals, and along the centerline of each bridge expansion joint. The survey shall extend 300'-0" beyond the bridge back of pavement seat or end of Structure Deck. The survey information shall include the top of Bituminous Pavement elevation and, when rotary milling/planing equipment is used, the corresponding depth of Bituminous Pavement to the Structure Deck. The Contractor shall ensure a surveying accuracy to within ± 0.01 feet for vertical control and ± 0.2 feet for horizontal control.

Voids in HMA created by the Contractor's Bituminous Pavement depth measurements shall be filled by material conforming to Section 9-20 or another material acceptable to the Engineer.

6-08.3(2)B Survey Submittal

The Contractor's survey records shall include descriptions of all survey control points including station/milepost, offset, and elevations of all secondary control points. The Contractor shall maintain survey records of sufficient detail to allow the survey to be reproduced. The Contractor shall submit a Type 2 Working Drawing consisting of the compiled survey records and information. Survey data shall be submitted as an electronic file in Microsoft Excel format.

6-08.3(2)C Final Grade Profile and Adjusted Removal Depth

Based on the results of the survey, the Engineer may develop a Final Grade Profile and Adjusted Removal Depth. If they are developed, the Final Grade Profile and Adjusted Removal Depth will be provided to the Contractor within three working days after receiving the Contractor's survey information. When provided, the Adjusted Removal Depth supersedes the Design Removal Depth to become the Bituminous Pavement removal depth for that Structure Deck.

6-08.3(3) General Bituminous Pavement Removal Requirements

Contractor shall remove Bituminous Pavement and associated deck repair material from Structure Decks to the horizontal limits shown in the Plans and to either the specified or adjusted Bituminous Pavement removal depth as applicable.

Removal of Bituminous Pavement within 12-inches of existing permanent features that limit the reach of the machine or the edge of the following items shall be by hand or by hand operated (nominal 30-pounds class) power tools: existing bridge expansion joint headers; steel expansion joint assemblies; concrete butt joints between back of pavement seats and bridge approach slabs, bridge drain assemblies; thrie beam post steel anchorage assemblies fastened to the side or top of the Structure Deck.

When removing Bituminous Pavement with a planer, Section 5-04.3(14) shall apply. If the planer contacts the Structure Deck in excess of the specified planing depth tolerance, or contacts steel reinforcing bars at any time, the Contractor shall immediately cease planing operations and notify the Engineer. Planing operations shall not resume until completion of the appropriate adjustments to the planing machine and receiving the Engineer's concurrence to resume.

6-08.3(4) Partial Depth Removal of Bituminous Pavement from Structure Decks

The depth of surfacing removal, as measured to the bottom of the lowest milling groove generated by the rotary milling/planing machine shall be +0.01, -0.02-feet of the specified or Adjusted Removal Depth as applicable.

6-08.3(5) Full Depth Removal of Bituminous Pavement from Structure Decks

6-08.3(5)A Method of Removal

The Contractor shall perform full depth removal by a method that does not damage or remove the Structure Deck in excess of the specified Bituminous Pavement removal tolerance. The Contractor shall submit a Type 2 Working Drawing consisting of the proposed methods and equipment to be used for full depth removal.

6-08.3(5)B Planer Requirements for Full Depth Removal

The final planed surface shall have a finished surface with a tolerance of +0.01, -0.02 feet within the planed surface profile, as measured from a 10-foot straight edge. Multiple passes of planing to achieve smoothness will not be allowed.

In addition to Section 6-08.3(3), the planing equipment shall conform to the following additional requirements:

1. The cutting tooth spacing on the rotary milling head shall be less than or equal to ¼ inch.
2. The rotary milling/planing machine shall have cutting teeth that leave a uniform plane surface at all times. All teeth on the mill head shall be kept at a maximum differential tolerance of ⅜-inch between the shortest and longest tooth, as measured by a straight edge placed the full width of the rotary milling head.
3. Cutting tips shall be replaced when 30 percent of the total length of the cutting tip material remains.

Prior to each day's Bituminous Pavement removal operations, the Contractor shall confirm to the satisfaction of the Engineer that the rotary head cutting teeth are within the specified tolerances.

6-08.3(5)C Structure Deck Cleanup after Bituminous Pavement Removal

Waterproofing membrane that is loose or otherwise not firmly bonded to the Structure Deck shall be removed as an incidental component of the Work of surfacing removal. Existing waterproofing membrane bonded to the Structure Deck need not be removed.

6-08.3(6) Repair of Damage due to Bituminous Pavement Removal Operations

All concrete bridge deck, pavement seat, and steel reinforcing bar damage due to the Contractor's surfacing removal operations shall be repaired by the Contractor in accordance with Section 1-07.13, and as specified below.

Damaged concrete in excess of the specified Bituminous Pavement removal tolerance shall be repaired in accordance with Section 6-08.3(7), with the bridge deck repair material placed to the level of the surrounding bridge deck and parallel to the final grade paving profile.

Damaged steel reinforcing bar shall be repaired as follows:

1. Damage to steel reinforcing bar resulting in a section loss less than 20-percent of the bar with no damage to the surrounding concrete shall be left in place and shall be repaired by removing the concrete to a depth ¾-inches around the top steel reinforcing bar and placing bridge deck repair material accepted by the Engineer to the level of the bridge deck and parallel to the final grade paving profile.
2. Damage to steel reinforcing bar resulting in a section loss of 20-percent or more in one location, bars partially or completely removed from the bridge deck, or where there is a lack of bond to the concrete, shall be repaired by removing the adjacent concrete and splicing a new bar of the same size. Concrete shall be removed to provide a ¾-inch minimum clearance around the bars. The splice bars shall extend a minimum of 40 bar diameters beyond each end of the damage.

6-08.3(7) Concrete Deck Repair

This Work consists of repairing the concrete deck after Bituminous Pavement has been removed.

6-08.3(7)A Concrete Deck Preparation

The Contractor, with the Engineer, shall inspect the exposed concrete deck to establish the extent of bridge deck repair in accordance with Section 6-09.3(6). Areas of Structure Deck left with existing well bonded waterproof membrane after full depth Bituminous Pavement removal are exempt from this inspection requirement.

All loose and unsound concrete within the repair area shall be removed with jackhammers no heavier than the nominal 30 pound class or chipping hammers no heavier than the nominal 15 pound class, or other mechanical means acceptable to the Engineer, and operated at angles less than 45 degrees as measured from the surface of the deck to the tool. If unsound concrete exists around the existing steel reinforcing bars, or if the bond between concrete and steel reinforcing bar is broken, the Contractor shall remove the concrete to provide a ¾ inch minimum clearance to the bar. The Contractor shall take care to prevent damage to the existing steel reinforcing bars and concrete to remain.

After removing sufficient concrete to establish the limits of the repair area, the Contractor shall make ¾ inch deep vertical saw cuts and maintain square edges at the boundaries of the repair area. The exposed steel reinforcing bars and concrete in the repair area shall be abrasive blasted and blown clean just prior to placing the bridge deck repair material.

6-08.3(7)B Ultra-Low Viscosity, Two-Part Liquid, Polyurethane-Hybrid Polymer Concrete

The ultra-low viscosity, two-part liquid, polyurethane-hybrid polymer concrete shall be mixed in accordance with the manufacturer's recommendations.

Aggregate shall conform to the gradation limit requirements recommended by the manufacturer. The aggregate and the ultra-low viscosity, two-part liquid, polyurethane-hybrid polymer concrete shall be applied to the repair areas in accordance with the sequence and procedure recommended by the manufacturer.

All repairs shall be float finished flush with the surrounding surface within a tolerance of ⅛ inch of a straight edge placed across the full width and breadth of the repair area.

6-08.3(7)C Pre-Packaged Cement Based Repair Mortar

The Contractor shall mix the pre-packaged cement based repair mortar using equipment, materials and proportions, batch sizes, and process as recommended by the manufacturer.

All repairs shall be float finished flush with the surrounding surface within a tolerance of ⅛ inch of a straight edge placed across the full width and breadth of the repair area.

6-08.3(7)D Cure

All bridge deck repair areas shall be cured in accordance with the manufacturer's recommendations and attain a minimum compressive strength of 2,500 psi before allowing vehicular and foot traffic on the repair and placing waterproofing membrane on the bridge deck over the repair.

6-08.3(8) Waterproof Membrane for Structure Decks

This work consists of furnishing and placing a waterproof sheet membrane system over a prepared Structure Deck prior to placing an HMA overlay. The waterproof membrane system shall consist of a sheet membrane adhered to the Structure Deck with a primer.

The Contractor shall comply with all membrane manufacturer's installation recommendations.

6-08.3(8)A Structure Deck Preparation

The Structure Deck and ambient air temperatures shall be above 50°F and the Structure Deck shall be surface-dry at the time of the application of the primer and membrane.

All areas of a Structure Deck that have fresh cast bridge deck concrete less than 28 days old (not including bridge deck repair concrete placed in accordance with Section 6-08.3(7)) shall cure for a period of time recommended by the membrane manufacturer, or as specified by the Engineer, before application of the membrane.

The entire Structure Deck and the sides of the curb and expansion joint headers to the height of the HMA overlay shall be free of all foreign material such as dirt, grease, etc. Prior to applying the primer or sheet membrane, all dust and loose material shall be removed from the Structure Deck. All surface defects such as spalled areas, cracks, protrusions, holes, sharp edges, ridges, etc., and other surface imperfections greater than ¼ inch in width shall be corrected prior to application of the membrane.

6-08.3(8)B Applying Primer

The primer shall be applied to the cleaned deck surfaces at the rate according to the procedure recommended by the membrane manufacturer. All surfaces to be covered by the membrane shall be thoroughly and uniformly coated with primer. Structure Deck areas left with existing well bonded waterproof membrane after bituminous surfacing removal shall receive an application of primer in accordance with the membrane manufacturer's recommendations. Precautionary measures shall be taken to ensure that pools and thick layers of primer are not left on the deck surface. The membrane shall not be applied until the primer has cured or volatile material has substantially dissipated, in accordance with the membrane manufacturer's recommendations.

The primer and waterproof membrane shall extend from the bridge deck up onto the curb face and expansion joint header face the thickness of the HMA overlay. The membrane shall adhere to the vertical surface.

6-08.3(8)C Placing Waterproof Membrane

Membrane application shall begin at the low point on the deck, and continue in a lapped shingle pattern. The overlap shall be a minimum of six inches or greater if recommended by the membrane manufacturer. Membrane seams shall be sealed as recommended by the membrane manufacturer. Hand rollers or similar tools shall be used on the applied membrane to assure firm and uniform contact with the primed Structure surfaces.

The fabric shall be neatly cut and contoured at all expansion joints and drains. The cuts at bridge drains shall be two right angle cuts made to the inside diameter of the bridge deck drain outlet, after which the corners of the waterproof membrane shall be turned down into the drains and laid in a coating of primer.

6-08.3(8)D Membrane Repair and Protection

The waterproof membrane will be visually inspected by the Engineer for uniformity, tears, punctures, bonding, bubbles, wrinkles, voids and other defects. All such deficiencies shall be repaired in accordance with the membrane manufacturer's recommendations prior to placement of the HMA overlay.

The membrane material shall be protected from damage due to the paving operations in accordance with the membrane manufacturer's recommendations. No traffic or equipment except that required for the actual waterproofing and paving operations will be permitted to travel or rest on the membrane until it is covered by the HMA overlay. The use of windrows is not allowed for laydown of HMA on a membrane.

Where waterproofing membrane is placed in stages or applied at different times, a strip of temporary paper shall be used to protect the membrane overlap from the HMA hand removal methods.

6-08.3(9) Placing Bituminous Pavement on Structure Decks

HMA overlay shall be applied on Grade Controlled Structure Decks using reference lines for vertical control in accordance with Section 5-04.3(3)C.

The compacted elevation of the HMA overlay on Structure Decks shall be within ± 0.02 feet of the specified overlay thickness or Final Grade Profile as applicable. Deviations from the final grade paving profile in excess of the specified tolerance and areas of non-conforming surface smoothness shall be corrected in accordance with Section 5-04.3(13).

Final grade Roadway transitions to a Structure Deck with Bituminous Pavement shall not exceed a 0.20 percent change in grade in accordance with the bridge deck transition for HMA overlay Standard Plan, unless shown otherwise in the Plans.

Final grade compacted HMA elevations shall be higher than an adjacent concrete edge by ¼ inch ± ⅛ inch at all expansion joint headers and concrete butt joints as shown in the concrete to asphalt butt joint details of the bridge paving joint seals Standard Plan. This also applies to steel edges within the limits of the overlay such as bridge drain frames and steel joint riser bars at bridge expansion joints.

6-08.3(9)A Protection of Structure Attachments and Embedments

The Contractor is responsible for protecting all Structure attachments and embedments from the application of BST and HMA.

Drainage inlets that are to remain open, and expansion joints, shall be cleaned out immediately after paving is completed. Materials passing through expansion joints shall be removed from the bridge within 10 working days.

All costs incurred by the Contractor in protective measures and clean up shall be included in the unit Contract prices for the associated Bid items of Work.

6-08.3(10) HMA Compaction on Structure Decks

Compaction of HMA on Structure Decks shall be in accordance with Section 5-04.3(10).

Work rejected in accordance with Section 5-04.3(11) shall include the materials, work, and incidentals to repair an existing waterproof membrane damaged by the removal of the rejected work.

6-08.3(11) Paved Panel Joint Seals and HMA Sawcut and Seals

Bridge paving joint seals shall be installed in accordance with Section 5-03.3(2)C and the details shown in the Plans and Standard Plans.

When concrete joints are exposed after removal of Bituminous Pavement, the joints shall be cleaned and sealed in accordance with Section 5-03.3(2)C2 and the paved panel joint seal details of the bridge paving joint seals Standard Plan, including placement of the closed cell backer rod at the base of the cleaned joint. If waterproofing membrane is required, the membrane shall be slack or folded at the concrete joint to allow for Structure movements without stress to the membrane. After placement of the HMA overlay, the second phase of the paved panel joint seal shall be completed by sawing the HMA and sealing the sawn joint in accordance with Section 5-03.3(2)C1.

6-08.4 Measurement

Removing existing Bituminous Pavement from Structure Decks will be measured by the square yard of Structure Deck surface area with removed overlay.

Bridge deck repair will be measured by the square foot surface area of deck concrete removed with the measurement taken at the plane of the top mat of steel reinforcing bars.

Waterproof membrane will be measured by the square yard surface area of Structure Deck and curb and header surface area covered by membrane.

6-08.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Structure Surveying", lump sum.

"Removing Existing Overlay From Bridge Deck___", per square yard.

The unit Contract price per square yard for "Removing Existing Overlay From Bridge Deck___", shall be full pay for performing the Work as specified for full removal of Bituminous Pavement on Structure Decks, including the removal of existing waterproof membrane and disposing of materials.

"Bridge Deck Repair Br. No.___", per square foot.

The unit Contract price per square foot for "Bridge Deck Repair Br. No.___" shall be full pay for performing the Work as specified, including removing and disposing of the concrete within the repair area and furnishing, placing, finishing, and curing the repair concrete.

"Waterproof Membrane Br. No.___", per square yard.

The unit Contract price per square yard for "Waterproof Membrane Br. No.___" shall be full pay for performing the Work as specified, including repairing any damaged or defective waterproofing membrane and repair of damaged HMA overlay.

6-09 Modified Concrete Overlays

6-09.1 Description

This Work consists of scarifying concrete bridge decks, preparing and repairing bridge deck surfaces designated and marked for further deck preparation, and placing, finishing, and curing modified concrete overlays.

6-09.2 Materials

Materials shall meet the requirements of the following Sections:

Portland Cement	9-01.2(1)
Blended Hydraulic Cement	9-01.2(1)B
Fine Aggregate	9-03.1
Coarse Aggregate	9-03.1
Mortar	9-20.4
Burlap Cloth	9-23.5
Admixtures	9-23.6
Fly Ash	9-23.9
Microsilica Fume	9-23.11
Water	9-25.1

Portland cement shall be either Type I or Type II. Type III portland cement will not be allowed.

Blended hydraulic cement shall be Type IP(X)MS and shall only be used in modified fly ash overlay. The required proportions for Type I cement and Type F fly ash shall be in accordance with Section 6-09.3(3)C. Only Type IP(X)MS that is blended with Type F fly ash is permitted for use. Type IP(X)MS that is blended with natural pozzolans are not allowed.

Fine aggregate shall be Class 1. Coarse aggregate shall be AASHTO grading No. 7 or No. 8.

Fly ash shall be Class F only.

Microsilica admixture shall be either a dry powder or a slurry admixture. Microsilica will be accepted based on submittal of a Manufacturer's Certificate of Compliance in accordance with Section 1-06.3. If the microsilica is a slurry admixture, the microsilica content of the slurry shall be certified as a percent by mass.

Latex admixture shall be a non-toxic, film-forming, polymeric emulsion in water to which all stabilizers have been added at the point of manufacture. The latex admixture shall be homogeneous and uniform in composition, and shall conform to the following:

Polymer Type	Styrene Butadiene
Stabilizers:	
Latex	Non-ionic surfactants
Portland Cement	Polydimethyl siloxane
Percent Solids	46.0 to 49.0
Weight per Gallon	8.4 pounds at 77°F
Color White PH (as shipped)	9 minimum
Freeze/Thaw Stability	5 cycles (5°F to 77°F)
Shelf Life	2 years minimum

Latex admixture will be accepted based on submittal of a Manufacturer's Certificate of Compliance in accordance with Section 1-06.3.

High Molecular Weight Methacrylate (HMWM) resin for crack and joint sealing shall conform to the following:

Viscosity	<25 cps (Brookfield RVT with UL adaptor, 50 rpm at 77°F) ... California Test 434
Density	8.5 to 8.8 pounds per gallon at 77°F... ASTM D2849
Flash Point	>200°F, PMCC (Pinsky-Martens CC)
Vapor Pressure	<0.04 inches Hg at 77°F, ASTM D323
Tg (DSC)	>136°F, ASTM D3418
Gel Time	60 minutes minimum

The promoter/initiator system for the methacrylate resin shall consist of a metal drier and peroxide.

Sand for abrasive finish shall be crushed sand, oven dried, and stored in moisture proof bags. The sand shall conform to the following gradation:

Sieve Size	Percent Passing	
	Minimum	Maximum
No. 10	98	100
No. 16	55	75
No. 20	30	50
No. 30	8	25
No. 50	0	5
No. 100	0	3

All percentages are by weight.

6-09.3 Construction Requirements

6-09.3(1) Equipment

6-09.3(1)A Power Driven Hand Tools

Power driven hand tools may be used for concrete scarification in areas not accessible to scarification machines, and for further deck preparation Work, and shall meet the following:

1. Jack hammers no heavier than the nominal 30-pound class.
2. Chipping hammers no heavier than the nominal 15-pound class.
3. Other mechanical means acceptable to the Engineer.

The power driven hand tools shall be operated at angles less than 45 degrees as measured from the surface of the deck to the tool.

6-09.3(1)B Rotary Milling Machines

Rotary milling machines used to remove an upper layer of existing concrete overlay, when present, shall have a maximum operating weight of 50,000 pounds and conform to Section 6-08.3(5)B.

6-09.3(1)C Hydro-Demolition Machines

Hydro-demolition machines shall consist of filtering and pumping units operating in conjunction with a remote-controlled robotic device, using high-velocity water jets to remove sound concrete to the lesser of 2 inches or the nominal scarification depth shown in the Plans with a single pass of the machine, and with the simultaneous removal of all deteriorated concrete. If the nominal scarification depth is greater than 2 inches then the multiple passes shall be required. Rotary heads are required for the final pass of the hydro-demolition machine. Hydro-demolition machines shall also clean any exposed reinforcing steel of all rust and corrosion products.

6-09.3(1)D Vacant

6-09.3(1)E Air Compressor

Air compressors shall be equipped with oil traps to eliminate oil from being blown onto the bridge deck.

6-09.3(1)F Vacuum Machine

Vacuum machines shall be capable of collecting all dust, concrete chips, freestanding water and other debris encountered while cleaning during deck preparation. The machines shall be equipped with collection systems that allow the machines to be operated in air pollution sensitive areas and shall be equipped to not contaminate the deck during final preparation for concrete placement.

6-09.3(1)G Water Spraying System

The water spraying system shall include a portable high-pressure sprayer with a separate water supply of potable water. The sprayer shall be readily available to all parts of the deck being overlaid and shall be able to discharge water in a fine mist to prevent accumulation of free water on the deck. Sufficient water shall be available to thoroughly soak the deck being overlaid and to keep the deck wet prior to concrete placement.

The Contractor shall certify that the water spraying system meets the following requirements:

Pressure	2,200 psi minimum
Flow Rate	4.5 gpm minimum
Fan Tip	15° to 25° Range

6-09.3(1)H Mobile Mixer for Latex Modified Concrete

Proportioning and mixing shall be accomplished in self-contained, self-propelled, continuous-mixing units conforming to the following requirements:

1. The mixer shall be equipped so that it can be grounded.
2. The mixer shall be equipped to provide positive measurement of the portland cement being introduced into the mix. A recording meter, visible at all times and equipped with a ticket printout, shall be used.
3. The mixer shall be equipped to provide positive control of the flow of water and latex admixture into the mixing chamber. Water flow shall be indicated by a flow meter with a minimum readability of ½ gallon per minute, accurate to ± 1 percent. The water system shall have a bypass valve capable of completely diverting the flow of water. Latex flow shall also be indicated by a flow meter with a minimum readability of 2 gallons per minute, accurate to ± 1 percent. The latex system shall be equipped with a bypass valve suitable for obtaining a calibrated sample of admixture.
4. The mixer shall be equipped to be calibrated to automatically proportion and blend all components of the specified mix on a continuous or intermittent basis as required by the finishing operation, and shall discharge mixed material through a conventional chute directly in front of the finishing machine.

Inspection of each mobile mixer shall be done by the Contractor in the presence of the Engineer and in accordance with the following requirements:

1. Check the manufacturer's inspection plate or mix setting chart for the serial number, the proper operating revolutions per minute (rpm), and the approximate number of counts on the cement meter to deliver 94 pounds of cement.
2. Make a general inspection of the mobile mixer to ensure cleanliness and good maintenance practices.
3. Check to see that the aggregate bins are empty and clean and that the bin vibrators work.

4. Verify that the cement aeration system operates, that the vent is open, and that the mixer is equipped with a grounding strap. Check the cement meter feeder to ensure that all fins and pockets are clean and free from accumulated cement. If the operator cannot demonstrate, through visual inspection, that the cement meter feeder is clean, all cement shall be removed from the bin and the cement meter feeder inspected. The aeration system shall be equipped with a gauge or indicator to verify that the system is operating.
5. Verify that the main belt is clean and free of any accumulated material.
6. Check the latex strainer to ensure cleanliness.

The initial calibration shall consist of the following items:

1. **Cement Meter**
   a. Refer to the truck manufacturer's mix setting chart to determine the specified operating rpm and the approximate number of counts required on the cement meter to deliver 94 pounds of cement.
   b. Place at least 40 bags (about 4,000 pounds) of cement in the cement bin.
   c. Ensure the mixer is resting on a level surface.
   d. Ensure the mixer is grounded.
   e. Adjust the engine throttle to obtain the specified rpm. Operate the unit, discharging cement until the belt has made one complete revolution. Stop the belt. Reset the cement meter to zero. Position a suitable container to catch the cement and discharge approximately one bag of cement. With a stopwatch, measure the time required to discharge the cement. Record the number of counts on the cement meter and determine the weight of the cement in the container. Repeat the process of discharging approximately one bag of cement until six runs have been made. Reset the cement meter to zero for each run.

   Example:

Run No.	Cement Counts	Weight of Cement	Time In Seconds
1	66	95	31
2	68	96	31.2
3	67	95.5	31.0
4	66	95	29.8
5	67	95.25	30.5
6	66	95	30.8
TOTAL	400	571.75	184.3

   Pounds of cement per count on cement meter:

$$\frac{\text{Weight of Cement}}{\text{No. of Counts}} = \frac{571.75}{400} = 1.43 \text{ LB./Count}$$

Counts per bag (94 pounds):

$$\frac{94}{1.43} = 65.7 \text{ Counts Bag}$$

Pounds of cement discharged per second:

$$\frac{\text{Weight of Cement}}{\text{Time in Seconds}} = \frac{571.75}{184.3} = 3.10 \text{ LB./SEC.}$$

Required time to discharge one bag:

$$\text{Time} = \frac{94}{3.10} = 30.32 \text{ SEC./Bag}$$

2. **Latex Throttling Valve**

   a. Check to be sure that the latex strainer is unobstructed.

   b. The latex throttling valve shall be adjusted to deliver 3.5 gallons of latex (29.4 pounds) for each bag of cement. From the above calculation 30.32 seconds are required to deliver one bag of cement.

   c. With the unit operating at the specified rpm, discharge latex into a container for 30.3 seconds and determine the weight of latex. Continue adjusting the valve until 29.4 to 29.5 pounds of latex is discharged in 30.3 seconds. Verify the accuracy of this valve setting three times.

3. **Water Flow Meter**

   a. Set the water flow meter by adjusting it to flow at ½ gallon per minute.

   b. Collect and weigh the water discharged during a 1-minute interval with the equipment operating at the specified rpm. Divide the weight of water by 8.34 to determine the number of gallons.

   c. Repeat items a. and b., above, with the flow meter adjusted to 1½ gallons per minute.

4. **Aggregate Bin Gates**

   a. Set the gate openings to provide the amount of aggregate required to produce concrete having the specified proportions.

   b. Discharge a representative sample of the aggregates through the gates and separate on the No. 4 sieve. Aggregates shall meet the requirements for proportions in accordance with Section 6-09.3(3)E.

   c. Adjust the gate openings if necessary to provide the proper ratio of fine aggregate to total aggregate.

5. **Production of Trial Mix** – Each mobile mixer shall be operated to produce at least ½ cubic yard of concrete, which shall be in compliance with these Specifications, prior to acceptance of the mobile mixer for job use. The Engineer will perform yield, slump, and air tests on the concrete produced by each mixer. Calibration of each mobile mixer shall be done by the Contractor in the presence of the Engineer. A complete calibration is required on each mixer on each concrete placement unless, after the

initial calibration, the personnel having the responsibility of mixer calibration on subsequent concrete placement were present during the initial calibration of the mixer and during the concrete placement operations and are able to verify the dial settings of the initial calibration and concrete placement.

If these criteria are met, a complete calibration need not be repeated provided that a single trial run verifies the previous settings of the cement meter, latex throttling valve, water flow meter, and aggregate gradations, and that the mixer has not left the project and the Engineer is satisfied that a complete calibration is not needed.

6-09.3(1)I Ready-Mix Trucks and Batch Plants for Concrete Class M, Fly Ash Modified and Microsilica Modified Concrete

Ready-mix trucks and batch plants shall conform to Section 6-02.3(4)A.

6-09.3(1)J Finishing Machine

The finishing machine shall meet the requirements of Section 6-02.3(10) and the following requirements:

The finishing machine shall be equipped with augers, followed by an oscillating, vibrating screed, vibrating roller tamper, or a vibrating pan, followed by a rotating cylindrical double drum screed. The vibrating screed, roller tamper or pan shall be of sufficient length and width to properly consolidate the mixture. The vibrating frequency of the vibrating screed, roller tamper or pan shall be variable with positive control.

6-09.3(2) Submittals

The Contractor shall submit the following Working Drawings in accordance with Section 1-05.3:

1. A Type 1 Working Drawing consisting of catalog cuts and operating parameters of the hydro-demolition machine selected by the Contractor for use in this project to scarify concrete surfaces.
2. A Type 1 Working Drawing consisting of catalog cuts, operating parameters, axle loads, and axle spacing of the rotary milling machine (if used to remove an upper layer of existing concrete overlay when present).
3. A Type 2 Working Drawing of the Runoff Water Disposal Plan. The Runoff Water Disposal Plan shall describe all provisions for the containment, collection, filtering, and disposal of all runoff water and associated contaminants and debris generated by the hydro-demolition process, including containment, collection and disposal of runoff water and debris escaping through breaks in the bridge deck.
4. A Type 2 Working Drawing of the method and materials used to contain, collect, and dispose of all concrete debris generated by the scarifying process, including provisions for protecting adjacent traffic from flying debris.

5. A Type 1 Working Drawing of the mix design for concrete Class M, and either fly ash modified concrete, microsilica modified concrete, or latex modified concrete, as selected by the Contractor for use in this project in accordance with Section 6-09.3(3).
6. A Type 1 Working Drawing of samples of the latex admixture and the portland cement for testing and compatibility (if latex modified concrete is used).
7. A Type 2 Working Drawing of the paving equipment Specifications and details of the screed rail support system, including details of anchoring the rails and providing rail continuity.

6-09.3(3) Concrete Overlay Mixes

6-09.3(3)A General

For fly ash, microsilica, and latex modified concrete, the Contractor shall adjust the slump to accommodate the gradient of the bridge deck, subject to the maximum slump specified.

For fly ash and microsilica modified concrete, the maximum water/cement ratio shall be calculated using all of the available mix water, including the free water in both the coarse and fine aggregate, and in the microsilica slurry if a slurry is used.

For fly ash and microsilica modified concrete, all water-reducing and air entraining admixtures, and superplasticizers, shall be used in accordance with the admixture manufacturer's recommendations.

6-09.3(3)B Concrete Class M

Concrete Class M for further deck preparation patching concrete shall be proportioned in accordance with the following mix design:

Portland Cement	705 pounds
Fine Aggregate	1,280 pounds
Coarse Aggregate	1,650 pounds
Water/Cement Ratio	0.37 maximum
Air (± 1½ percent)	6 percent
Slump (± 1 inch)	5 inches

The use of a water-reducing admixture conforming to AASHTO M194 Type A will be required to produce patching concrete with the desired slump, and shall be used in accordance with the admixture manufacturer's recommendations. Air entraining admixtures shall conform to AASHTO M154 and shall be used in accordance with the admixture manufacturer's recommendations. The use of accelerating admixtures or other types of admixtures is not allowed.

6-09.3(3)C Fly Ash Modified Concrete

Fly ash modified concrete shall be a workable mix, uniform in composition and consistency. Mix proportions per cubic yard shall be as follows:

Portland Cement	611 pounds
Fly Ash	275 pounds
Fine Aggregate	38 percent of total aggregate
Coarse Aggregate	62 percent of total aggregate
Water/Cement Ratio	0.30 maximum
Air (± 1½ percent)	6 percent
Slump	7 inches maximum

6-09.3(3)D Microsilica Modified Concrete

Microsilica modified concrete shall be a workable mix, uniform in composition and consistency. Mix proportions per cubic yard shall be as follows:

Portland Cement	658 pounds
Microsilica Fume	52 pounds
Fine Aggregate	1,515 pounds
Coarse Aggregate	1,515 pounds
Water/Cement Ratio	0.33 maximum
Air (± 1½ percent)	6 percent
Slump	7 inches maximum

6-09.3(3)E Latex Modified Concrete

Latex modified concrete shall be a workable mix, uniform in composition and consistency. Mix proportions per cubic yard shall be as follows:

Portland Cement	1.00 parts by weight
Fine Aggregate	2.40 to 2.75 parts by weight
Coarse Aggregate	1.75 to 2.00 parts by weight
Latex Admixture	3.50-gallons per bag of cement
Water/Cement Ratio	0.33 maximum
Air Content of Plastic Mix	6 percent maximum
Slump	7 inches maximum

The aggregates shall be proportioned such that the amount of aggregate passing the No. 4 sieve is 65 ± 5 percent of the total aggregate (fine plus coarse). All calculations shall be based on dry weights.

The moisture content of the fine aggregate and coarse aggregate shall be no more than 3.0 and 1.0 percent, respectively, above the saturated surface dry condition.

The water limit for calculating the water/cement ratio shall include the added water, the free water in the aggregates, and 52 percent of the latex admixture.

6-09.3(4) Storing and Handling

6-09.3(4)A Vacant

6-09.3(4)B Latex Admixture

The admixture shall be kept in suitable containers that will protect it from freezing and from exposure to temperatures in excess of 85°F. Containers of the admixture shall not be stored in direct sunlight for periods in excess of 10 days. When stored in direct sunlight the top and sides of the containers shall be covered with insulating blanket material.

Storage of the admixture may extend over a period greater than 10 days as long as the conditions specified above are maintained and the latex admixture is agitated or stirred once every 10 days. Stirring or agitation of the admixture shall be done mechanically in accordance with the manufacturer's recommendation. If the ambient temperature is higher than 85°F at any time during the storage period, the admixture shall be covered by insulated blankets or other means that will maintain the admixture temperature below 85°F.

The admixture shall be strained through a Number 10 strainer at the time it is introduced into the mixing tank from the storage containers.

6-09.3(4)C High Molecular Weight Methacrylate Resin (HMWM)

The HMWM resin shall be stored in a cool dry place and protected from freezing and exposure to temperature in excess of 100°F. The promoter and initiator, if supplied separate from the resin, shall not contact each other directly. Containers of promoters and initiators shall not be stored together in a manner that will allow leakage or spillage from one to contact the containers or material of the other.

6-09.3(5) Scarifying Concrete Surface

6-09.3(5)A General

The Contractor shall not begin scarifying a concrete bridge deck surface unless completion of the scarification and concrete overlay can be accomplished within the current construction season.

The Contractor shall protect adjacent traffic from flying debris generated by the scarification process in accordance with item 4 of Section 6-09.3(2).

The Contractor shall collect, contain, and dispose of all concrete debris generated by the scarification process in accordance with item 4 of Section 6-09.3(2).

All areas of the deck that are inaccessible to the selected scarifying machine shall be scarified to remove the concrete surface matrix by a method acceptable to the Engineer. The maximum scarified depth shall be equal to the nominal scarification depth shown in the Plans or as otherwise allowed in areas of existing dense, sound bridge deck concrete repair material. If these areas are hand-chipped then the equipment shall meet the requirements as specified in Section 6-09.3(1)A.

Dense, sound areas of existing bridge deck concrete repair material shall be sufficiently scarified to provide 1-inch minimum clearance to the top of the fresh modified concrete overlay.

Concrete process water generated by scarifying concrete surface and removing existing concrete overlay operations shall be contained, collected, and disposed of in accordance with Sections 5-01.3(11) and 6-09.3(5)C, and the Section 6-09.3(2) Runoff Water Disposal Plan.

6-09.3(5)B Testing of Hydro-Demolition Machines

A trial area shall be performed to demonstrate that the equipment and methods of operation are capable of producing results satisfactory to the Engineer. The trial area shall consist of a patch approximately 30 square feet in sound concrete as determined by the Engineer.

The equipment shall be programmed to remove concrete to the nominal scarification depth shown in the Plans, but no more than 2 inches, with a single pass of the machine. The Engineer will grant acceptance of the equipment based on successful results from the trial area test.

6-09.3(5)C Hydro-Demolishing

Once the operating parameters of the Hydro-Demolition machine are defined by programming and calibration as specified in Section 6-09.3(5)B, they shall be monitored every 20 feet as the machine progresses across the bridge deck, in order to prevent the unnecessary removal of sound concrete below the required nominal removal depth. The Contractor shall maintain a minimum production rate of 250-square feet per hour during the deck scarifying process.

All water used in the Hydro-Demolition process shall be potable. Stream or lake water will not be permitted.

All bridge drains and other outlets within 100 feet of the Hydro-Demolition machine shall be temporarily plugged during the Hydro-Demolition operation. When scarifying a bridge deck passing over traffic lanes, the Contractor shall protect the traffic below by restricting and containing scarifying operations, and implementing traffic control measures.

The Contractor shall provide for the collection, filtering and disposal of all runoff water generated by the Hydro-Demolition process, in accordance with the Runoff Water Disposal Plan in accordance with item 3 of Section 6-09.3(2). The Contractor shall comply with applicable regulations concerning such water disposal.

6-09.3(5)D Vacant

6-09.3(5)E Removing Existing Concrete Overlay Layer by Rotomilling

When the Contractor elects to remove the upper layer of existing concrete overlay, when present, by rotomilling prior to final scarifying, the entire concrete surface of the bridge deck shall be milled to remove the surface matrix to the depth specified in the Plans with a tolerance as specified in Section 6-08.3(5)B. The operating parameters of the rotary milling machine shall be monitored in order to prevent the unnecessary removal of concrete below the specified removal depth.

6-09.3(5)F Repair of Steel Reinforcing Bars Damaged by Scarifying Operations

All reinforcing steel damaged due to the Contractor's operations shall be repaired by the Contractor. For bridge decks not constructed under the same Contract as the concrete overlay, damage to existing reinforcing steel shall be repaired and paid for in accordance with Section 1-09.6 if the existing concrete cover is ½ inch or less. All other reinforcing steel damaged due to the Contractor's operations shall be repaired by the Contractor at no additional expense to the Contracting Agency.

The repair shall be as follows or as directed by the Engineer:

1. Damage to epoxy coating, when present on existing steel reinforcing bars, shall be repaired in accordance with Section 6-02.3(24)H.
2. Damage to bars resulting in a section loss of 20 percent or more of the bar area shall be repaired by chipping out the adjacent concrete and splicing a new bar of the same size. Concrete shall be removed to provide a ¾-inch minimum clearance around the bars. The splice bars shall extend a minimum of 40 bar diameters beyond each end of the damage.
3. Any bars partially or completely removed from the deck shall have the damaged portions removed and spliced with new bars as outlined in item 2 above.

6-09.3(5)G Cleanup Following Scarification

After scarifying is completed, the entire lane or strip being overlaid shall be thoroughly cleaned of all dust, freestanding water and loose particles.

6-09.3(6) Further Deck Preparation

Once the lane or strip being overlaid has been cleaned of debris from scarifying, the entire scarified surface shall be inspected by the Contractor, in the presence of the Engineer, in accordance with ASTM D4580, Method B. The Contractor shall mark those areas of the existing bridge deck requiring further deck preparation.

Further deck preparation will be required when any one of the following conditions is present:

1. Unsound concrete in accordance with ASTM D4580, Method B.
2. Lack of bond between existing concrete and reinforcing steel.
3. All existing nonconcrete patches.

Dense, sound areas of existing bridge deck material shall be sufficiently scarified to the limits shown in the plans in accordance with 6-09.3(5)A and is not considered further deck preparation.

If the concrete overlay is placed on a bridge deck as part of the same Contract as the bridge deck construction, then all Work associated with the further deck preparation shall be performed at no additional expense to the Contracting Agency.

6-09.3(6)A Equipment for Further Deck Preparation

Further deck preparation shall be performed using either power driven hand tools conforming to Section 6-09.3(1)A, or hydro-demolition machines conforming to Section 6-09.3(1)C.

6-09.3(6)B Deck Repair Preparation

All material in the repair area shall be removed by chipping, hydro demolishing, or other approved mechanical means to a depth necessary to remove all loose and unsound material.

Care shall be taken in removing the deteriorated material to not damage any of the existing deck or steel reinforcing bars that are to remain in place. All removal shall be accomplished by making vertical edges at the boundaries of the repair area. In no case shall the depth of a sawn vertical cut exceed ¾ inch or to the top of the top steel reinforcing bars, whichever is less.

The exposed steel reinforcing bars and concrete in the repair area shall be sandblasted or hydro-blasted and blown clean just prior to placing concrete.

Where existing steel reinforcing bars inside deck repair areas show deterioration greater than 20-percent section loss, the Contractor shall furnish and place steel reinforcing bars alongside the deteriorated bars in accordance with the details shown in the *Standard Plans*. Payment for such extra Work will be by force account as provided in Section 1-09.6.

Bridge deck areas outside the repair area or steel reinforcing bar inside or outside the repair area damaged by the Contractor's operations, shall be repaired by the Contractor at no additional expense to the Contracting Agency, and to the satisfaction of the Engineer.

6-09.3(6)C Placing Deck Repair Concrete

Deck repair concrete for modified concrete overlays shall be either modified concrete or concrete Class M as specified below.

Before placing any deck repair concrete, the Contractor shall flush the existing concrete in the repair area with water and make sure that the existing concrete is well saturated. The Contractor shall remove any freestanding water prior to placing the deck repair concrete. The Contractor shall place the deck repair concrete onto the existing concrete while it is wet.

Type 1 deck repairs, defined as deck repair areas with a maximum depth of one-half the periphery of the bottom bar of the top layer of steel reinforcement or, where depths are greater, the exposed bar length does not exceed 12-continuous inches along the length of the bar, may be filled during the placement of the concrete overlay. The Work of Type 1 further deck preparation shall consist of removing and disposing of the concrete within the repair area.

Type 2 deck repairs, defined as deck repair areas not conforming to the definition of Type 1 deck repairs, shall be repaired with concrete Class M to the scarification depth shown in the plans and wet cured for 42 hours in accordance with Section 6-09.3(13), prior to placing the concrete overlay. The Work of Type 2 further deck preparation shall consist of removing and disposing of concrete within the repair area, and furnishing, placing, finishing, and curing the repair concrete. During the curing period, all vehicular and foot traffic shall be prohibited on the repair area.

6-09.3(7) Surface Preparation for Concrete Overlay

Following the completion of any required further deck preparation the entire lane or strip being overlaid shall be cleaned to be free from oil and grease, rust and other foreign material that may still be present. These materials shall be removed by detergent-cleaning or other method accepted by the Engineer followed by sandblasting.

After detergent cleaning and sandblasting is completed, the entire lane or strip being overlaid shall be cleaned in final preparation for placing concrete.

Hand tool chipping, sandblasting and cleaning in areas adjacent to a lane or strip being cleaned in final preparation for placing concrete shall be discontinued when final preparation is begun. Scarifying and hand tool chipping shall remain suspended until the concrete has been placed and the requirement for curing time has been satisfied. Sandblasting and cleaning shall remain suspended for the first 24 hours of curing time after the completion of concrete placing.

Scarification, and removal of the upper layer of concrete overlay when present, may proceed during the final cleaning and overlay placement phases of the Work on adjacent portions of the Structure so long as the scarification and concrete overlay removal operations are confined to areas which are a minimum of 100 feet away from the defined limits of the final cleaning or overlay placement in progress. If the scarification and concrete overlay removal impedes or interferes in any way with the final cleaning or overlay placement as determined by the Engineer, the scarification and concrete overlay removal Work shall be terminated immediately and the scarification and concrete overlay removal equipment removed sufficiently away from the area being prepared or overlaid to eliminate the conflict. If the grade is such that water and contaminants from the scarification and concrete overlay removal operation will flow into the area being prepared or overlaid, the scarification and concrete overlay removal operation shall be terminated and shall remain suspended for the first 24 hours of curing time after the completion of concrete placement.

If, after final cleaning, the lane or strip being overlaid becomes wet, the Contractor shall flush the surface with high-pressure water, prior to placement of the overlay. All freestanding water shall be removed prior to concrete placement. Concrete placement shall begin within 24 hours of the completion of deck preparation for the portion of the deck to be overlaid. If concrete placement has not begun within 24 hours, the lane or strip being overlaid shall be cleaned by a light sand blasting followed by washing with the high-pressure water spray or by cleaning with the high-pressure spray.

Traffic other than required construction equipment will not be permitted on any portion of the lane or strip being overlaid that has undergone final preparation for placing concrete unless allowed by the Engineer. To prevent contamination, all equipment allowed on the deck after final cleaning shall be equipped with drip guards.

6-09.3(8) Quality Assurance

6-09.3(8)A Quality Assurance for Microsilica Modified and Fly Ash Modified Concrete Overlays

The Engineer will perform slump, temperature, and entrained air tests for acceptance in accordance with Section 6-02.3(5)D and as specified in this section after the Contractor has turned over the concrete for acceptance testing. Concrete samples for testing shall be supplied to the Engineer in accordance with Section 6-02.3(5)E. Concrete from the first truckload shall not be placed until tests for acceptance have been completed by the Engineer and the results indicate that the concrete is within acceptable limits. Sampling and testing will continue for each load until two successive loads meet all applicable acceptance test requirements. Except for the first load of concrete, up to ½ cubic yard may be placed prior to testing for acceptance. After two successive tests indicate that the concrete is within specified limits, the sampling and testing frequency may decrease to one for every three truckloads. Loads to be sampled will be selected in accordance with the random selection process outlined in FOP for WAQTC TM2.

When the results of any subsequent acceptance test indicates that the concrete does not conform to the specified limits, the sampling and testing frequency will be resumed for each truckload. Whenever two successive subsequent tests indicate that the concrete is within the specified limits, the random sampling and testing frequency of one for every three truck loads may resume.

6-09.3(8)B Quality Assurance for Latex Modified Concrete Overlays

The Engineer will perform slump, temperature, and entrained air tests for acceptance in accordance with Section 6-02.3(5)D and as specified in this section after the Contractor has turned over the concrete for acceptance testing. The Engineer will perform testing as the concrete is being placed. Samples shall be taken on the first charge through each mobile mixer and every other charge thereafter. The sample shall be taken after the first 2 minutes of continuous mixer operation. Concrete samples for testing shall be supplied to the Engineer in accordance with Section 6-02.3(5)E.

During the initial proportioning, mixing, placing, and finishing operations, the Engineer may require the presence of a technical representative from the latex admixture manufacturer. The technical representative shall be capable of performing, demonstrating, inspecting, and testing all of the functions required for placement of the latex modified concrete as specified in Section 6-09.3(11). This technical representative shall aid in the proper installation of the latex modified concrete. Recommendations made by the technical representative on or off the jobsite shall be adhered to by the Contractor. The Engineer will advise the Contractor in writing a minimum of 5 working days before such services are required.

6-09.3(9) Mixing Concrete For Concrete Overlay

6-09.3(9)A Mixing Microsilica Modified or Fly Ash Modified Concrete

Mixing of concrete shall be in accordance with Section 6-02, with the following exceptions:

1. The mixing shall be done at a batch plant.
2. The volume of concrete transported by truck shall not exceed 6-cubic yards per truck.

6-09.3(9)B Mixing Latex Modified Concrete

The equipment used for mixing the concrete shall be operated with strict adherence to the procedures set forth by its manufacturer.

A minimum of two mixers will be required at the overlay site for each concrete placement when the total volume of concrete to be placed during the concrete placement exceeds the material storage capacity of a single mixer. Additional mixers may be required if conditions require that material be stockpiled away from the jobsite. The Contractor shall have sufficient mixers on hand to ensure a consistent and continuous delivery and placement of concrete throughout the concrete placement.

Charging the mobile mixer shall be done in the presence of the Engineer. Mixing capabilities shall be such that the finishing operation can proceed at a steady pace.

6-09.3(10) Overlay Profile and Screed Rails

6-09.3(10)A Survey of Existing Bridge Deck Prior to Scarification

Prior to beginning the scarifying concrete surface finish work specified under Section 6-09.3(5), the Contractor shall complete a survey of the existing bridge deck(s) specified to receive modified concrete overlay for use in establishing the existing cross section and grade profile elevations.

The Contracting Agency will provide the Contractor with primary survey control information consisting of descriptions of two primary control points used for the horizontal and vertical control. Primary control points will be described by reference to the bridge or project-specific stationing and elevation datum. The Contracting Agency will also provide horizontal coordinates for the beginning and ending points and for

each Point of Intersection (PI) on each centerline alignment included in the project. The Contractor shall provide the Engineer 21 calendar days notice in advance of scheduled concrete surface scarification work to allow the Contracting Agency time to provide the primary survey control information.

The Contractor shall verify the primary survey control information furnished by the Contracting Agency and shall expand the survey control information to include secondary horizontal and vertical control points as needed for the project. The Contractor's survey records shall include descriptions of all survey control points, including coordinates and elevations of all secondary control points.

The Contractor shall maintain detailed survey records, including a description of the work performed on each shift, the methods utilized to conduct the survey, and the control points used. The record shall be of sufficient detail to allow the survey to be reproduced. A Type 1 Working Drawing of each day's survey record shall be provided to the Engineer within 3 working days after the end of the shift. The Contractor shall compile the survey information in an electronic file format acceptable to the Contracting Agency (Excel spreadsheet format is preferred).

Survey information collected shall include station, offset, and elevation for each lane line and curb line. Survey information shall be collected at even 20-foot station intervals and also at the centerline of each bridge expansion joint. The Contractor shall ensure a surveying accuracy to within ± 0.01 feet for vertical control and ± 0.2 feet for horizontal control. The survey shall extend 100 feet beyond the bridge back of pavement seat.

Except for the primary survey control information furnished by the Contracting Agency, the Contractor shall be responsible for all calculations, surveying, and measuring required for setting, maintaining, and resetting equipment and materials necessary for the construction of the overlay to the final grade profile. The Contracting Agency may post-check the Contractor's surveying, but these post-checks shall not relieve the Contractor of responsibility for internal survey quality control.

The Contracting Agency will establish the final grade profile based on the Contractor's survey, and will provide the final grade profile to the Contractor within three working days after receiving the Contractor's survey information.

The Contractor shall not begin scarifying concrete surface work specified under Section 6-09.3(5) until receiving the final grade profile from the Engineer.

6-09.3(10)B Establishing Finish Overlay Profile

The finish grade profile shall be + ¼ inch/- ⅛ inch from the Engineer's final grade profile. The final grade profile shall be verified prior to the placement of modified concrete overlay with the screed rails in place. The finishing machine shall be passed over the entire surface to be overlaid and the final screed rail adjustments shall be made. If the resultant overlay thickness is not compatible with the finish grade profile generated by the Contractor's screed rail setup, the Contractor shall make profile adjustments as specified by the Engineer. After the finish overlay profile has been verified, changes in the finishing machine elevation controls will not be allowed. The Contractor shall be

responsible for setting screed control to obtain the specified finish grade overlay profile as well as the finished surface smoothness requirements specified in Section 6-02.3(10).

Screed rails upon which the finishing machine travels shall be placed outside the area to be overlaid, in accordance with item 7 of Section 6-09.3(2). Interlocking rail sections or other approved methods of providing rail continuity are required.

Hold-down devices shot into the concrete are not permitted unless the concrete is to be subsequently overlaid. Hold-down devices of other types leaving holes in the exposed area will be allowed provided the holes are subsequently filled with mortar conforming to Section 9-20.4(2) mixed at a 1:2 cement/aggregate ratio. Hold-down devices shall not penetrate the existing deck by more than ¾ inch.

Screed rails may be removed at any time after the concrete has taken an initial set. Adequate precautions shall be taken during the removal of the finishing machine and rails to protect the edges of the new surfaces.

6-09.3(11) Placing Concrete Overlay

Five to ten working days prior to modified concrete overlay placement, a preoverlay conference shall be held to discuss equipment, construction procedures, personnel, and previous results. Inspection procedures shall also be reviewed to ensure coordination. Those attending representing the Contractor shall include the superintendent and all foremen in charge of placing and finishing the modified concrete overlay.

If the project includes more than one bridge deck, an additional conference shall be held just before placing modified concrete overlay for each subsequent bridge deck.

The Contractor shall not place modified concrete overlay until the Engineer agrees that:

1. Modified concrete overlay producing and placement rates will be high enough to meet placing and finishing deadlines,
2. Finishers with enough experience have been employed, and
3. Adequate finishing tools and equipment are at the site.

Concrete placement shall be made in accordance with Section 6-02 and the following requirements:

1. After the lane or strip to be overlaid has been prepared and immediately before placing the concrete, it shall be thoroughly soaked and kept continuously wet with water for a minimum period of 6 hours prior to placement of the concrete. All freestanding water shall be removed prior to concrete placement. During concrete placement, the lane or strip shall be kept moist.

   The concrete shall then be promptly and continuously delivered and deposited on the placement side of the finishing machine.

If latex modified concrete is used, the concrete shall be thoroughly brushed into the surface and then brought up to final grade. If either microsilica modified concrete or fly ash modified concrete are used, a slurry of the concrete, excluding aggregate, shall be thoroughly brushed into the surface prior to the overlay placement.

Care shall be exercised to ensure that the surface receives a thorough, even coating and that the rate of progress is limited so that the brushed concrete does not become dry before it is covered with additional concrete as required for the final grade. All aggregate which is segregated from the mix during the brushing operation shall be removed from the deck and disposed of by the Contractor.

If either microsilica modified concrete or fly ash modified concrete are used, the Contractor shall ensure that a sufficient number of trucks are used for concrete delivery to obtain a consistent and continuous delivery and placement of concrete throughout the concrete placement operation.

When concrete is to be placed against the concrete in a previously placed transverse joint, lane, or strip, the previously placed concrete shall be sawed back 6 inches to straight and vertical edges and shall be sandblasted or water blasted before new concrete is placed. The Engineer may decrease the 6 inch saw back requirement to 2 inches minimum, if a bulkhead was used during previous concrete placement and the concrete was hand vibrated along the bulkhead.

2. Concrete placement shall not begin if rain is expected. Adequate precautions shall be taken to protect freshly placed concrete in the event that rain begins during placement. Concrete that is damaged by rain shall be removed and replaced by the Contractor at no additional expense to the Contracting Agency, and to the satisfaction of the Engineer.

3. Concrete shall not be placed when the temperature of the concrete surface is less than 45°F or greater than 75°F, and wind velocity one foot above the bridge deck is in excess of 10 mph. If the Contractor elects to Work at night to meet these criteria, adequate lighting shall be provided at no additional expense to the Contracting Agency.

4. If concrete placement is stopped for a period of ½ hour or more, the Contractor shall install a bulkhead transverse to the direction of placement at a position where the overlay can be finished full width up to the bulkhead. The bulkhead shall be full depth of the overlay and shall be installed to grade. The concrete shall be finished and cured in accordance with these Specifications.

   Further placement is permitted only after a period of 12 hours unless a gap is left in the lane or strip. The gap shall be of sufficient width for the finishing machine to clear the transverse bulkhead installed where concrete placement was stopped. The previously placed concrete shall be sawed back from the bulkhead, to a point designated by the Engineer, to straight and vertical edges and shall be sandblasted or water blasted before new concrete is placed.

5. Concrete shall not be placed against the edge of an adjacent lane or strip that is less than 36 hours old.

6-09.3(12) Finishing Concrete Overlay

Finishing shall be accomplished in accordance with the applicable portions of Section 6-02.3(10) and as follows. Concrete shall be placed and struck-off approximately ½ inch above final grade and then consolidated and finished to final grade with a single pass (the Engineer may require additional passes) of the finishing machine. Hand finishing may be necessary to close up or seal off the surface. The final product shall be a dense uniform surface.

Latex shall not be sprayed on a freshly placed latex modified concrete surface; however, a light fog spray of water is permitted if required for finishing, as determined by the Engineer.

Construction dams shall be separated from the newly placed concrete by passing a pointing trowel along the inside surfaces of the dams. Care shall be exercised to ensure that this trowel cut is made for the entire depth and length of the dams after the concrete has stiffened sufficiently that it does not flow back.

6-09.3(13) Curing Concrete Overlay

As the finishing operation progresses, the concrete shall be immediately covered with a single layer of clean, new or used, wet burlap. The burlap shall have a maximum width of 6 feet. The Engineer will determine the suitability of the burlap for reuse, based on the cleanliness and absorption ability of the burlap. Care shall be exercised to ensure that the burlap is well drained and laid flat with no wrinkles on the deck surface. Adjacent strips of burlap shall have a minimum overlap of 6 inches.

Once in place the burlap shall be lightly fog sprayed with water. A separate layer of white, reflective type polyethylene sheeting shall immediately be placed over the wet burlap.

As an alternative to the application of burlap and fog spraying described above, the Contractor may propose a curing system using proprietary curing blankets specifically manufactured for bridge deck curing. The Contractor shall submit a Type 2 Working Drawing consisting of details of the proprietary curing blanket system, including product literature and details of how the system is to be installed and maintained.

The wet curing regimen as described shall remain in place for a minimum of 42-hours.

6-09.3(14) Checking for Bond

After the requirements for curing have been met, the entire overlaid surface shall be sounded by the Contractor in accordance with ASTM D4580, in a manner accepted by and in the presence of the Engineer, to ensure total bond of the concrete to the bridge deck. Concrete in unbonded areas shall be removed and replaced by the Contractor at no additional expense to the Contracting Agency, in accordance with Section 6-09.3(6) except as modified here.

Saw cut the edges around the repair area with an edge perpendicular to the concrete surface. The depth of the saw cut shall be ¾ inch, but shall be reduced if necessary to avoid damaging any reinforcement. The geometry of the repair perimeter shall be

rectangular, avoiding reentrant corners. All concrete in the removal area shall be removed by chipping, or other approved mechanical means to the depth necessary to remove all loose or unsound concrete. All removal shall maintain square edges at the boundaries of the repair area. Concrete for patching shall be the same modified concrete as used in the overlay.

The repair area shall be wet cured for 42 hours in accordance with Section 6-09.3(13). After curing requirements have been met, all repaired areas shall be sounded by the Contractor in accordance with this section.

6-09.3(15) Sealing and Texturing Concrete Overlay

After the requirements for checking for bond have been met, all joints and visible cracks shall be filled and sealed with a high molecular weight methacrylate resin (HMWM). Cracks 1⁄16 inch and greater in width shall receive two applications of HMWM. Immediately following the application of HMWM, the wetted surface shall be coated with sand for abrasive finish.

After all cracks have been filled and sealed and the HMWM resin has cured, the concrete overlay surface shall receive a longitudinally sawn texture in accordance with Section 6-02.3(10)D5.

Traffic shall not be permitted on the finished concrete until it has reached a minimum compressive strength of 3,000 psi as verified by rebound number determined in accordance with ASTM C805 and the longitudinally sawn texture is completed.

6-09.4 Measurement

Scarifying concrete surface will be measured by the square yard of surface actually scarified.

Modified concrete overlay will be measured by the cubic foot of material placed. For latex modified concrete overlay, the volume will be determined by the theoretical yield of the design mix and documented by the counts of the cement meter less waste. For both microsilica modified concrete overlay and fly ash modified concrete overlay, the volume will be determined from the concrete supplier's Certificate of Compliance for each batch delivered less waste. Waste is defined as the following:

1. Material not placed.
2. Material placed in excess of 6 inches outside a longitudinal joint or transverse joint.

Finishing and curing modified concrete overlay will be measured by the square yard of overlay surface actually finished and cured.

Further deck preparation for Type 1 deck repair and for Type 2 deck repair will be measured by the square foot of surface area of deck concrete removed in accordance with Section 6-09.3(6).

6-09.5 Payment

Payment will be made for each of the following Bid items that are included in the Bid Proposal:

"Scarifying Conc. Surface", per square yard.

The unit Contract price per square yard for "Scarifying Conc. Surface" shall be full pay for performing the Work as specified, including testing and calibration of the machines and tools used, containment, collection, and disposal of all water and abrasives used and debris created by the scarifying operation, measures taken to protect adjacent traffic from flying debris, and final cleanup following the scarifying operation.

"Modified Conc. Overlay", per cubic foot.

The unit contract price per cubic foot for "Modified Conc. Overlay" shall be full pay for furnishing the modified concrete overlay, including the overlay material placed into Type 1 deck repairs in accordance with Section 6-09.3(6)C.

"Finishing and Curing Modified Conc. Overlay", per square yard.

The unit Contract price per square yard for "Finishing and Curing Modified Conc. Overlay" shall be full pay for performing the Work as specified, including placing, finishing, and curing the modified concrete overlay, checking for bond, and sealing all cracks.

"Further Deck Preparation for Type 1 Deck Repair", per square foot.

"Further Deck Preparation for Type 2 Deck Repair", per square foot.

"Structure Surveying", lump sum.

The lump sum contract price for "Structure Surveying" shall be full pay to perform the work as specified, including establishing secondary survey control points, performing survey quality control, and recording, compiling, and submitting the survey records to the Engineer.

6-10 Concrete Barrier

6-10.1 Description

This section applies to building precast or cast-in-place cement concrete barriers as required by the Plans, these Specifications, or the Engineer.

This Work may also include the removal, storage and resetting of permanent barrier at the locations shown in the Plans or as specified by the Engineer.

6-10.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates	9-03
Premolded Joint Fillers	9-04.1
Reinforcing Steel	9-07
Grout	9-20.3

Wire rope shall be Class 6 × 19, made of improved plow steel that has been galvanized and preformed. Galvanizing shall meet ASTM A603. The wire rope shall have right regular lay and a fiber core. It shall be ⅝ inch in diameter and have a minimum breaking strength of 15 tons.

All hardware (connecting pins, drift pins, nuts, washers, etc.) shall be galvanized in accordance with AASHTO M 232.

Connecting pins, drift pins and steel pins for type 3 anchors shall conform to Section 9-06.5(4) and be galvanized in accordance with AASHTO M232. All other hardware shall conform to Section 9-06.5(1) and be galvanized in accordance with AASHTO M232.

Grout for permanent installations of precast single slope barrier shall conform to Section 9-20.3(3) and shall be placed in accordance with Section 6-02.3(20).

6-10.3 Construction Requirements

Single slope barrier shall be cast-in-place or slipformed, except when precast single slope barrier is specified in the Plans or specified by the Engineer. Concrete barrier installed in conjunction with light standard foundations and sign bridge foundations, regardless of the barrier shape, shall be cast-in-place using stationary forms.

Concrete barrier transition Type 2 to bridge f-shape shall be precast.

Steel welded wire reinforcement deformed, conforming to Section 9-07.7, may be substituted in concrete barrier in place of deformed steel bars conforming to Section 9-07.2, subject to the following conditions:

1. Steel welded wire reinforcement spacing shall be the same as the deformed steel bar spacing shown in the Standard Plans.

2. The minimum cross sectional area for steel welded wire reinforcement shall be no less than 86 percent of the cross sectional area for the deformed steel bars being substituted.
3. Development lengths and splice lengths shall conform to requirements specified in the AASHTO *LRFD Bridge Design Specifications*, current edition.

6-10.3(1) Precast Concrete Barrier

Precast concrete barrier shall meet all the requirements in Section 6-02.3(9), except as modified in this section.

Test results from the QC testing shall demonstrate compliance with Sections 6-02.3(4)C consistency, 6-02.3(4)D temperature and time of placement, 6-02.3(2)A air content, and compressive strength. All tests will be conducted in accordance with Section 6-02.3(5)D.

The QC tester conducting the sampling and testing shall be qualified by ACI, Grade I to perform this Work. The equipment used shall be calibrated/certified annually.

All test results and certifications shall be kept at the fabricator's facility for review by the Contracting Agency.

The Contracting Agency intends to perform Quality Assurance Inspection. This inspection is for the qualification of the plant QC process. This inspection shall not relieve the Contractor of any responsibility for identifying and replacing defective material and workmanship.

The concrete in precast barrier shall be Class 5000 for Type F and Class 4000 for all other precast barriers, and comply with the provisions of Section 6-02.3. No concrete barrier shall be shipped until test cylinders made of the same concrete and cured under the same conditions show the concrete has reached the specified 28 day compressive strength.

The Contractor may use Type III portland cement, but shall bear any added cost.

Precast barrier shall be cast in steel forms. After release, the barrier shall be finished to an even, smooth, dense surface, free from any rock pockets or holes larger than ¼ inch across. Troweling shall remove all projecting concrete from the bearing surface.

If heat curing methods are used, precast concrete barrier shall be cured in accordance with Section 6-02.3(25)D except that the barrier shall be cured in the forms until a rebound number test, or test cylinders which have been cured under the same conditions as the barrier, indicate the concrete has reached a compressive strength of a least 70% of the specified 28 day compressive strength. No additional curing is required once the barrier is removed from the forms.

The barrier shall be precast in sections as the *Standard Plans* require. All barrier in the same project (except end sections and variable length units needed for closure) shall be the same length. All barrier shall be new and unused. It shall be true to Plan dimensions. The manufacturer shall be responsible for any damage or distortion that results from manufacturing.

Only one section less than 20 feet long for single slope barrier and 10 feet long for all other barriers may be used in any single run of precast barrier, and it shall be at least 8 feet long. It may be precast or cast-in-place. Hardware identical to that used with other sections shall interlock such a section with adjacent precast sections.

Barrier connection voids for permanent installations of precast single slope barrier shall be filled with grout.

6-10.3(2) Cast-In-Place Concrete Barrier

Forms for cast-in-place concrete barrier, including traffic barrier, traffic-pedestrian barrier, and pedestrian barrier on bridges and related Structures, shall be made of steel or exterior plywood coated with plastic. The Contractor may construct the barrier by the slip-form method.

The barrier shall be made of Class 4000 concrete that meets the requirements of Section 6-02, except that the fine aggregate gradation used for slip-form barrier may be either Class 1 or 2. The Contractor may use portland cement Type III at no additional expense to the Contracting Agency.

In addition to the steel reinforcing bar tying and bracing requirements specified in Section 6-02.3(24) C, the Contractor may also place small amounts of concrete to aid in holding the steel reinforcing bars in place. These small amounts of concrete shall be not more than 2-cubic feet in volume, and shall be spaced at a minimum of 10-foot intervals within the steel reinforcement cage. These small amounts of concrete shall be consolidated and shall provide 2 inches minimum clearance to the steel reinforcing bars on the outside face of the barrier. All spattered and excess mortar and concrete shall be removed from the steel reinforcing bars prior to slip-form casting.

Barrier expansion joints shall be spaced at 96-foot intervals, and dummy joints shall be spaced at 12-foot intervals unless otherwise specified in the Contract.

Immediately after removing the forms, the Contractor shall complete any finishing Work needed to produce a uniformly smooth, dense surface. The surface shall have no rock pockets and no holes larger than ¼ inch across. The barrier shall be cured and finished in accordance with Section 6-02.3(11)A.

The maximum allowable deviation from a 10-foot straightedge held longitudinally on all surfaces shall be ¼ inch. For single sloped barrier the maximum allowable deviation from a straightedge held along the vertical sloped face of the barrier shall be ¼ inch.

At final acceptance of the project, the barrier shall be free from stains, smears, and any discoloration.

6-10.3(3) Removing and Resetting Permanent Concrete Barrier

The Contractor shall reset concrete barrier if the Plans or the Engineer require. If resetting is impossible immediately after removal, the Contractor shall store the barrier at Engineer-approved locations.

6-10.3(4) Joining Precast Concrete Barrier to Cast-In-Place Barrier

The Contractor may join segments of cast-in-place barrier to precast barrier where transitions, split barriers, or gaps shorter than 10 feet require it. At each joint of this type, the cast-in-place segment shall include hardware that ties both its ends to abutting precast sections.

6-10.3(5) Temporary Barrier

For temporary barrier, the Contractor may use precast concrete barrier or temporary steel barrier. If temporary steel barrier is selected, the Contractor shall verify the lateral deflection distance meets or is less than what is shown in the Contract Plans. Temporary concrete barrier shall comply with Standard Plan requirements and cross-sectional dimensions, except that: (1) it may be made in other lengths than those shown in the Standard Plan, and (2) it may have permanent lifting holes no larger than 4 inches in diameter or lifting loops. Temporary steel barrier shall be certified that it meets the requirements of NCHRP 350 or MASH Test Level 3 or 4 as specified in Section 1-10.2(3). Temporary steel barrier shall be installed in accordance with the manufacturer's recommendations.

If the Contract calls for the removal and resetting of permanent barrier, and the permanent barrier is not required to remain in place until reset, the permanent barrier may be substituted for temporary concrete barrier. Any of the permanent barrier damaged during its use as temporary barrier will become the property of the Contractor and be replaced with permanent barrier when the permanent barrier is reset to its permanent location.

All barrier shall be in good condition, without cracks, chips, spalls, dirt, or traffic marks. If any barrier segment is damaged during or after placement, the Contractor shall immediately repair it to the Engineer's satisfaction or replace it with an undamaged section.

Delineators shall be placed on the traffic face of the barrier 6 inches from the top and spaced a maximum of 40 feet on tangents and 20 feet through curves. The reflector color shall be white on the right side of traffic and yellow on the left side of traffic. The Contractor shall maintain, replace and clean the delineators when ordered by the Engineer.

As soon as the temporary barrier is no longer needed, the Contractor shall remove it from the project. Contracting Agency furnished barrier shall remain Contracting Agency property, and the Contractor shall deliver it to a stockpile site noted in the Contract or to locations as approved by the Engineer. Contractor furnished barrier shall remain the property of the Contractor.

6-10.3(6) Placing Concrete Barrier

Precast concrete barrier Type F, Types 2 and 4, precast single slope barrier, and transitions shall rest on a paved foundation shaped to a uniform grade and section. The foundation surface for precast concrete barrier Type F, Types 2 and 4, precast single slope barrier, and transitions shall meet this test for uniformity: When a 10-foot straightedge is placed on the surface parallel to the centerline for the barrier, the surface shall not vary more than ¼ inch from the lower edge of the straightedge. If deviations exceed ¼ inch, the Contractor shall correct them as required in Section 5-04.3(13).

The Contractor shall align the joints of all precast segments so that they offset no more than ¼ inch transversely and no more than ¾ inch vertically. Grouting is not permitted, except as previously stated for single slope barrier. If foundation grade and section are acceptable, the Engineer may permit the Contractor to obtain vertical alignment of the barrier by shimming. Shimming shall be done with a polystyrene, foam pad (12 by 24 inches) under the end 12 inches of bearing surface.

Precast barrier shall be handled and placed with equipment that will not damage or disfigure it.

6-10.4 Measurement

Precast concrete barrier will be measured by the linear foot along its completed line and slope.

Temporary barrier will be measured by the linear foot along the completed line and slope of the barrier, one time only for each setup of barrier protected area. Any intermediate moving or resetting will not be measured.

Cast-in-place concrete barrier will be measured by the linear foot along its completed line unless the Contract specifies that it be measured per cubic yard for concrete Class 4000 and per pound for steel reinforcing bar (as required in Section 6-02.4).

Cast-in-place concrete barrier light standard section will be measured by the unit for each light standard section installed.

Removing and resetting existing permanent barrier will be measured by the linear foot and will be measured one time only for removing, storage, and resetting. No measure will be made for barrier that has been removed and reset for the convenience of the Contractor.

Concrete barrier transition Type 2 to bridge F-shape will be measured by the linear foot installed.

Single slope concrete barrier light standard foundation will be measured by the unit for each light standard foundation installed.

Traffic barrier, traffic pedestrian barrier, and pedestrian barrier will be measured as specified for cast-in-place concrete barrier.

6-10.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Precast Conc. Barrier Type ____", per linear foot.

"Precast Conc. Barrier Type F Unanchored", per linear foot.

"Precast Conc. Barrier Type F Anchored", per linear foot.

"Cast-In-Place Conc. Barrier", per linear foot.

"Conc. Class 4000 _____", per cubic yard.

"St. Reinf. Bar _____", per pound.

"Removing and Resetting Existing Permanent Barrier", per linear foot.

The unit Contract price per linear foot for "Cast-In-Place Conc. Barrier" shall be full pay for excavation, forms, placement, special construction features, and all other materials, tools, equipment, and labor necessary to complete the Work as specified; except that when the Contract specifies, the unit Contract price per cubic yard for "Conc. Class 4000 _____" and the per pound for "St. Reinf. Bar _____", shall be full pay for excavation, forms, placement, special construction features, and all other materials, tools, equipment, and labor necessary to complete the Work as specified.

"Traffic Barrier", per linear foot.

"Traffic Pedestrian Barrier", per linear foot.

"Pedestrian Barrier" per linear foot.

The unit Contract price per linear foot for "Traffic Barrier", "Traffic Pedestrian Barrier", and "Pedestrian Barrier" shall be full pay for constructing the barrier on top of the bridge deck, and associated bridge approach slabs, curtain walls and wingwalls, excluding the steel reinforcing bars that extend from the bridge deck, bridge approach slab, curtain walls, and wingwalls.

"Single Slope Concrete Barrier", per linear foot.

The unit Contract price per linear foot for "Single Slope Concrete Barrier" shall be full pay for either cast-in-place or precast single slope concrete barrier.

"Conc. Barrier Transition Type 2 to Bridge F-Shape", per linear foot.

The unit Contract price per linear foot for "Conc. Barrier Transition Type 2 to Bridge F-Shape" shall be full pay for performing the Work as specified, excluding bridge traffic barrier modifications necessary for this installation.

"Single Slope Conc. Barrier Light Standard Foundation", per each.

"Cast-In-Place Conc. Barrier Light Standard Section", per each.

"Temporary Barrier", per linear foot.

The unit Contract price per linear foot for “Temporary Barrier” shall be full pay for all costs, including furnishing, installing, connecting, anchoring, maintaining, temporary storage, and final removal of the temporary barrier.

Payment for transition sections between different types of barrier shall be made at the unit Contract price for the type of barrier indicated in the Plans for each transition section.

6-11 Reinforced Concrete Walls

6-11.1 Description

This Work consists of constructing reinforced concrete retaining walls, including those shown in the *Standard Plans*, L walls, and counterfort walls.

6-11.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Gravel Backfill	9-03.12
Premolded Joint Filler	9-04.1(2)
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Concrete Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Water	9-25

Other materials required shall be as specified in the Special Provisions.

6-11.3 Construction Requirements

6-11.3(1) Submittals

The Contractor shall submit Type 2E Working Drawings consisting of excavation shoring plans in accordance with Section 2-09.3(3)D.

The Contractor shall submit Type 2E Working Drawings of falsework and formwork plans in accordance with Sections 6-02.3(16) and 6-02.3(17).

If the Contractor elects to fabricate and erect precast concrete wall stem panels, Type 2E Working Drawings of the following information shall be submitted in accordance with Section 6-02.3(9)A:

1. Working drawings for fabrication of the wall stem panels, showing dimensions, steel reinforcing bars, joint and joint filler details, surface finish details, lifting devices with the manufacturer's recommended safe working capacity, and material Specifications.
2. Working drawings and design calculations for the erection of the wall stem panels showing dimensions, support points, support footing sizes, erection blockouts, member sizes, connections, and material Specifications.
3. Design calculations for the precast wall stem panels, the connection between the precast panels and the cast-in-place footing, and all modifications to the cast-in-place footing details as shown in the Plans or *Standard Plans*.

6-11.3(2) Excavation and Foundation Preparation

Excavation shall conform to Section 2-09.3(3), and to the limits and construction stages shown in the Plans. Foundation soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C.

6-11.3(3) Precast Concrete Wall Stem Panels

The Contractor may fabricate precast concrete wall stem panels for construction of Standard Plan Retaining Walls. Precast concrete wall stem panels may be used for construction of non-Standard Plan retaining walls if allowed by the Plans or Special Provisions. Precast concrete wall stem panels shall conform to Section 6-02.3(9) except as modified in this Section, and shall be cast with Class 4000 concrete.

The precast concrete wall stem panels shall be designed in accordance with the following codes:

1. For all loads except as otherwise noted – AASHTO *LRFD Bridge Design Specifications*, latest edition and current interims. The seismic design shall use the acceleration coefficient and soil profile type as specified in the Plans.
2. For all wind loads – AASHTO Guide Specifications for Structural Design of Sound Barriers, latest edition and current interims.

The precast concrete wall stem panels shall be fabricated in accordance with the dimensions and details shown in the Plans, except as modified in the shop drawings.

The precast concrete wall stem panels shall be fabricated full height, and shall be fabricated in widths of 8, 16, and 24 feet.

The construction tolerances for the precast concrete wall stem panels shall be as follows:

Height	±¼ inch
Width	±¼ inch
Thickness	+¼ inch
	-⅛ inch
Concrete cover for steel reinforcing bar	+⅜ inch
	-⅛ inch
Width of precast concrete wall stem panel joints	±¼ inch
Offset of precast concrete wall stem panels	±¼ inch
(Deviation from a straight line extending 5 feet on each side of the panel joint)	

The precast concrete wall stem panels shall be constructed with a mating shear key between adjacent panels. The shear key shall have beveled corners and shall be 1½ inches in thickness. The width of the shear key shall be 3½ inches minimum and 5½ inches maximum. The shear key shall be continuous and shall be of uniform width over the entire height of the wall stem.

The Contractor shall provide the specified surface finish as noted, and to the limits shown, in the Plans to the exterior concrete surfaces. Special surface finishes achieved with form liners shall conform to Sections 6-02.2 and 6-02.3(14) as supplemented in the

Special Provisions. Rolled on textured finished shall not be used. Precast concrete wall stem panels shall be cast in a vertical position if the Plans call for a form liner texture on both sides of the wall stem panel.

The precast concrete wall stem panel shall be rigidly held in place during placement and curing of the footing concrete.

The precast concrete wall stem panels shall be placed a minimum of 1 inch into the footing to provide a shear key. The base of the precast concrete wall stem panel shall be sloped ½ inch per foot to facilitate proper concrete placement.

To ensure an even flow of concrete under and against the base of the wall panel, a form shall be placed parallel to the precast concrete wall stem panel, above the footing, to allow a minimum 1-foot head to develop in the concrete during concrete placement.

The steel reinforcing bars shall be shifted to clear the erection blockouts in the precast concrete wall stem panel by 1½ inches minimum.

All precast concrete wall stem panel joints shall be constructed with joint filler installed on the rear (backfill) side of the wall. The joint filler material shall extend from 2 feet below the final ground level in front of the wall to the top of the wall. The joint filler shall be a nonorganic flexible material and shall be installed to create a waterproof seal at panel joints.

The soil bearing pressure beneath the falsework supports for the precast concrete wall stem panels shall not exceed the maximum design soil pressure shown in the Plans for the retaining wall.

6-11.3(4) Cast-In-Place Concrete Construction

Cast-in-place concrete for concrete retaining walls shall be formed, reinforced, cast, cured, and finished in accordance with Section 6-02, and the details shown in the Plans and *Standard Plans*. All cast-in-place concrete shall be Class 4000. Cast-in-place footings shall have a longitudinal slope no steeper than 1V: 6H, unless otherwise shown in the Plans or Standard Plans.

The Contractor shall provide the specified surface finish as noted, and to the limits shown, in the Plans to the exterior concrete surfaces. Special surface finishes achieved with formliners shall conform to Sections 6-02.2 and 6-02.3(14) as supplemented in the Special Provisions.

Cast-in-place concrete for adjacent wall stem sections (between vertical expansion joints) shall be formed and placed separately, with a minimum 12-hour time period between concrete placement operations.

Premolded joint filler, ½ inch thick, shall be placed full height of all vertical wall stem expansion joints in accordance with Section 6-01.14.

6-11.3(5) Backfill, Weepholes, and Gutters

Unless the Plans specify otherwise, backfill and weepholes shall be placed in accordance with the *Standard Plans* and Section 6-02.3(22). Gravel backfill for drain shall be compacted in accordance with Section 2-09.3(1)E. Backfill within the zone defined as Bridge Approach Embankment in Section 1-01.3 shall be compacted in accordance with Method C of Section 2-03.3(14)C. All other backfill shall be compacted in accordance with Method B of Section 2-03.3(14)C, unless otherwise specified.

Cement concrete gutter shall be constructed as shown in the *Standard Plans*.

6-11.3(6) Traffic Barrier and Pedestrian Barrier

When shown in the Plans, traffic barrier and pedestrian barrier shall be constructed in accordance with Sections 6-02.3(11)A and 6-10.3(2), and the details shown in the Plans and *Standard Plans*.

6-11.4 Measurement

Concrete Class 4000 for retaining wall will be measured as specified in Section 6-02.4. Steel reinforcing bar for retaining wall and epoxy-coated steel reinforcing bar for retaining wall will be measured as specified in Section 6-02.4.

Traffic barrier and pedestrian barrier will be measured as specified in Section 6-10.4 for cast-in-place concrete barrier.

6-11.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Conc. Class 4000 For Retaining Wall", per cubic yard.

All costs in connection with furnishing and installing weep holes and premolded joint filler shall be included in the unit Contract price per cubic yard for "Conc. Class 4000 for Retaining Wall".

"St. Reinf. Bar For Retaining Wall", per pound.

"Epoxy-Coated St. Reinf. Bar For Retaining Wall", per pound.

"Traffic Barrier", per linear foot.

"Pedestrian Barrier", per linear foot.

The unit Contract price per linear foot for "___ Barrier" shall be full pay for constructing the barrier on top of the retaining wall, except that when these Bid items are not included in the Proposal, all costs in connection with performing the Work as specified shall be included in the unit Contract price per cubic yard for "Conc. Class 4000 For Retaining Wall", and the unit Contract price per pound for "___ Bar For Retaining Wall".

6-12 Noise Barrier Walls

6-12.1 Description

This Work consists of constructing cast-in-place concrete, precast concrete, masonry, and timber noise barrier walls, including those shown in the *Standard Plans*.

6-12.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Gravel Backfill	9-03.12
Premolded Joint Filler	9-04.1(2)
Bolts, Nuts, and Washers	9-06.5(1)
Noise Barrier Wall Access Door	9-06.17
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Paints	9-08
Grout	9-20.3
Concrete Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Water	9-25

Other materials required shall be as specified in the Special Provisions.

6-12.3 Construction Requirements

6-12.3(1) Submittals

All noise barrier walls not constructed immediately adjacent to the Roadway, and that require construction of access for Work activities, shall have a noise barrier wall access plan. The Contractor shall submit a Type 2 Working Drawing consisting of the noise barrier wall access plan. The noise barrier wall access plan shall include, but not be limited to, the locations of access to the noise barrier wall construction sites, and the method, materials, and equipment used to construct the access, remove the access, and recontour and reseed the disturbed ground.

For construction of all noise barrier walls with shafts, the Contractor shall submit a Type 2 Working Drawing consisting of the shaft construction plan, including at a minimum the following information:

1. List and description of equipment to be used to excavate and construct the shafts, including description of how the equipment is appropriate for use in the expected subsurface conditions.
2. The construction sequence and order of shaft construction.

3. Details of shaft excavation methods, including methods to clean the shaft excavation.
4. Details and dimensions of the shaft, and casing if used.
5. The method used to prevent ground caving (temporary casing, slurry, or other means).
6. Details of concrete placement including procedures for deposit through a conduit, tremie, or pump.
7. Method and equipment used to install and support the steel reinforcing bar cage.

For construction of precast concrete noise barrier walls, the Contractor shall submit Type 2 Working Drawings consisting of shop drawings for the precast concrete panels in accordance with Section 6-02.3(9)A. In addition to the items listed in Section 6-02.3(9)A, the precast concrete panel shop drawings shall include the following:

1. Construction sequence and method of forming the panels.
2. Details of additional reinforcement provided at lifting and support locations.
3. Method and equipment used to support the panels during storage, transporting, and erection.
4. Erection sequence, including the method of lifting the panels, placing and adjusting the panels to proper alignment and grade, and supporting the panels during bolting, grouting, and backfilling operations.

The Contractor shall not begin noise barrier wall construction activities, including access construction and precast concrete panel fabrication, until receiving the Engineer's approval of all appropriate and applicable submittals.

6-12.3(2) Work Access and Site Preparation

The Contractor shall construct Work access in accordance with the Work access plan. The construction access roads shall minimize disturbance to the existing vegetation, especially trees. Only trees and shrubs in direct conflict with the approved construction access road alignment shall be removed. Only one access road into the noise barrier wall from the main Roadway and one access road from the noise barrier wall to the main Roadway shall be constructed at each noise barrier wall.

Existing vegetation that has been identified by the Engineer shall be protected in accordance with s 1-07.16 and 2-01, and the Special Provisions.

6-12.3(3) Shaft Construction

The Contractor shall excavate and construct the shafts in accordance with the shaft construction plan.

The shafts shall be excavated to the required depth as shown in the Plans. The excavation shall be completed in a continuous operation using equipment capable of excavating through the type of material expected to be encountered.

If the shaft excavation is stopped, the Contractor shall secure the shaft by installing a safety cover over the opening. The Contractor shall ensure the safety of the shaft and surrounding soil and the stability of the side walls. A temporary casing, slurry, or other methods acceptable to the Engineer shall be used as necessary to ensure such safety and stability.

When caving conditions are encountered, the Contractor shall stop further excavation until implementing the method to prevent ground caving as specified in the shaft construction plan.

When obstructions are encountered, the Contractor shall notify the Engineer promptly. An obstruction is defined as a specific object (including, but not limited to, boulders, logs, and man made objects) encountered during the shaft excavation operation, which prevents or hinders the advance of the shaft excavation. When efforts to advance past the obstruction to the design shaft tip elevation result in the rate of advance of the shaft drilling equipment being significantly reduced relative to the rate of advance for the rest of the shaft excavation, then the Contractor shall remove the obstruction under the provisions of Section 6-12.5. The method of removal of such obstructions, and the continuation of excavation shall be as proposed by the Contractor and accepted by the Engineer.

The Contractor shall use appropriate means to clean the bottom of the excavation of all shafts. No more than 2 inches of loose or disturbed material shall be present at the bottom of the shaft just prior to beginning concrete placement.

The Contractor shall not begin placing steel reinforcing bars and concrete in the shaft until receiving the Engineer's acceptance of the shaft excavation.

The steel reinforcing bar cage shall be rigidly braced to retain its configuration during handling and construction. The Contractor shall not place individual or loose bars. The Contractor shall install the steel reinforcing bar cage as specified in the shaft construction plan. The Contractor shall maintain the minimum concrete cover shown in the Plans.

If casings are used, the Contractor shall remove the casing during concrete placement. A minimum 5-feet head of concrete shall be maintained to balance soil and water pressure at the bottom of the casing. The casing shall be smooth. Where the top of the shaft is above the existing ground, the Contractor shall case the top of the hole prior to placing the concrete.

Concrete for shafts shall conform to Class 4000P. The Contractor shall place concrete in the shaft immediately after completing the shaft excavation and receiving the Engineer's acceptance of the excavation. The Contractor shall place the concrete in one continuous operation to the elevation shown in the Plans, using a method to prevent segregation of aggregates. The Contractor shall place the concrete as specified in the shaft construction plan. If water is present, concrete shall be placed in accordance with Section 6-02.3(6)B.

6-12.3(4) Trench, Grade Beam, or Spread Footing Construction

Where the noise barrier wall foundations exist below the existing ground line, excavation shall conform to Section 2-09.3(4), and to the limits and construction stages shown in the Plans. Foundation soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C.

Where the noise barrier wall foundations exist above the existing ground line, the Contractor shall place and compact backfill material in accordance with Section 2-03.3(14)C.

Concrete for trench, grade beam, or spread footing foundations shall conform to Class 4000.

Cast-in-place concrete shall be formed, placed, and cured in accordance with Section 6-02, except that concrete for trench foundations shall be placed against undisturbed soil. Cast-in-place footings shall have a longitudinal slope no steeper than 1V: 6H, unless otherwise shown in the Plans or Standard Plans.

The excavation shall be backfilled in accordance with item 1 of the Compaction Subsection of Section 2-09.3(1)E.

The steel reinforcing bar cage and the noise barrier wall anchor bolts shall be installed and rigidly braced prior to grade beam and spread footing concrete placement to retain their configuration during concrete placement. The Contractor shall not place individual or loose steel reinforcing bars and anchor bolts, and shall not install anchor bolts during or after concrete placement.

6-12.3(5) Cast-In-Place Concrete Panel Construction

Construction of cast-in-place concrete panels for noise barrier walls shall conform to Section 6-11.3(4). For noise barrier walls with traffic barrier, the construction of the traffic barrier shall also conform to Section 6-10.3(2).

The top of the cast-in-place concrete panels shall conform to the top of wall profile shown in the Plans. Where a vertical step is constructed to provide elevation change between adjacent panels, the dimension of the step shall be 2 feet. Each horizontal run between steps shall be a minimum of 48 feet.

6-12.3(6) Precast Concrete Panel Fabrication and Erection

The Contractor shall construct the precast concrete panels in accordance with Section 6-02.3(9), and the following requirements:

1. Concrete shall conform to Class 4000.
2. Except as otherwise noted in the Plans and Special Provisions, all concrete surfaces shall receive a Class 2 finish in accordance with Section 6-02.3(14)B.
3. The Contractor shall fully support the precast concrete panel to avoid bowing and sagging surfaces.

After receiving the Engineer's review of the shop drawings, the Contractor shall cast one precast concrete panel to be used as the sample panel. The Contractor shall construct the sample panel in accordance with the procedure and details specified in the shop drawings. The Contractor shall make the sample panel available to the Engineer for acceptance.

Upon receiving the Engineer's acceptance of the sample panel, the Contractor shall continue production of precast concrete panels for the noise barrier wall. All precast concrete panels will be evaluated against the sample panel for the quality of workmanship exhibited. The sample panel shall be retained at the fabrication site until all precast concrete panels have been fabricated and accepted. After completing precast concrete panel fabrication, the Contractor may utilize the sample panel as a production noise barrier wall panel.

4. In addition to the fabrication tolerance requirements of Section 6-02.3(9), the precast concrete panels for noise barrier walls shall not exceed the following scalar tolerances:

   Length and Width: ± ⅛ inch per 5 feet, not to exceed ¼ inch total.
   Thickness: ± ¼ inch.

   The difference obtained by comparing the measurement of the diagonal of the face of the panels shall not be greater than ½ inch.

   Dimension tolerances for the traffic barrier portion of precast concrete panels formed with traffic barrier shapes shall conform to Section 6-10.3(2).

5. Precast concrete panels shall not be erected until the foundations for the panels have attained a minimum compressive strength of 3,400 psi.

6. The bolts connecting the precast concrete panels to their foundation shall be tightened to "snug tight" as defined in Section 6-03.3(32).

7. After erection, the precast concrete panels shall not exceed the joint space tolerances shown in the Plans. The panels shall not exceed ⅜ inch out of plumb in any direction.

   The Contractor shall seal the joints between precast concrete panels with a backer rod and sealant system as specified. The Contractor shall seal both sides of the joint full length.

The top of precast concrete panels shall conform to the top of wall profile shown in the Plans. Where a vertical step is constructed to provide elevation change between adjacent panels, the dimension of the step shall be 2 feet. Each horizontal run between steps shall be a minimum of 48 feet.

6-12.3(7) Masonry Wall Construction

Construction requirements for masonry noise barrier wall panels shall be as specified in the Special Provisions.

6-12.3(8) Fabricating and Erecting Timber Noise Barrier Wall Panels

Construction requirements for timber noise barrier wall panels shall be as specified in the Special Provisions.

6-12.3(9) Access Doors and Concrete Landing Pads

The Contractor shall install access doors and door frames as shown in the Plans and *Standard Plans*. The Contractor shall install the access doors to open toward the Roadway side. The door frames shall be set in place with grout conforming to either Section 9-20.3(2) or 9-20.3(4) and placed in accordance with Section 6-02.3(20), with the grout completely filling the void between the door frame and the noise barrier wall panel.

All frame and door surfaces, except stainless steel surfaces, shall be painted in accordance with Section 6-07.3(9). Primer shall be applied to all non-stainless steel surfaces. All primer coated exposed metal surfaces shall be field painted with the remaining Section 6-07.3(9)A paint system coats. The top coat, when dry, shall match the color specified in the Plans or Special Provisions.

The Contractor shall construct concrete landing pads for each access door location as shown in the Plans. The concrete shall conform to Section 6-02.3(2)B.

Access door deadbolt locks shall be capable of accepting a Best CX series core. The Contractor shall furnish and install a spring-loaded construction core lock with each lock. The Engineer will furnish the permanent Best CX series core for the Contractor to install at the conclusion of the project.

6-12.3(10) Finish Ground Line Dressing

The Contractor shall contour and dress the ground line on both sides of the noise barrier wall, providing the minimum cover over the foundation as shown in the Plans. The Contractor shall contour the ground adjacent to the barrier to ensure good drainage away from the barrier.

After the access roads are no longer needed for noise barrier wall construction activities, the Contractor shall restore the area to the original condition. The Contractor shall recontour the access roads to match into the surrounding ground and shall reseed all disturbed areas in accordance with the Section 8-01 and the Special Provisions, and the noise barrier wall access plan.

6-12.4 Measurement

Noise barrier wall will be measured by the square foot area of one face of the completed wall panel in place. Except as otherwise noted, the bottom limit for measurement will be the top of the trench footing, spread footing, or shaft cap. For Noise Barrier Type 5, the bottom measurement limit will be the optional construction joint at the base of the traffic barrier. For Noise Barrier Type 7, the bottom measurement limit will be base of the traffic barrier. For Noise Barrier Types 8, 11, 12, 14, 15, and 20, the bottom measurement limit will be the base of the wall panel.

Noise barrier wall access door will be measured once for each access door assembly with concrete landing pad furnished and installed.

6-12.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Noise Barrier Wall Type __", per square foot.

The unit Contract price per square foot for "Noise Barrier Wall Type __" shall be full pay for constructing the noise barrier walls as specified, including constructing and removing access roads, excavating and constructing foundations and grade beams, constructing cast-in-place concrete, and masonry wall panels, fabricating and erecting precast concrete, and timber wall panels, applying sealer, and contouring the finish ground line adjacent to the noise barrier walls.

"Noise Barrier Wall Access Door", per each.

The unit Contract price per each for "Noise Barrier Wall Access Door" shall be full pay for furnishing and installing the access door assembly as specified, including painting the installed access door assembly and constructing the concrete landing pads.

"Removing Noise Barrier Wall Shaft Obstructions", estimated.

Payment for removing obstructions, as defined in Section 6-12.3(3), will be made for the changes in shaft construction methods necessary to remove the obstruction. The Contractor and the Engineer shall evaluate the effort made and reach agreement on the equipment and employees utilized, and the number of hours involved for each. Once these cost items and their duration have been agreed upon, the payment amount will be determined using the rate and markup methods specified in Section 1-09.6. For the purpose of providing a common proposal for all bidders, the Contracting Agency has entered an amount for the item "Removing Noise Barrier Wall Shaft Obstructions" in the bid proposal to become a part of the total bid by the Contractor.

If the shaft construction equipment is idled as a result of the obstruction removal work and cannot be reasonably reassigned within the project, then standby payment for the idled equipment will be added to the payment calculations. If labor is idled as a result of the obstruction removal work and cannot be reasonably reassigned within the project, then all labor costs resulting from Contractor labor agreements and established Contractor policies will be added to the payment calculations.

The Contractor shall perform the amount of obstruction work estimated by the Contracting Agency within the original time of the contract. The Engineer will consider a time adjustment and additional compensation for costs related to the extended duration of the shaft construction operations, provided:

1. The dollar amount estimated by the Contracting Agency has been exceeded, and;
2. The Contractor shows that the obstruction removal work represents a delay to the completion of the project based on the current progress schedule provided in accordance with Section 1-08.3.

6-13 Structural Earth Walls

6-13.1 Description

This Work consists of constructing structural earth walls (SEW).

6-13.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Gravel Borrow for Structural Earth Walls	9-03.14(4)
Premolded Joint Filler	9-04.1(2)
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Mortar	9-20.4
Concrete Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Water	9-25

Other materials required shall be as specified in the Special Provisions.

6-13.3 Construction Requirements

Proprietary structural earth wall systems shall be as specified in the Special Provisions.

6-13.3(1) Quality Assurance

The structural earth wall manufacturer shall provide a qualified and experienced representative to resolve wall construction problems. The structural earth wall manufacturer's representative shall be present at the beginning of wall construction activities, and at other times as needed throughout construction. Recommendations made by the structural earth wall manufacturer's representative shall be followed by the Contractor.

The completed wall shall meet the following tolerances:

1. Deviation from the design batter and horizontal alignment, when measured along a 10-foot straightedge, shall not exceed the following:
   a. Welded wire faced structural earth wall: 2 inches
   b. Precast concrete panel and concrete block faced structural earth wall: ¾ inch

2. Deviation from the overall design batter of the wall shall not exceed the following per 10 feet of wall height:
   a. Welded wire faced structural earth wall: 1½ inches
   b. Precast concrete panel and concrete block faced structural earth wall: ½ inch
3. The maximum outward bulge of the face between welded wire faced structural earth wall reinforcement layers shall not exceed 2 inches. The maximum allowable offset in any precast concrete facing panel joint shall be ¾ inch. The maximum allowable offset in any concrete block joint shall be ¾ inch.
4. The base of the structural earth wall excavation shall be within 3 inches of the staked elevations, unless otherwise accepted or specified by the Engineer.
5. The external structural earth wall dimensions shall be placed within 2 inches of that staked on the ground.
6. The backfill reinforcement layers shall be located horizontally and vertically within 1 inch of the locations shown in the structural earth wall Working Drawings.

At least 5 working days prior to the Contractor beginning any structural earth wall Work at the site, a structural earth wall preconstruction conference shall be held to discuss construction procedures, personnel, and equipment to be used, and other elements of structural earth wall construction. Those attending shall include:

1. (representing the Contractor) The superintendent, on site supervisors, and all foremen in charge of excavation, leveling pad placement, concrete block and soil reinforcement placement, and structural earth wall backfill placement and compaction.
2. (representing the Structural Earth Wall Manufacturer) The qualified and experienced representative of the structural earth wall manufacturer as specified at the beginning of this section.
3. (representing the Contracting Agency) The Engineer, key inspection personnel, and representatives from the WSDOT Construction Office and Materials Laboratory Geotechnical Services Branch.

6-13.3(2) Submittals

The Contractor, or the supplier as the Contractor's agent, shall furnish a Manufacturer's Certificate of Compliance certifying that the structural earth wall materials conform to the specified material requirements. This includes providing a Manufacturer's Certificate of Compliance for all concrete admixtures, cement, fly ash, steel reinforcing bars, reinforcing strips, reinforcing mesh, tie strips, fasteners, welded wire mats, backing mats, construction geotextile for wall facing, drainage geosynthetic fabric, block connectors, and joint materials. The Manufacturer's Certificate of Compliance for geogrid reinforcement shall include the information specified in Section 9-33.4(4) for each geogrid roll, and shall specify the geogrid polymer types for each geogrid roll.

A Type 1 Working Drawing of all test results performed by the Contractor or the Contractor's supplier, which are necessary to ensure compliance with the specifications, shall be submitted along with each Manufacturer's Certificate of Compliance.

Before fabrication, the Contractor shall submit a Type 1 Working Drawing consisting of the field construction manual for the structural earth walls, prepared by the wall manufacturer. This manual shall provide step-by-step directions for construction of the wall system.

The Contractor, through the license/patent holder for the structural earth wall system, shall submit Type 2E Working Drawings consisting of detailed design calculations and details. If not prepared by the license/patent holder for the structural earth system, the design calculation and working drawing submittal shall include documentation that the design calculation and working drawing submittal has been reviewed by, and received the concurrence of, the headquarters organization of the structural earth wall manufacturer as identified in the Special Provisions. Review and concurrence by a sales representative office is not acceptable.

6-13.3(2)A Design Calculation Content Requirements

The design calculation submittal shall include detailed design calculations based on the wall geometry and design parameters specified in the Plans and Special Provisions. The calculations shall include detailed explanations of any symbols, design input, materials property values, and computer programs used in the design of the walls. All computer output submitted shall be accompanied by supporting hand calculations detailing the calculation process. If MSEW 3.0, or a later version, is used for the wall design, hand calculations supporting MSEW are not required.

The design calculations shall be based on the current AASHTO *LRFD Bridge Design Specifications*, including current interims, the current WSDOT *Bridge Design Manual* LRFD (BDM), and the WSDOT *Geotechnical Design Manual* (GDM), and also based on the following:

1. The wall design calculations shall address all aspects of wall internal stability for the service, strength, and extreme event limit states.
2. The wall surcharge conditions (backfill slope) shown in the Plans.
3. If a highway is adjacent to and on top of the wall, a 2-foot surcharge shall be used in the design.
4. If the Plans detail an SEW traffic barrier or SEW pedestrian barrier on top of the wall, the barrier shall be designed for a minimum TL-4 impact load, unless otherwise specified in the Plans or Special Provisions.
5. If the Plans detail an SEW traffic barrier or SEW pedestrian barrier on top of the wall, the wall shall be designed for the impact load transferred from the barrier to the wall.

6. The geotechnical design parameters for the wall shall be as specified in the Special Provisions.
7. The soil reinforcement length shall be as shown in the Plans. If the Plans do not show a length, the length shall be either 6 feet or 0.7 times the wall design height H, whichever is greater.

If there are differences in design requirements between the AASHTO *LRFD Bridge Design Specifications* and the BDM or GDM, the BDM and GDM requirements shall govern.

6-13.3(2)B Working Drawing Content Requirements

All design details shown in the working drawings shall be selected from the design details and products specified for the specific structural earth wall manufacturer in the Preapproved Wall Appendix in the current WSDOT *Geotechnical Design Manual* (GDM). Geosynthetic reinforcement shown in the working drawings shall be selected from the products listed in the current WSDOT Qualified Products List (QPL). Substitution of design details and products not listed in the current WSDOT GDM or QPL will not be allowed.

The working drawing submittal shall include all details, dimensions, quantities, and cross sections necessary to construct the wall based on the wall geometry and design parameters specified in the Plans and Special Provisions, and shall include, but not be limited to, the following items:

1. A plan and elevation sheet or sheets for each wall, containing the following:
    a. An elevation view of the wall that includes the following:
        i. The elevation at the top of the wall, at all horizontal and vertical break points, and at least every 50 feet along the wall;
        ii. Elevations at the base of welded wire mats or the top of leveling pads and foundations, and the distance along the face of the wall to all steps in the welded wire mats, foundations, and leveling pads;
        iii. The designation as to the type of panel, block, or module;
        iv. The length, size, and number of geogrids or mesh or strips, and the distance along the face of the wall to where changes in length of the geogrids or mesh or strips occur; or
        v. The length, size, and wire sizes and spacing of the welded wire mats and backing mats, and the distance along the face of the wall to where changes in length, size, and wire sizes and spacing of the welded wire mats and backing mats occur; and
        vi. The location of the original and final ground line.

b. A plan view of the wall that indicates the offset from the construction centerline to the face of the wall at all changes in horizontal alignment; the limit of the widest module, geogrid, mesh, strip, or welded wire mat, and the centerline of any drainage structure or drainage pipe that is behind or passes under or through the wall.

c. General notes, if any, required for design and construction of the wall.

d. All horizontal and vertical curve data affecting wall construction.

e. A listing of the summary of quantities provided on the elevation sheet of each wall for all items, including incidental items.

f. A cross section showing limits of construction. In fill sections, the cross section shall show the limits and extent of select granular backfill material placed above original ground.

g. Limits and extent of reinforced soil volume.

2. All details, including steel reinforcing bar bending details. Bar bending details shall be in accordance with Section 9-07.1.

3. All details for foundations and leveling pads, including details for steps in the foundations or leveling pads.

4. All modules and facing elements shall be detailed. The details shall show all dimensions necessary to construct the element, all steel reinforcing bars in the element, and the location of reinforcement element attachment devices embedded in the precast concrete facing panel or concrete block.

5. All details for construction of the wall around drainage facilities, sign, signal, luminaire, and noise barrier wall foundations, and structural abutment and foundation elements shall be clearly shown.

6. All details for connections to SEW traffic or pedestrian barriers, coping, parapets, noise barrier walls, and attached lighting shall be shown.

7. All details for the SEW traffic or pedestrian barrier attached to the top of the wall (if shown in the Plans), including interaction with bridge approach slabs.

6-13.3(3) Excavation and Foundation Preparation

Excavation shall conform to Section 2-09.3(3). Foundation soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C. The foundation for the Structure shall be graded level for a width equal to or exceeding the length of reinforcing as shown in the structural earth wall Working Drawings and, for walls with geogrid reinforcing, in accordance with Section 2-12.3. Prior to wall construction, the foundation, if not in rock, shall be compacted as accepted by the Engineer.

At the foundation level of the bottom course of precast concrete facing panels and concrete blocks, an unreinforced concrete leveling pad shall be provided as shown in the Plans. The leveling pad shall be cured a minimum of 12 hours and have a minimum compressive strength of 1,500 psi before placement of the precast concrete facing panels or concrete blocks.

6-13.3(4) Precast Concrete Facing Panel and Concrete Block Fabrication

Precast concrete facing panels shall conform to Section 6-02.3(9), except as modified in this section.

Concrete for precast concrete facing panels shall meet the following requirements:

1. Have a minimum 28-day compressive strength of 4,000 pounds per square inch, unless otherwise specified in the Special Provisions for specific proprietary wall systems.
2. Contain a water-reducing admixture meeting AASHTO M194 Type A, D, F, or G.
3. Be air-entrained, 6 percent ± 1½ percent.
4. Have a maximum slump of 4 inches, or 6 inches if a Type F or G water reducer is used.

Concrete for dry cast concrete blocks shall meet the following requirements:

1. Have a minimum 28-day compressive strength of 4,000 psi.
2. Conform to ASTM C1372, except as otherwise specified.
3. The lot of blocks produced for use in this project shall conform to the following freeze-thaw test requirements when tested in accordance with ASTM C1262. Minimum acceptable performance shall be defined as weight loss at the conclusion of 150 freeze-thaw cycles not exceeding 1 percent of the block's initial weight for a minimum of four of the five block specimens tested.
4. The concrete blocks shall have a maximum water absorption of 1 percent above the water absorption content of the lot of blocks produced and successfully tested for the freeze-thaw test specified in item 3 above.

The precast concrete facing panels and concrete blocks shall be considered acceptable regardless of curing age when compressive test results indicate that the compressive strength conforms to the 28-day requirements and when the visual inspection is satisfactorily completed. Testing of dry cast concrete blocks shall conform to ASTM C140.

All precast concrete facing panels shall be 5 feet square, except:

1. for partial panels at the top, bottom, and ends of the wall; and
2. as otherwise shown in the Plans.

All precast concrete facing panels shall be manufactured within the following tolerances:

1. All dimensions ± 3⁄16 inch.
2. Squareness, as determined by the difference between the two diagonals, shall not exceed ½ inch.
3. Surface defects on smooth formed surfaces measured on a length of 5 feet shall not exceed ⅛ inch. Surface defects on textured-finished surfaces measured on a length of 5 feet shall not exceed 5⁄16 inch.

All concrete blocks shall be manufactured within the following tolerances:

1. Vertical dimensions shall be ± 1⁄16 inch of the Plan dimension, and the rear height shall not exceed the front height.
2. The dimensions of the grooves in the top and bottom faces of the concrete blocks shall be formed within the tolerances specified by the proprietary wall manufacturer, for the fit required for the block connectors.
3. All other dimensions shall be ± ¼ inch of the Plan dimension.

Tie attachment devices, except for geosynthetic reinforcement, shall be set in place to the dimensions and tolerances shown in the Plans prior to casting.

The forms forming precast concrete facing panels, including the forms for loop pockets and access pockets, and the forms forming the concrete blocks, shall be removed in accordance with the recommendations of the wall manufacturer, without damaging the concrete.

The concrete surface for the precast concrete facing panel shall have the finish shown in the Plans for the front face and an unformed finish for the rear face. The rear face of the precast concrete facing panel shall be roughly screeded to eliminate open pockets of aggregate and surface distortions in excess of ¼ inch.

The concrete surface for the front face of the concrete block shall be flat, and shall be a conventional "split face" finish in accordance with the wall manufacturer's Specifications.The concrete surface of all other faces shall be Class 2 in accordance with Section 6-02.3(14)B. The finish and appearance of the concrete blocks shall also conform to ASTM C1372. The color of the concrete block shall be concrete gray, unless otherwise shown in the Plans.

The date of manufacture, production lot number, and the piece-mark, shall be clearly marked on the rear face of each precast concrete facing panel, and marked or tagged on each pallet of concrete blocks.

All precast concrete facing panels and concrete blocks shall be handled, stored, and shipped in accordance with Sections 6-02.3(9) to prevent chipping, cracks, fractures, and excessive bending stresses.

Precast concrete facing panels in storage shall be supported on firm blocking located immediately adjacent to tie strips to avoid bending the tie strips.

6-13.3(5) Precast Concrete Facing Panel and Concrete Block Erection

Precast concrete facing panels shall conform to Section 6-02.3(9), except as modified in this section.

The precast concrete facing panels shall be placed vertically. During erection, precast concrete facing panels shall be handled by means of a lifting device set into the upper edge of the panels.

Concrete blocks shall be erected in a running bond fashion in accordance with the wall manufacturer's field construction manual, and may be placed by hand. The top surface of each course of concrete blocks, including all pockets and recesses, shall be cleaned of backfill and all extraneous materials prior to connecting the reinforcing strips or geosynthetic reinforcing, and placing the next course of concrete blocks. Concrete blocks receiving geosynthetic reinforcement shall be connected as specified in the Special Provisions. Cap block top courses shall be bonded to the lower course of concrete blocks as specified below. All other concrete blocks shall be connected with block connectors or pins placed into the connector slots.

Precast concrete facing panels and concrete blocks shall be placed in successive horizontal lifts as backfill placement proceeds in the sequence shown in the structural earth wall Working Drawings as approved by the Engineer.

External bracing is required for the initial lift for precast concrete facing panels.

As backfill material is placed behind the precast concrete facing panels, the panels shall be maintained in vertical position by means of temporary wooden wedges placed in the joint at the junction of the two adjacent panels on the external side of the wall.

Reinforcing shall be placed normal to the face of the wall, unless otherwise shown in the Plans or directed by the Engineer. Prior to placement of the reinforcing, backfill shall be compacted.

Geosynthetic reinforcing shall be placed in accordance with Section 2-12.3 and as follows:

1. The Contractor shall stretch out the geosynthetic in the direction perpendicular to the wall face to remove all slack and wrinkles, and shall hold the geosynthetic in place with soil piles or other methods as recommended by the geosynthetic manufacturer, before placing backfill material over the geosynthetic to the specified cover.
2. The geosynthetic reinforcement shall be continuous in the direction perpendicular to the wall face from the back face of the concrete panel to the end of the geosynthetic or to the last geogrid node at the end of the specified reinforcement length. Geosynthetic splices parallel to the wall face will not be allowed.

At the completion of each course of concrete blocks and prior to installing any block connectors or geosynthetic reinforcement at this level, the Contractor shall check the blocks for level placement in all directions, and shall adjust the blocks by grinding or rear face shimming, or other method as recommended by the structural earth wall manufacturer's representative and as approved by the Engineer, to bring the blocks into a level plane.

For concrete block wall systems receiving a cap block top course, the cap blocks shall be bonded to the lower course either with mortar conforming to Section 9-20.4(3), or with an adhesive capable of bonding the concrete block courses together.

6-13.3(6) Welded Wire Faced Structural Earth Wall Erection

The Contractor shall erect the welded wire wall reinforcement in accordance with the wall manufacturer's field construction manual. Construction geotextile for wall facing shall be placed between the backfill material within the reinforced zone and the coarse granular material immediately behind the welded wire wall facing, as shown in the Plans and the structural earth wall Working Drawings. Geosynthetic reinforcing, when used, shall be placed in accordance with Sections 2-12.3 and 6-13.3(5).

6-13.3(7) Backfill

Backfill placement shall closely follow erection of each course of welded wire mats and backing mats, precast concrete facing panels, or concrete blocks. Backfill shall be placed in such a manner as to avoid any damage or disturbance to the wall materials or misalignment of the welded wire mats and backing mats, precast concrete facing panels, or concrete blocks. Backfill shall be placed in a manner that segregation does not occur. Construction equipment shall not operate directly on the wall reinforcement. A minimum backfill thickness of 6 inches over the reinforcement shall be required prior to operation of vehicles or equipment.

The Contractor shall place wall backfill over geosynthetic reinforcement, or construction geotextile for wall facing, in accordance with Section 2-12.3.

Misalignment or distortion of the precast concrete facing panels or concrete blocks due to placement of backfill outside the limits of this Specification shall be corrected in a manner acceptable to the Engineer.

The moisture content of the backfill material prior to and during compaction shall be uniformly distributed throughout each layer of material. The moisture content of all backfill material shall conform to Sections 2-03.3(14)C and 2-03.3(14)D.

Backfill shall be compacted in accordance with Method C of Section 2-03.3(14)C, except as follows:

1. The maximum lift thickness after compaction shall not exceed 10 inches.
2. The Contractor shall decrease this lift thickness, if necessary, to obtain the specified density.

3. The Contractor shall not use sheepsfoot rollers or rollers with protrusions for compacting backfill reinforced with geosynthetic layers, or for compacting the first lift of backfill above the construction geosynthetic for wall facing for each layer of welded wire mats. Rollers shall have sufficient capacity to achieve compaction without causing distortion to the face of the wall in accordance with the tolerances specified in Section 6-13.3(1).
4. The Contractor shall compact the zone within 3 feet of the back of the wall facing panels without causing damage to or distortion of the wall facing elements (welded wire mats, backing mats, construction geotextile for wall facing, precast concrete facing panels, and concrete blocks) by using a plate compactor. No soil density tests will be taken within this area.
5. For wall systems with geosynthetic reinforcement, the minimum compacted backfill lift thickness of the first lift above each geosynthetic reinforcement layer shall be 6 inches.

At the end of each day's operation, the Contractor shall shape the last level of backfill to permit runoff of rainwater away from the wall face. In addition, the Contractor shall not allow surface runoff from adjacent areas to enter the wall construction site.

6-13.3(8) Guardrail Placement

Where guardrail posts are required, the Contractor shall not begin installing guardrail posts until completing the structural earth wall to the top of wall elevation shown in the Plans. The Contractor shall install the posts in a manner that prevents movement of the precast concrete facing panels or concrete blocks, and prevents ripping, tearing, or pulling of the wall reinforcement.

The Contractor may cut welded wire reinforcement of welded wire faced structural earth walls to facilitate placing the guardrail posts, but only in the top two welded wire reinforcement layers and only with the permission of the Engineer in a manner that prevents bulging of the wall face and prevents ripping or pulling of the welded wire reinforcement. Holes through the welded wire reinforcement shall be the minimum size necessary for the post. The Contractor shall demonstrate to the Engineer prior to beginning guardrail post installation that the installation method will not rip, tear, or pull the wall reinforcement.

The Contractor shall place guardrail posts between the reinforcing strips, reinforcing mesh, and tie strips of the non-geosynthetic reinforced precast concrete panel or concrete block faced structural earth walls. Holes through the reinforcement of geosynthetic reinforced walls, if necessary, shall be the minimum size necessary for the guardrail post.

6-13.3(9) SEW Traffic Barrier and SEW Pedestrian Barrier

The Contractor, in conjunction with the structural earth wall manufacturer, shall design and detail the SEW traffic barrier and SEW pedestrian barrier in accordance with Section 6-13.3(2) and the above ground geometry details shown in the Plans. The barrier Working Drawings and supporting calculations shall be Type 2E and shall include, at a minimum, the following:

1. Complete details of barrier cross section geometry, including the portion below ground, and accommodations necessary for bridge approach slabs, PCCP, drainage facilities, underground utilities, and sign support, luminaire pole, traffic signal standard, and other barrier attachments.
2. Details of the steel reinforcement of the barrier, including a bar list and bending diagram in accordance with Section 6-02.3(24), and including additional reinforcement required at sign support, luminaire pole, traffic signal standard, and other barrier attachment locations.
3. Details of the interface of, and the interaction between, the barrier and the top layers of structural earth wall reinforcement and facing.
4. When the Plans specify placement of conduit pipes through the barrier, details of conduit pipe and junction box placement.

SEW traffic barrier and SEW pedestrian barrier shall be constructed in accordance with Sections 6-02.3(11)A and 6-10.3(2), and the details in the Plans and in the structural earth wall Working Drawings as approved by the Engineer. The moment slab supporting the SEW traffic or pedestrian barrier shall be continuously wet cured for 3 days in accordance with Section 6-02.3(11).

6-13.4 Measurement

Structural earth wall will be measured by the square foot of completed wall in place. The bottom limits for vertical measurement will be the bottom of the bottom mat, for welded wire faced structural earth walls, or the top of the leveling pad (or bottom of wall if no leveling pad is present) for precast concrete panel or concrete block faced structural earth walls. The top limit for vertical measurement will be the top of wall as shown in the Plans. The horizontal limits for measurement are from the end of the wall to the end of the wall.

Gravel borrow for structural earth wall including haul will be measured by the cubic yard in place determined by the limits shown in the Plans.

SEW traffic barrier, and SEW pedestrian barrier will be measured as specified in Section 6-10.4 for cast-in-place concrete barrier.

6-13.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Structural Earth Wall", per square foot.

The unit Contract price per square foot for "Structural Earth Wall" shall be full payment for all costs to perform the Work in connection with constructing structural earth walls, including leveling pads and copings when specified.

"Gravel Borrow for Structural Earth Wall incl. Haul", per cubic yard.

The unit Contract price per cubic yard for "Gravel Borrow for Structural Earth Wall incl. Haul" shall be full payment for all costs to perform the Work in connection with furnishing and placing backfill for structural earth wall, including hauling and compacting the backfill, and furnishing and placing the wall-facing backfill for welded wire-faced structural earth walls.

"SEW Traffic Barrier", per linear foot.

"SEW Pedestrian Barrier", per linear foot.

The unit Contract price per linear foot for "SEW ___ Barrier" shall be full pay for constructing the barrier on top of the structural earth wall, except that when these Bid items are not included in the Proposal, all costs in connection with performing the Work as specified shall be included in the unit Contract price per square foot for "Structural Earth Wall".

6-14 Geosynthetic Retaining Walls

6-14.1 Description

This Work consists of constructing geosynthetic retaining walls, including those shown in the *Standard Plans*.

6-14.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Sand	9-03.13(1)
Gravel Borrow for Structural Earth Wall	9-03.14(4)
Polyurethane Sealant	9-04.2(3)
Closed Cell Foam Backer Rod	9-04.2(3)A
Anchor Rods and Associated Nuts, Washers, and Couplers	9-06.5(4)
Reinforcing Steel	9-07
Welded Wire Reinforcement	9-07.7
Grout	9-20.3(4)
Construction Geosynthetic	9-33

Anchor plate shall conform to ASTM A36, ASTM A572 Grade 50, or ASTM A588.

The requirements specified in Section 2-12.2 for geotextile shall also apply to geosynthetic and geogrid materials used for permanent and temporary geosynthetic retaining walls.

Other materials required shall be as specified in the Special Provisions.

6-14.3 Construction Requirements

Temporary geosynthetic retaining walls are defined as those walls and wall components constructed and removed or abandoned before the Physical Completion Date of the project or as shown in the Plans. All other geosynthetic retaining walls shall be considered as permanent.

6-14.3(1) Quality Assurance

The Contractor shall complete the base of the retaining wall excavation to within plus or minus 3 inches of the staked elevations unless otherwise directed by the Engineer. The Contractor shall place the external wall dimensions to within plus or minus 2 inches of that staked on the ground. The Contractor shall space the reinforcement layers vertically and place the overlaps to within plus or minus 1 inch of that shown in the Plans.

The completed wall(s) shall meet the following tolerances:

	Permanent Wall	Temporary Wall
Deviation from the design batter and horizontal alignment for the face when measured along a 10-foot straightedge at the midpoint of each wall layer shall not exceed:	3 inches	5 inches
Deviation from the overall design batter per 10 feet of wall height shall not exceed:	2 inches	3 inches
Maximum outward bulge of the face between backfill reinforcement layers shall not exceed:	4 inches	6 inches

6-14.3(2) Submittals

The Contractor shall submit Type 2E Working Drawings consisting of detailed plans for each wall. The Working Drawing submittal shall include all details, dimensions, and cross sections necessary to construct the wall based on the wall geometry and design parameters specified in the Plans, including at a minimum, the following:

1. Detailed wall plans, with plan and elevation views for each wall, showing the actual lengths proposed for the geosynthetic reinforcing layers and the locations of each geosynthetic product proposed for use in each of the geosynthetic reinforcing layers.
2. Detailed cross sections showing the geosynthetic reinforcing layers, fascia connection dowels or anchor rods, and fascia formwork connection or support details located within or adjacent to the wall backfill.
3. The Contractor's proposed wall construction method, including proposed forming systems, types of equipment to be used, proposed erection sequence and details of how the backfill will be retained during each stage of construction.
4. Manufacturer's Certificate of Compliance, samples of the retaining wall geosynthetic and sewn seams for the purpose of acceptance as specified.
5. Details of geosynthetic retaining wall corner construction, including details of the positive connection between the wall sections on both sides of the corner.
6. Details of terminating a top layer of retaining wall geosynthetic and backfill due to a changing retaining wall profile.

Acceptance of the Contractor's proposed wall construction details and methods shall not relieve the Contractor of their responsibility to construct the walls in accordance with the requirements of these Specifications.

6-14.3(3) Excavation and Foundation Preparation

Excavation shall conform to Section 2-09.3(3). Foundations soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C.

The Contractor shall direct all surface runoff from adjacent areas away from the retaining wall construction site.

6-14.3(4) Erection and Backfill

The Contractor shall begin wall construction at the lowest portion of the excavation and shall place each layer horizontally as shown in the Plans. The Contractor shall complete each layer entirely before beginning the next layer.

Geotextile splices shall consist of a sewn seam or a minimum 1-foot overlap. Geogrid splices shall consist of adjacent geogrid strips butted together and fastened using hog rings, or other methods acceptable to the Engineer, in such a manner to prevent the splices from separating during geogrid installation and backfilling. Splices exposed at the wall face shall prevent loss of backfill material through the face. The splicing material exposed at the wall face shall be as durable and strong as the material to which the splices are tied. The Contractor shall offset geosynthetic splices in one layer from those in the other layers such that the splices shall not line up vertically. Splices parallel to the wall face will not be allowed, as shown in the Plans.

The Contractor shall stretch out the geosynthetic in the direction perpendicular to the wall face to ensure that no slack or wrinkles exist in the geosynthetic prior to backfilling.

For geogrids, the length of the reinforcement required as shown in the Plans shall be defined as the distance between the geosynthetic wrapped face and the last geogrid node at the end of the reinforcement in the wall backfill.

The Contractor shall place fill material on the geosynthetic in lifts such that 6 inches minimum of fill material is between the vehicle or equipment tires or tracks and the geosynthetic at all times. The Contractor shall remove all particles within the backfill material greater than 3 inches in size. Turning of vehicles on the first lift above the geosynthetic will not be permitted. The Contractor shall not end dump fill material directly on the geosynthetic without the prior permission of the Engineer.

The Contractor shall use a temporary form system to prevent sagging of the geosynthetic facing elements during construction. A typical example of a temporary form system and sequence of wall construction required when using this form are detailed in the Plans. Soil piles or the geosynthetic manufacturer's recommended method, in combination with the forming system shall be used to hold the geosynthetic in place until the specified cover material is placed.

The Contractor shall place and compact the wall backfill in accordance with the wall construction sequence detailed in the Plans and Method C of Section 2-03.3(14)C, except as follows:

1. The maximum lift thickness after compaction shall not exceed 10 inches
2. The Contractor shall decrease this lift thickness, if necessary, to obtain the specified density.
3. Rollers shall have sufficient capacity to achieve compaction without causing distortion to the face of the wall in accordance with Section 6-14.3(1).
4. The Contractor shall not use sheepsfoot rollers or rollers with protrusions.
5. The Contractor shall compact the zone within 3 feet of the back of the wall facing panels without causing damage to or distortion of the wall facing elements (welded wire mats, backing mats, construction geotextile for wall facing, precast concrete facing panels, and concrete blocks) by using a plate compactor. No soil density tests will be taken within this area.
6. For wall systems with geosynthetic reinforcement, the minimum compacted backfill lift thickness of the first lift above each geosynthetic reinforcement layer shall be 6 inches.

The Contractor shall construct wall corners at the locations shown in the Plans, and in accordance with the wall corner construction sequence and method in the Working Drawing submittal. Wall angle points with an interior angle of less than 150 degrees shall be considered to be a wall corner. The wall corner shall provide a positive connection between the sections of the wall on each side of the corner such that the wall backfill material cannot spill out through the corner at any time during the design life of the wall. The Contractor shall construct the wall corner such that the wall sections on both sides of the corner attain the full geosynthetic layer embedment lengths shown in the Plans.

Where required by retaining wall profile grade, the Contractor shall terminate top layers of retaining wall geosynthetic and backfill in accordance with the method in the Working Drawing submittal. The end of each layer at the top of the wall shall be constructed in a manner that prevents wall backfill material from spilling out the face of the wall throughout the life of the wall. If the profile of the top of the wall changes at a rate of 1:1 or steeper, this change in top of wall profile shall be considered to be a corner.

6-14.3(5) Guardrail Placement

The Contractor shall install guardrail posts as shown in the Plans after completing the wall, but before the permanent facing is installed. The Contractor shall install the posts in a manner that prevents bulging of the wall face and prevents ripping, tearing, or pulling of the geosynthetic reinforcement. Holes through the geosynthetic reinforcement shall be the minimum size necessary for the post. The Contractor shall demonstrate to the Engineer prior to beginning guardrail post installation that the installation method will not rip, tear, or pull the geosynthetic reinforcement.

6-14.3(6) Permanent Facing

The Contractor shall construct a permanent facing to the surface of all permanent geosynthetic retaining walls as shown in the Plans. Shotcrete facing, if shown in the Plans, shall conform to Section 6-18. Concrete fascia panel, if shown in the Plans, shall be constructed in accordance with Section 6-02. Cast-in-place concrete fascia panels shall be cured in accordance with the requirements in Section 6-02.3(11) for retaining walls. The Contractor shall apply the specified surface finish as noted, and to the limits shown, in the Plans to the exterior concrete surface. Precast concrete fascia panels shall conform to Section 6-02.3(9). When noted in the Plans, the Contractor shall apply pigmented sealer to the limits shown in the Plans.

Asphalt or cement concrete gutter shall be constructed as shown in the Plans and as specified in Section 8-04.

6-14.3(7) Geosynthetic Retaining Wall Traffic Barrier and Geosynthetic Retaining Wall Pedestrian Barrier

Geosynthetic wall traffic barrier (single slope and f-shape) and geosynthetic retaining wall pedestrian barrier shall be constructed in accordance with Sections 6-02.3(11)A and 6-10.3(2), and the details in the Plans. The moment slab supporting the geosynthetic wall traffic barrier and geosynthetic wall pedestrian barrier shall be continuously wet cured for 3 days in accordance with Section 6-02.3(11).

6-14.4 Measurement

Permanent geosynthetic retaining wall and temporary geosynthetic retaining wall will be measured by the square foot of face of completed wall. Corner wrap area and extensions of the geosynthetic wall beyond the area of wall face shown in the Plans or staked by the Engineer are considered incidental to the wall construction and will not be included in the measurement of the square foot of face of completed geosynthetic retaining wall.

Gravel borrow for structural earth wall will be measured as specified in Section 2-03.4.

Shotcrete facing and concrete fascia panel will be measured by the square foot surface area of the completed facing or fascia panel, measured to the neat lines of the facing or panel as shown in the Plans. When a footing is required, the measurement of the fascia panel area will include the footing.

Geosynthetic wall single slope traffic barrier, geosynthetic wall f-shape traffic barrier, and geosynthetic retaining wall pedestrian barrier will be measured as specified in Section 6-10.4 for cast-in-place concrete barrier.

6-14.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Geosynthetic Retaining Wall", per square foot.

"Temporary Geosynthetic Retaining Wall", per square foot.

All costs in connection with constructing the temporary or permanent geosynthetic retaining wall as specified shall be included in the unit Contract price per square foot for "Geosynthetic Retaining Wall" and "Temporary Geosynthetic Retaining Wall", including compaction of the backfill material and furnishing and installing the temporary forming system.

"Gravel Borrow for Structural Earth Wall Incl. Haul", per ton or per cubic yard.

All costs in connection with furnishing and placing backfill material for temporary or permanent geosynthetic retaining walls as specified shall be included in the unit Contract price per ton or per cubic yard for "Gravel Borrow for Structural Earth Wall Incl. Haul".

"Concrete Fascia Panel For Geosynthetic Wall", per square foot.

All costs in connection with constructing the concrete fascia panels as specified shall be included in the unit Contract price per square foot for "Concrete Fascia Panel For Geosynthetic Wall", including all steel reinforcing bars, premolded joint filler, polyethylene bond breaker strip, joint sealant, PVC pipe for weep holes, exterior surface finish, and pigmented sealer (when specified), constructing and placing the concrete footing, edge beam, anchor beam, anchor rod assembly, and backfill.

Shotcrete facing will be paid for in accordance with Section 6-18.5.

"Geosynthetic Wall Single Slope Traffic Barrier", per linear foot.

"Geosynthetic Wall F-Shape Traffic Barrier", per linear foot.

"Geosynthetic Retaining Wall Pedestrian Barrier", per linear foot.

The unit Contract price per linear foot for "Geosynthetic Wall Single Slope Traffic Barrier", "Geosynthetic Wall F-Shape Traffic Barrier", and "Geosynthetic Retaining Wall Pedestrian Barrier" shall be full pay for constructing the barrier on top of the geosynthetic retaining wall.

6-15 Soil Nail Walls

6-15.1 Description

This Work consists of constructing soil nail walls.

6-15.2 Materials

Materials shall meet the requirements of the following sections:

Grout	9-20.3(4)
Prefabricated Drainage Mat	9-33.2(3)

Other materials required, including materials for soil nails, shall be as specified in the Special Provisions.

6-15.3 Construction Requirements

6-15.3(1) General Description

Soil nailing shall consist of excavating to the layer limits shown in the Plans, drilling holes at the specified angle into the native material, placing and grouting epoxy coated or encapsulated steel reinforcing bars (soil nails) in the drilled holes, placing prefabricated drainage material and steel reinforcement, and applying a shotcrete facing over the steel reinforcement. After completing the wall to full height, the Contractor shall construct the concrete fascia panels as shown in the Plans.

All proprietary items used in the soil nailed Structure shall be installed in accordance with the manufacturer's recommendations. In the event of a conflict between the manufacturer's recommendations and these Specifications, these Specifications shall prevail.

6-15.3(2) Contractor's Experience Requirements

The Contractor or Subcontractor performing this Work shall have completed at least five projects, within the last 5 years, involving construction of retaining walls using soil nails or ground anchors or shall have completed the construction of two or more projects totaling at least 15,000 square feet of retaining wall with a minimum total of 500 soil nails or ground anchors.

The Contractor shall assign an engineer with at least 3 years of experience in the design and construction of permanently anchored or nailed Structures to supervise the Work. The Contractor shall not use consultants or manufacturer's representatives in order to meet the requirements of this Section. Drill operators and on-site supervisors shall have a minimum of 1 year experience installing permanent soil nails or ground anchors.

Contractors or Subcontractors that are specifically prequalified in Class 36 Work will be considered to have met the above experience requirements.

6-15.3(3) Submittals

The Contractor shall submit Type 2 Working Drawings of the following information.

1. A brief description of each project satisfying the Contractors Experience Requirements with the Owner's name and current phone number (this item is not required if the Contractor or Subcontractor is prequalified in Class 36).
2. A list identifying the following personnel assigned to this project and their experience with permanently anchored or nailed Structures:
   a. Supervising Engineer.
   b. Drill Operators.
   c. On-site Supervisors who will be assigned to the project.
3. The proposed detailed construction procedure that includes:
   a. Proposed method(s) of excavation of the soil and/or rock.
   b. A plan for the removal and control of groundwater encountered during excavation, drilling, and other earth moving activities. Include a list of the equipment used to remove and control groundwater.
   c Proposed drilling methods and equipment.
   d. Proposed hole diameter(s).
   e. Proposed method of soil nail installation.
   f. Mix design and procedures for placing the grout.
   g. Shotcrete mix design with compressive strength test results.
   h. Procedures for placing the shotcrete (include placement in conditions when ground water is encountered).
   i. Encapsulation system for additional corrosion protection selected for the soil nails and anchorages requiring encapsulation.
4. Detailed Working Drawings of the method proposed for the soil nail testing that includes:
   a. All necessary drawings and details to clearly describe the proposed system of jacking support, framing, and bracing to be used during testing.
   b. Calibration data for each load cell, test jack, pressure gauge, stroke counter on the grout pump, and master gauge to be used. The calibration tests shall have been performed by an independent testing Laboratory, and tests shall have been performed within 60 calendar days of the date submitted. Testing or Work shall not commence until the Engineer has approved the load cell, jack, pressure gage, and master pressure gauge calibrations.
5. Certified mill test results and typical stress-strain curves along with samples from each heat, properly marked, for the soil nail steel. The typical stress-strain curve shall be obtained by approved standard practices. The guaranteed ultimate strength, yield strength, elongation, and composition shall be specified.

6-15.3(4) Preconstruction Conference

A soil nail preconstruction conference shall be held at least 5 working days prior to the Contractor beginning any permanent soil nail Work at the site to discuss construction procedures, personnel, materials and equipment to be used. Those attending shall include:

1. (representing the Contractor) The superintendent, on site supervisors, and all foremen in charge of excavating the soil face, drilling the soil nail hole, placing the soil nail and grout, placing the shotcrete facing, and tensioning and testing the soil nail.
2. (representing the Contracting Agency) The Engineer, key inspection personnel, and representatives from the WSDOT Construction Office and Materials Laboratory Geotechnical Services Branch.

If the Contractor's key personnel change, or if the Contractor proposes a significant revision of the approved permanent soil nail installation plan, an additional conference shall be held before any additional permanent soil nail operations are performed.

6-15.3(5) Earthwork

The ground contour above the wall shall be established to its final configuration and slope as shown in the Plans prior to beginning excavation of the soil for the first row of soil nails. All excavation shall conform to Section 2-03.

The excavation shall proceed from the top down in a horizontal lift sequence with the ground level excavated no more than 3 feet below the elevation of the row of nails to be installed in that lift. The excavated vertical wall face shall not be left unshored more than 24 hours for any reason. A lift shall not be excavated until the nail installation and reinforced shotcrete placement for the preceding lift has been completed and accepted. After a lift is excavated, the cut surface shall be cleaned of all loose materials, mud, rebound, and other foreign matter that could prevent or reduce shotcrete bond.

The accuracy of the ground cut shall be such that the required thickness of shotcrete can be placed within a tolerance of plus or minus 2 inches from the defined face of the wall, and over excavation does not damage overlying shotcrete sections by undermining or other causes.

The Contractor should review the geotechnical recommendations report prepared for this project for further information on the soil conditions at the location of each wall. Copies of the geotechnical recommendations report are available for review by prospective Bidders at the location identified in the Special Provisions.

6-15.3(6) Soil Nailing

The Contractor shall not handle and transport the encapsulated soil nails until the encapsulation grout has reached sufficient strength to resist damage during handling. The Contractor shall handle the encapsulated soil nails in such a manner to prevent large deflections or distortions during handling. When handling or transporting encapsulated soil nails, the Contractor shall provide slings or other equipment necessary to prevent damage to the soil nails and the corrosion protection. The Engineer may reject any encapsulated nail which is damaged during transportation or handling. Damaged or defective encapsulation shall be repaired in accordance with the manufacturer's recommendations.

Soil nails shall be handled and sorted in such a manner as to avoid damage or corrosion. Prior to inserting a soil nail in the drilled hole, the Contractor and the Engineer will examine the soil nail for damage. If, in the opinion of the Engineer, the epoxy coating or bar has been damaged, the nail shall be repaired. If, in the opinion of the Engineer, the damage is beyond repair, the soil nail shall be rejected.

If, in the opinion of the Engineer, the epoxy coating can be repaired, the Contractor shall patch the coating with an Engineer approved patching material.

Nail holes shall be drilled at the locations shown in the Plans or as staked by the Engineer. The nails shall be positioned plus or minus 6 inches from the theoretical location shown in the Plans. The Contractor shall select the drilling method and the grouting pressure used for the installation of the soil nail. The drill hole shall be located so that the longitudinal axis of the drill hole and the longitudinal axis of the nail are parallel. At the point of entry the soil nail shall be installed within plus or minus 3 degrees of the inclination from horizontal shown in the Plans, and the nail shall be within plus or minus 3 degrees of a line drawn perpendicular to the face of the wall unless otherwise shown in the Plans.

Water or other liquids shall not be used to flush cuttings during drilling, but air may be used. The nail shall be inserted into the drilled hole with centralizers to the desired depth in such a manner as to prevent damage to the drilled hole, sheathing or epoxy during installation. The centralizers shall provide a minimum of 0.5 inches of grout cover over the soil nail and shall be spaced no further than 8 feet apart. When the soil nail cannot be completely inserted into the drilled hole without difficulty, the Contractor shall remove the nail from the drilled hole and clean or redrill the hole to permit insertion. Partially inserted soil nails shall not be driven or forced into the hole. Subsidence, or any other detrimental impact from drilling shall be cause for immediate cessation of drilling and repair of all damages in a manner approved by the Engineer at no additional cost to the Contracting Agency.

If caving conditions are encountered, no further drilling will be allowed until the Contractor selects a method to prevent ground movement. The Contractor may use temporary casing. The Contractor's method to prevent ground movement shall be approved by the Engineer. The casings for the nail holes, if used, shall be removed as the grout is being placed.

Where necessary for stability of the excavation face, a sealing layer of shotcrete may be placed before drilling is started, or the Contractor shall have the option of drilling and grouting of nails through a stabilizing berm of native soil at the face of the excavation. The stabilizing berm shall extend horizontally from the soil face and from the face of the shotcrete a minimum distance of 1 foot, and shall be cut down from that point at a safe slope, no steeper than 1H:1V unless approved by the Engineer. The berm shall be excavated to final grade after installation and full length grouting of the nails. Nails damaged during berm excavation shall be repaired or replaced by the Contractor, to the satisfaction of the Engineer, at no added cost to the Contracting Agency.

If sections of the wall are constructed at different times than the adjacent soil nail sections, the Contractor shall use stabilizing berms, temporary slopes, or other measures acceptable to the Engineer, to prevent sloughing or failure of the adjacent soil nail sections.

If cobbles and boulders are encountered at the soil face during excavation, the Contractor shall remove all cobbles and boulders that protrude from the soil face into the design wall section and fill the void with shotcrete. All shotcrete used to fill voids created by removal of cobbles and boulders shall be incidental to shotcrete facing.

The grout equipment shall produce a grout free of lumps and undispersed cement. A positive displacement grout pump shall be used. The pump shall be equipped with a pressure gauge near the discharge end to monitor grout pressures. The pressure gauge shall be capable of measuring pressures of at least 150 psi or twice the actual grout pressures used by the Contractor, whichever is greater. The grouting equipment shall be sized to enable the grout to be pumped in one continuous operation. The mixer shall be capable of continuously agitating the grout.

The grout shall be injected from the lowest point of the drilled hole. The quantity of the grout and the grout pressures shall be recorded. The grout pressures and grout takes shall be controlled to prevent excessive ground heave.

The Contractor shall make and cure grout cubes once per day in accordance with WSDOT T 813. These samples shall be retained by the Contractor until all associated verification and proof testing of the soil nails has been successfully completed. If the Contractor elects to test the grout cubes for compressive strength, testing shall be conducted by an independent laboratory and shall be in accordance with the FOP for AASHTO T106.

6-15.3(7) Shotcrete Facing

Prior to placing any shotcrete on an excavated layer, the Contractor shall vertically center prefabricated drainage mat between the columns of nails as shown in the Plans. The prefabricated drainage mat shall be installed in accordance with the manufacturer's recommendations. The permeable drain side shall be placed against the exposed soil face. The prefabricated drainage mat shall be installed after each excavation lift and shall be hydraulically connected with the prefabricated drainage mat previously placed, such that the vertical flow of water is not impeded. The Contractor shall tape all joints in the prefabricated drainage mat to prevent shotcrete intrusion during shotcrete application.

The Contractor shall place steel reinforcing bars and welded wire fabric, and apply the shotcrete facing in accordance with Section 6-18 and the details shown in the Plans.

The shotcrete shall be constructed to the minimum thickness as shown in the Plans. Costs associated with additional thickness of shotcrete due to over excavation or irregularities in the cut face shall be borne by the Contractor.

Each soil nail shall be secured at the shotcrete facing with a steel plate as shown in the Plans. The plate shall be seated on a wet grout pad of a pasty consistency similar to that of mortar for brick-laying. The nut shall then be sufficiently tightened to achieve full bearing surface behind the plate. After the shotcrete and grout have had time to gain the specified strength, the nut shall be tightened with at least 100 foot-pounds of torque. After final tightening of the nut, the threads of the soil nail shall at a minimum be flush with the end of the nut.

6-15.3(8) Soil Nail Testing and Acceptance

Both verification and proof testing of the nails is required. The Contractor shall supply all materials, equipment, and labor to perform the tests. The Contractor shall submit Type 1 Working Drawings of all test data. Soil nails used for verification tests and proof tests shall not be production soil nails, but instead shall be separate sacrificial soil nails not otherwise incorporated into the Work.

The testing equipment shall include a dial gauge or vernier scale capable of measuring to 0.001 inch of the ground anchor movement. A hydraulic jack and pump shall be used to apply the test load. The movement-measuring device shall have a minimum travel equal to the theoretical elastic elongation of the total nail length plus 1 inch. The dial gauge or vernier scale shall be aligned so that its axis is within 5 degrees from the axis of the nail and shall be monitored with a reference system that is independent of the jacking system and excavation face.

The jack and pressure gauge shall be calibrated by an independent testing Laboratory as a unit. Each load cell, test jack and pressure gauge, grout pump stroke counter, and master gauge, shall be calibrated as specified in Section 6-15.3(3), item 4b. Additionally, the Contractor shall not use load cells, test jacks and pressure gauges, grout pump stroke counters, and master gauges, greater than 60 calendar days past their most recent calibration date, until such items are re-calibrated by an independent testing Laboratory.

The pressure gauge shall be graduated in increments of either 100 psi or 2 percent of the maximum test load, whichever is less. The pressure gauge shall be selected to place the maximum test load within the middle ⅔ of the range of the gauge. The ram travel of the jack shall not be less than the theoretical elastic elongation of the total length at the maximum test load plus 1 inch. The jack shall be independently supported and centered over the nail so that the nail does not carry the weight of the jack. The Contractor shall have a second calibrated jack pressure gauge at the site. Calibration data shall provide a specific reference to the jack and the pressure gauge.

The loads on the nails during the verification and proof tests shall be monitored to verify consistency of load – defined as maintaining the test load within 5 percent of the specified value. Verification and proof test loads less than 20,000 pounds or sustained for 5 minutes or less shall be monitored by the jack pressure gauge alone. Verification and proof test loads equal to or greater than 20,000 pounds and sustained for longer than 5 minutes shall be monitored with the assistance of an electric or hydraulic load cell. The Contractor shall provide the load cell, the readout device, and a calibration curve from the most recent calibration as specified in Section 6-15.3(3), item 4b. The load cell shall be selected to place the maximum test load within the middle ⅔ of the range of the load cell. The load cell shall be mounted between the jack and the anchor plate. The stressing equipment shall be placed over the nail in such a manner that the jack bearing plates, load cell and stressing anchorage are in alignment.

Nails to be tested shall be initially grouted no closer to the excavation face than the dimension shown in the Plans. After placing the grout, the nail shall remain undisturbed until the grout has reached strength sufficient to provide resistance during testing. Test nails shall be left in the ground after testing, with the exposed portion of the test nail cut and removed to 2 feet behind the excavated face or inside face of shotcrete. The drill holes for test nails shall be completely backfilled with grout or nonstructural filler after testing on those test nails has been completed.

Load testing shall be performed against a temporary reaction frame with bearing pads that bear directly against the existing soil or the shotcrete facing. Bearing pads shall be kept a minimum of 12 inches from the edges of the drilled hole and the load shall be distributed to prevent failure of the soil face or fracture of the shotcrete. The Contractor shall submit Type 2E Working Drawings of the reaction frame.

The soil nail load monitoring procedure for verification and proof test load greater than 20,000 pounds and sustained for longer than 5 minutes shall be as follows:

1. For each increment of load, attainment of the load shall be initially established and confirmed by the reading taken from the jack gauge.
2. Once the soil nail anchor load has been stabilized, based on the jack gauge reading, the load cell readout device shall immediately be read and recorded to establish the load cell reading to be used at this load. The load cell reading is intended only as a confirmation of a stable soil nail load, and shall not be taken as the actual load on the soil nail.
3. During the time period that the load on the soil nail is held at this load increment, the Contractor shall monitor the load cell reading. The Contractor shall adjust the jack pressure as necessary to maintain the initial load cell reading. Jack pressure adjustment for any other reason will not be allowed.
4. Soil nail elongation measurements shall be taken at each load increment as specified in Sections 6-15.3(8)A and 6-15.3(8)B.
5. Steps 1 through 4 shall be repeated at each increment of load, in accordance with the load sequence specified in Sections 6-15.3(8)A and 6-15.3(8)B.

6-15.3(8)A Verification Testing

Verification testing shall be performed on nails installed within the pattern of production nails to verify the Contractor's procedures, hole diameter, and design assumptions. No drilling or installation of production nails will be permitted in any ground/rock unit unless successful verification testing of anchors in that unit has been completed and approved by the Engineer, using the same equipment, methods, nail inclination, nail length, and hole diameter as planned for the production nails. Changes in the drilling or installation method may require additional verification testing as determined by the Engineer and shall be done at no additional expense to the Contracting Agency. Verification tests may be performed prior to excavation for the soil nail wall.

Successful verification tests are required within the limits as specified in the Special Provisions. Test nail locations within these limits shall be at locations selected by the Engineer.

The Contractor shall submit Type 2E Working Drawings consisting of design details of the verification testing, including the system for distributing test load pressures to the excavation surface and appropriate nail bar size and reaction plate. The intent is to stress the bond between the grout and the surrounding soil/rock to at least twice the design load transfer. Prior to beginning verification testing, the Contractor shall measure and record the length of the nonbonded zone for each verification test soil nail.

The bar shall be proportioned such that the maximum stress at 200 percent of the test load does not exceed 80 percent of the yield strength of the steel. The jack shall be positioned at the beginning of the test such that unloading and repositioning of the jack during the test will not be required. The verification tests shall be made by incrementally loading the nails in accordance with the following schedule of hold time:

AL	1 minute
0.25TL	10 minutes
0.50TL	10 minutes
0.75TL	10 minutes
1.00TL	10 minutes
1.25TL	10 minutes
1.50TL	60 minutes
1.75TL	10 minutes
2.00TL	10 minutes

AL = Nail Alignment Load
TL = Nail Test Load

The test load shall be determined by the following equation = Test Load (TL) = Bond Length (BL) × Design Load Transfer (DLT).

The load shall be applied in increments of 25 percent of the test load. Each load increment shall be held for at least 10 minutes. Measurement of nail movement shall be obtained at each load increment. The load-hold period shall start as soon as the load is applied and the nail movement with respect to a fixed reference shall be measured and recorded at 1 minute, 2, 3, 4, 5, 6, 10, 20, 30, 40, 50, and 60 minutes.

The Engineer will evaluate the results of each verification test and make a determination of the suitability of the test and of the Contractor's proposed production nail design and installation system. Tests that fail to meet the design criteria will require additional verification testing or an approved revision to the Contractor's proposed production nail design and installation system. If a nail fails in creep, retesting will not be allowed.

A verification tested nail with a 60-minute load hold at 1.50TL is acceptable if:

1. The nail carries the test load with a creep rate that does not exceed 0.08 inch per log cycle of time and is at a linear or decreasing creep rate.
2. The total movement at the test load exceeds 80 percent of the theoretical elastic elongation of the non-bonded length.

Furthermore, a pullout failure shall not occur for the verification test anchor at the 2.0TL maximum load. Pullout failure load is defined as the load at which attempts to increase the test load result only in continued pullout movement of the test nail without a sustainable increase in the test load.

6-15.3(8)B Proof Testing

Proof tests shall be performed on proof test soil nails installed within the pattern of the production soil nails at the locations shown in the Plans. Proof test soil nails shall be installed using the same equipment, methods, nail inclination, nail length, and hole diameter as for adjacent production nails. The Contractor shall maintain the side-wall stability of the drill hole for the non-grouted portion during the test. The bond length shall be determined from the Nail Schedule and Test Nail Detail shown in the Plans. Prior to beginning proof testing, the Contractor shall measure and record the length of the nonbonded zone for each proof test soil nail.

Proof tests shall be performed by incrementally loading the nail in accordance with the schedule below. The anchor movement shall be measured and recorded to the nearest 0.001 inch with respect to an independent fixed reference point in the same manner as for the verification tests at the alignment load and at each increment of load. The load shall be monitored in accordance with Section 6-15.3(8). The scheduling of hold times shall be as follows:

AL	1 minute
0.25TL	5 minutes
0.50TL	5 minutes
0.75TL	5 minutes
1.00TL	5 minutes
1.25TL	5 minutes
1.50TL	10 minutes

AL = Nail Alignment Load
TL = Nail Test Load

The maximum load in a proof test shall be held for 10 minutes. The load hold period shall start as soon as the maximum load is applied and the nail movement with respect to an independent fixed reference shall be measured and recorded at 1, 2, 3, 4, 5, 6, and 10 minutes. The nail movement between 1 and 10 minutes shall not exceed 0.04 inches. If the nail movement between 1 and 10 minutes exceeds 0.04 inches, the maximum load shall be held an additional 50 minutes. If the load hold is extended, the nail movement shall be recorded at 20, 30, 40, 50, and 60 minutes. If a nail fails in creep, retesting will not be allowed.

A proof tested nail is acceptable if:

1. The nail carries the maximum load with less than 0.04 inches of movement between 1 and 10 minutes, unless the load hold extended to 60 minutes, in which case the nail would be acceptable if the creep rate does not exceed 0.08 inches per log cycle of time.
2. The total movement at the maximum load exceeded 80 percent of the theoretical elastic elongation of the non-bonded length.
3 The creep rate is not increasing with time during the load hold period.

If a proof test fails, the Engineer may direct the Contractor to replace some or all of the installed production nails between the failed test and an adjacent proof test nail that has met the test criteria. The Engineer may also require additional proof testing. All additional proof tests, and all installation of additional or modified nails, shall be performed at no additional expense to the Contracting Agency.

6-15.3(9) Concrete Fascia Panels

The Contractor shall construct the concrete fascia panels in accordance with Section 6-02 and the details in the Plans. The concrete fascia panels shall be cured in accordance with the Section 6-02.3(11) requirements specified for retaining walls. The Contractor shall provide the specified surface finish as noted, and to the limits shown, in the Plans to the exterior concrete surface. When noted in the Plans, the Contractor shall apply pigmented sealer to the limits shown in the Plans.

Asphalt or cement concrete gutter shall be constructed as shown in the Plans and as specified in Section 8-04.

6-15.4 Measurement

Prefabricated drainage mat will be measured by the square yard of material furnished and installed.

Soil nails will be measured per each for each soil nail installed and accepted.

Soil nail verification test and soil nail proof test will be measured per each for each successfully completed soil nail verification test and soil nail proof test at the locations specified in the Special Provisions and shown in the Plans.

Shotcrete facing and concrete fascia panel will be measured by the square foot surface area of the completed facing or fascia panel, measured to the neat lines of the facing or panel as shown in the Plans.

6-15.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Soil Nail – Epoxy Coated", per each.

"Soil Nail – Encapsulated", per each.

All costs in connection with furnishing and installing the soil nails as specified shall be included in the unit Contract price per each for "Soil Nail - ___", including all drilling, grouting, centralizers, bearing plates, welded shear connectors, nuts, and other Work required for installation of each soil nail.

"Prefabricated Drainage Mat", per square yard.

"Soil Nail Verification Test and Soil Nail Proof Test", per each.

All costs in connection with successfully completing soil nail verification tests and soil nail proof tests as specified shall be included in the unit contract price per each for "Soil Nail Verification Test and Soil Nail Proof Test", including removal of the exposed portion of the test nail and backfilling the drilled hole with grout or nonstructural filler.

"Concrete Fascia Panel", per square foot.

All costs in connection with constructing the concrete fascia panels as specified shall be included in the unit Contract price per square foot for "Concrete Fascia Panel", including all steel reinforcing bars, premolded joint filler, polyethylene bond breaker strip, joint sealant, PVC pipe for weep holes, exterior surface finish, and pigmented sealer (when specified).

Shotcrete facing will be paid for in accordance with Section 6-18.5.

Unless otherwise specified, all costs in connection with excavation in front of the back face of the shotcrete facing shall be included in the unit Contract price per cubic yard for "Roadway Excavation" or "Roadway Excavation Incl. Haul" as specified in Section 2-03.5.

6-16 Soldier Pile and Soldier Pile Tieback Walls

6-16.1 Description

This Work consists of constructing soldier pile walls and soldier pile tieback walls.

6-16.2 Materials

Materials shall meet the requirements of the following sections:

Controlled Density Fill	2-09.3(1)E
Cement	9-01
Aggregates for Concrete	9-03.1
Gravel Backfill	9-03.12
Premolded Joint Filler	9-04.1(2)
Welded Shear Studs	9-06.15
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Paints	9-08
Timber Lagging	9-09.2
Preservative Treatment for Timber Lagging	9-09.3(1)
Soldier Piles	9-10.5
Concrete Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Water	9-25
Prefabricated Drainage Mat	9-33.2(3)

Other materials required shall be as specified in the Special Provisions.

6-16.3 Construction Requirements

6-16.3(1) Quality Assurance

The steel soldier piles shall be placed so that the centerline of the pile at the top is within 1 inch of the Plan location. The steel soldier pile shall be plumb, to within 0.5 percent of the length based on the total length of the pile.

Welding, repair welding, and welding inspection shall conform to the Section 6-03.3(25) requirements for welding, repair welding, and welding inspection for all other steel fabrication.

6-16.3(2) Submittals

The Contractor shall submit Type 2 Working Drawings consisting of shop plans as specified in Section 6-03.3(7) for all structural steel, including the steel soldier piles, and shall submit Type 2 Working Drawings consisting of shop plans and other details as specified in Section 6-17.3(3) for permanent ground anchors.

The Contractor shall submit Type 1 Working Drawings consisting of the permanent ground anchor grout mix design and the procedures for placing the grout to the Engineer for approval.

The Contractor shall submit Type 2E Working Drawings consisting of forming plans for the concrete fascia panels, as specified in Sections 6-02.3(16) and 6-02.3(17).

1. Where the lateral pressure from concrete placement, as specified in Section 6-02.3(17)J,
   is less than or equal to the design earth pressure, the Contractor may tie forms directly to the soldier piles.
2. Where the lateral pressure from concrete placement, as specified in Section 6-02.3(17)J,
   is greater than the design earth pressure, the Contractor shall follow one of the following procedures:
   a. Tie the forms to strongbacks behind the lagging, or use some other system that confines the pressure from concrete placement between the lagging and the form panels, in addition to the ties to the soldier piles.
   b. Reduce the rate of placing concrete to reduce the pressure from concrete placement to less than or equal to the design earth pressure in addition to the ties to the soldier piles.
   c. Follow a procedure with a combination of a. and b.
3. The Contractor shall design the forms for an appropriate rate of placing concrete so that no cold joints occur, considering the wall thickness and height, and volume of concrete to be placed.

The Contractor shall submit Type 2 Working Drawings consisting of a shaft installation plan. In preparing the submittal, the Contractor shall reference the available subsurface data provided in the Contract test hole boring logs and the geotechnical report(s) prepared for this project. This plan shall provide at least the following information:

1. An overall construction operation sequence and the sequence of shaft construction.
2. List, description, and capacities of proposed equipment including but not limited to cranes, drills, augers, bailing buckets, final cleaning equipment, and drilling units. The narrative shall describe why the equipment was selected, and describe equipment suitability to the anticipated site and subsurface conditions. The narrative shall include a project history of the drilling equipment demonstrating the successful use of the equipment on shafts of equal or greater size in similar soil/rock conditions.
3. Details of shaft excavation methods including proposed drilling methods, methods for cleanout of the shafts, disposal plan for excavated material and drilling slurry (if applicable), and a review of method suitability to the anticipated site and subsurface conditions.

4. Details of the method(s) to be used to ensure shaft stability (i.e., prevention of caving, bottom heave, etc. using temporary casing, slurry, or other means) during excavation and concrete placement. This shall include a review of method suitability to the anticipated site and subsurface conditions. If temporary casings are proposed, casing dimensions and detailed procedures for casing installation and removal shall be provided. If slurry is proposed, detailed procedures for mixing, using, maintaining, and disposing of the slurry shall be provided. A detailed mix design, and a discussion of its suitability to the anticipated subsurface conditions shall also be provided for the proposed slurry.
5. Details of soldier pile placement including internal support bracing and centralization methods.
6. Details of concrete placement including proposed operational procedures for pumping and/or tremie methods.
7. Details of the device used to prevent unauthorized entry into a shaft excavation.
8. The method to be used to form the horizontal construction joint at the top elevation specified for concrete Class 4000P in the shaft.

6-16.3(3) Shaft Excavation

Shafts shall be excavated to the required depth as shown in the Plans. The minimum diameter of the shaft shall be as shown in the Plans. The excavation shall be completed in a continuous operation using equipment capable of excavating through the type of material expected to be encountered.

The Contractor may use temporary telescoping casing to construct the shafts.

If the shaft excavation is stopped the shaft shall be secured by installation of a safety cover. It shall be the Contractor's responsibility to ensure the safety of the shaft and surrounding soil and the stability of the sidewalls. A temporary casing, slurry, or other methods specified in the shaft installation plan shall be used if necessary to ensure such safety and stability.

Where caving in conditions are encountered, no further excavation will be allowed until the Contractor has implemented the method to prevent ground caving as submitted in accordance with item 4 of the Shaft Installation Plan.

No more than 2 inches of loose or disturbed material, for soldier piles with permanent ground anchors, nor more than 12 inches of loose or disturbed material, for soldier piles without permanent ground anchors, shall be present at the bottom of the shaft just prior to beginning concrete placement.

The excavated shaft shall be inspected and receive acceptance by the Engineer prior to proceeding with construction.

When obstructions are encountered, the Contractor shall notify the Engineer promptly. An obstruction is defined as a specific object (including, but not limited to, boulders, logs, and man made objects) encountered during the shaft excavation operation that

prevents or hinders the advance of the shaft excavation. When efforts to advance past the obstruction to the design shaft tip elevation result in the rate of advance of the shaft drilling equipment being significantly reduced relative to the rate of advance for the rest of the shaft excavation, then the Contractor shall remove the obstruction under the provisions of Section 6-16.5. The method of removal of such obstructions, and the continuation of excavation shall be as proposed by the Contractor and approved by the Engineer.

Excavation of shafts shall not commence until a minimum of 12 hours after the shaft backfill for the adjacent shafts has been placed.

The temporary casings for the shafts shall be removed. A minimum 5-foot head of concrete shall be maintained to balance the soil and water pressure at the bottom of the casing. The casing shall be smooth.

6-16.3(4) Installing Soldier Piles

Soldier piles, if spliced, shall conform to all requirements of Section 6-05.3(6).

The prefabricated steel soldier piles shall be lowered into the drilled shafts and secured in position. Concrete cover over the soldier pile shall be 3 inches minimum, except that the cover over the soldier pile flange plate reinforcing at permanent ground anchor locations shall be 1½ inches minimum.

The steel soldier piles and attachments shall be shop painted after fabrication to the limits shown in the Plans with one coat of inorganic zinc primer. Application of the one coat of primer shall be in accordance with Section 6-07. The welded shear studs may be attached before or after painting. Paint damaged by welding shear studs in place does not require repair.

6-16.3(5) Backfilling Shaft

The excavated shaft shall be backfilled with either controlled density fill (CDF), or pumpable lean concrete, as shown in the Plans and subject to the following requirements:

1. Dry shaft excavations shall be backfilled with CDF.
2. Wet shaft excavations shall be backfilled with pumpable lean concrete.
3. Pumpable lean concrete shall be a Contractor designed mix providing a minimum 28-day compressive strength of 100 psi. Acceptance of pumpable lean concrete will conform to the acceptance requirements specified in Section 2-09.3(1) for CDF.
4. A wet shaft is defined as a shaft where water is entering the excavation and remains present to a depth of 6 inches or more.
5. When the Plans or test hole boring logs identify the presence of a water table at or above the elevation of the bottom of soldier pile shaft, the excavation shall be considered as wet, except as otherwise noted. Such a shaft may be considered a dry shaft provided the Contractor furnishes and installs casing that is sufficiently sealed into competent soils such that water cannot enter the excavation.

Placement of the shaft backfill shall commence immediately after completing the shaft excavation and receiving the Engineer's approval of the excavation. CDF or pumpable lean concrete shall be placed in one continuous operation to the top of the shaft. Vibration of shaft backfill is not required.

If water is not present, the shaft backfill shall be deposited by a method that prevents segregation of aggregates. The shaft backfill shall be placed such that the free-fall is vertical down the shaft without hitting the sides of the soldier pile or the excavated shaft. The Contractor's method for depositing the shaft backfill shall have approval of the Engineer prior to the placement of the shaft backfill.

If water is present, the shaft backfill shall be deposited in accordance with Section 6-02.3(6)B.

6-16.3(6) Designing and Installing Lagging and Installing Permanent Ground Anchors

Lagging for soldier pile walls shall conform to one of the following two categories:

1. Temporary lagging is defined as lagging that is in service as a structural member for a maximum of 36 months before a permanent load-carrying fascia is in place, except for the following exception: Lagging for soldier pile walls in site soils conforming to an excluded soil type as defined under Section 6-16.3(6)A will be classified as permanent lagging conforming to Section 6-16.3(6)C, in which case this requirement will be specified in the Plans along with design details for such lagging.
2. Permanent lagging is defined as all lagging not conforming to the definition of temporary lagging as specified in category 1, above.

6-16.3(6)A Soil Classification

For the purposes of designing lagging for soldier pile walls, soils shall be categorized in the classifications defined below.

Soil Type 1

The following shall be considered Type 1 soils:

1. Cohesive fine-grained soils either CL or CH of medium consistency with $\gamma H/Su < 5$.
2. Cohesive fine-grained soils either CL or CH that are stiff to very stiff and nonfissured.
3. Fine-grained soils either ML or SM-ML that are above the water table.
4. Coarse-grained soils either GW, GP, GM, GC, SW, SP, or SM that are medium dense to dense.

Soil Type 2

The following shall be considered Type 2 soils:

1. Cohesive fine-grained soils either CL or CH that are heavily overconsolidated and fissured.

2. Fine-grained ML soils or coarse-grained SM-ML soils that are below the water table.
3. Coarse-grained SC soil that is medium dense to dense and is below the water table.
4. Coarse-grained soils either SW, SP, or SM that are loose.

Soil Type 3

The following shall be considered Type 3 soils:

1. Cohesive fine-grained soils either CL or CH that are soft with $\gamma H/Su > 5$.
2. Fine-grained slightly plastic ML soil that is below the water table.
3. Coarse-grained SC soil that is loose and below the water table.

Exclusions

Regardless of whether site soils conform to one of the soil types defined above, site soils under the following conditions are excluded from the Type 1, Type 2, and Type 3 soil classifications:

1. Disturbed soils such as those in landslides or known unstable areas.
2. Layered soils dipping into the excavation steeper than 4H:1V.

Lagging for soldier pile walls located in site soils excluded from the Type 1, Type 2, and Type 3 soil classifications shall be designed in accordance with the latest AASHTO *LRFD Bridge Design Specifications* with current interim specifications. Use of the table in Section 6-16.3(6)B for timber lagging in these situations will not be allowed.

6-16.3(6)B Temporary Lagging

The Contractor shall design temporary lagging for all soldier pile walls. The temporary lagging design shall be based on the following:

1. The AASHTO *LRFD Bridge Design Specifications*, latest edition with current interim specifications, except that timber members used for temporary lagging may be selected based on the table below.
2. The soil type as specified in the Plans or as determined from the geotechnical report prepared for the project.
3. The soil pressure diagram, either as shown in the Plans or as included in the geotechnical report prepared for the project, including the surcharge for temporary construction load when shown in the Plans.

The Contractor shall submit Type 2E Working Drawings consisting of the soldier pile wall lagging design details and supporting design calculations. The submittal shall include, at a minimum, the following:

1. Description of the material used for the lagging, including identification of applicable material specifications.
2. Installation method and sequence.

3. If the lagging material is to be removed during or after installation of the permanent fascia, a description of how the lagging is removed without disturbing or damaging the fascia, soldier piles, and retained soil, and a description of how, and with what material, the void left by the removal of lagging is to be filled.

4. For all cases, except with timber for temporary lagging, a description with appropriate details of how subsurface drainage is to be accommodated, either in accordance with Section 6-16.3(7) for timber lagging, Section 6-15.3(7) for shotcrete facing, or other means appropriate for the geotechnical site conditions and acceptable to the Engineer for other lagging materials. Lagging materials and lagging installation methods that cause the buildup of, and prevent the relief of, pore water pressure will not be allowed. Free-draining materials are defined as those materials that exhibit a greater permeability than the material being retained.

Temporary lagging may be untreated timber conforming to the Section 9-09.2 requirements specified under Structures for timber lagging or another material selected by the Contractor.

Timber for temporary lagging shall conform to the minimum actual thickness specified in the table below for the soil type, exposed wall height, and lagging clear span as shown in the Plans.

Notwithstanding the requirements of Section 1-06.1, steel materials used by the Contractor as temporary lagging may be salvaged steel provided that the use of such salvaged steel materials shall be subject to visual inspection and acceptance by the Engineer. For salvaged steel materials where the grade of steel cannot be positively identified, the design stresses for the steel shall conform to the Section 6-02.3(17)B requirements for salvaged steel, regardless of whether rivets are present or not.

Minimum Actual Thickness of Timber Used as Temporary Lagging							
Soil Type[1]	**1**	**1**	**2**	**2**	**3**	**3**	**3**
Exposed Wall Height (feet)	**25 and under**	**Over 25 to 60**	**25 and under**	**Over 25 to 60**	**15 and under**	**Over 15 to 25**	**Over 25**
Clear Span of Lagging (feet)	**Minimum Actual Thickness of Rough Cut Timber Lagging (inches)[3]**						
5	2	3	3	3	3	3	4
6	3	3	3	3	3	4	5
7	3	3	3	4	4	5	6
8	3	4	4	4	5	6	See Note[2]
9	4	4	4	5	See Note[2]	See Note[2]	See Note[2]
10	4	5	5	5	See Note[2]	See Note[2]	See Note[2]

[1]Soil Type as defined in Section 6-16.3(6)A.
[2]For exposed wall heights exceeding the limits in the table above, or where minimum rough cut lagging thickness is not provided, the Contractor shall design the lagging in accordance with the latest AASHTO *LRFD Bridge Design Specifications* with current interim specifications.
[3]Table modified from FHWA document "Lateral Support Systems and Underpinning" (Report No. FHWA-RD-75-130).

6-16.3(6)C Permanent Lagging

Permanent lagging, including timber, shall be as shown in the Plans. The use of the table in Section 6-16.3(6)B for the design of timber lagging for permanent lagging will not be allowed.

6-16.3(6)D Installing Lagging and Permanent Ground Anchors

The excavation and removal of CDF and pumpable lean concrete for the lagging installation shall proceed in advance of the lagging and shall not begin until the CDF and pumpable lean concrete are of sufficient strength that the material remains in place during excavation and lagging installation. If the CDF or pumpable lean concrete separates from the soldier pile, or caves or spalls from around the soldier pile, the Contractor shall discontinue excavation and lagging installation operations until the CDF and pumpable lean concrete is completely set. The bottom of the excavation in front of the wall shall be level. Excavation shall conform to Section 2-03.

For walls without permanent ground anchors, the bottom of excavation shall not be more than 3 feet below the bottom level of the lagging already installed, but in no case shall the depth of excavation beneath the bottom level of installed lagging be such to cause instability of the excavated face. For walls with permanent ground anchors, the bottom of excavation shall be not more than 3 feet below the permanent ground anchor level until all permanent ground anchors at that level are installed and stressed, but in no case shall the depth of excavation beneath the permanent ground anchor level be such to cause instability of the excavated face. Any caving that occurs during excavation shall be backfilled with free-draining material.

Installing, stressing, and testing the permanent ground anchors shall be in accordance with Section 6-17 and the construction sequence specified in the Plans.

The lagging shall be installed from the top of the soldier pile proceeding downward. The lagging shall make direct contact with the soil. When and where lagging is not in full contact with the soil being retained, either the lagging shall be wedged back to create contact or the void shall be filled with a free-draining material.

When utilizing lagging in fill situations, the backfill layers shall be placed in accordance with Section 2-03.3(14) except that all layers shall be compacted to 90 percent of maximum density.

6-16.3(7) Prefabricated Drainage Mat

For walls with concrete fascia panels, a 4-foot-wide strip of prefabricated drainage mat shall be installed full height of the concrete fascia panel, centered between soldier pile flanges, unless otherwise shown in the Plans.

The prefabricated drainage mat shall be attached to the lagging in accordance with the manufacturer's recommendations. The fabric side shall face the lagging. Splicing of the prefabricated drainage mat shall be in accordance with the manufacturer's recommendations.

The Contractor shall ensure the hydraulic connection of the prefabricated drainage mat to the previously installed material so that the vertical flow of water is not impeded.

The Contractor shall tape all joints in the prefabricated drainage mat to prevent concrete intrusion during concrete fascia panel construction.

6-16.3(8) Concrete Fascia Panel

The Contractor shall construct the concrete fascia panels as shown in the Plans, and in accordance with the forming plan. The concrete fascia panels shall be cured in accordance with the Section 6-02.3(11) requirements specified for retaining walls.

The Contractor shall provide the specified surface finish as noted, and to the limits shown, in the Plans to the exterior concrete surface. When noted in the Plans, the Contractor shall apply pigmented sealer to the limits shown in the Plans.

Asphalt or cement concrete gutter shall be constructed as shown in the Plans.

6-16.4 Measurement

Soldier pile shaft construction will be measured by the linear foot of shaft excavated below the top of ground line for the shaft, defined as the highest existing ground point within the shaft diameter.

Furnishing soldier pile will be measured by the linear foot of pile assembly specified in the Proposal, including adjustments to the Plan quantity made in accordance with Section 1-04.4.

Lagging will be measured by the square foot area of lagging installed. The quantity will be computed based on the vertical dimension from the highest lagging elevation to the lowest lagging elevation between each pair of adjacent soldier piles as the height dimension and the center-to-center spacing of the soldier piles as the length dimension.

Prefabricated drainage mat will be measured by the square yard of material furnished and installed.

Concrete fascia panel will be measured by the square foot surface area of the completed fascia panel, measured to the neat lines of the panel as shown in the Plans.

6-16.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Shaft - ___ Diameter", per linear foot.

All costs in connection with constructing soldier pile shafts shall be included in the unit Contract price per linear foot for "Shaft - ___ Diameter", including shaft excavation, temporary casing if used, CDF, lean concrete, concrete Class 4000P, and installing the soldier pile assembly.

"Furnishing Soldier Pile - ___", per linear foot.

All costs in connection with furnishing soldier pile assemblies shall be included in the unit Contract price per linear foot for "Furnishing Soldier Pile - ___", including fabricating and painting the pile assemblies, and field splicing and field trimming the soldier piles. Payment will be made based on the quantity specified in the Proposal unless changes are made to this quantity in accordance with Section 1-04.4, in which case the quantity specified in the Proposal will be adjusted by the amount of the change and will be paid for in accordance with Section 1-04.4.

"Lagging", per square foot.

All costs in connection with furnishing and installing lagging shall be included in the unit contract price per square foot for "Lagging", including design of temporary lagging and filling voids behind the lagging with a free-draining material as approved by the Engineer.

"Prefabricated Drainage Mat", per square yard.

"Concrete Fascia Panel", per square foot.

All costs in connection with constructing the concrete fascia panels as specified shall be included in the unit Contract price per square foot for "Concrete Fascia Panel", including all steel reinforcing bars, premolded joint filler, polyethylene bond breaker strip, joint sealant, PVC pipe for weep holes, exterior surface finish, and pigmented sealer (when specified).

Unless otherwise specified, all costs in connection with non-shaft excavation, including all excavation required for placement of timber lagging, shall be included in the unit Contract price per cubic yard for "Roadway Excavation" or "Roadway Excavation Incl. Haul" as specified in Section 2-03.5.

"Removing Soldier Pile Shaft Obstructions", estimated.

Payment for removing obstructions, as defined in Section 6-16.3(3), will be made for the changes in shaft construction methods necessary to remove the obstruction. The Contractor and the Engineer shall evaluate the effort made and reach agreement on the equipment and employees utilized, and the number of hours involved for each. Once these cost items and their duration have been agreed upon, the payment amount will be determined using the rate and markup methods specified in Section 1-09.6. For the purpose of providing a common proposal for all bidders, the

Contracting Agency has entered an amount for the item “Removing Soldier Pile Shaft Obstructions” in the bid proposal to become a part of the total bid by the Contractor.

If the shaft construction equipment is idled as a result of the obstruction removal work and cannot be reasonably reassigned within the project, then standby payment for the idled equipment will be added to the payment calculations. If labor is idled as a result of the obstruction removal work and cannot be reasonably reassigned within the project, then all labor costs resulting from Contractor labor agreements and established Contractor policies will be added to the payment calculations.

The Contractor shall perform the amount of obstruction work estimated by the Contracting Agency within the original time of the contract. The Engineer will consider a time adjustment and additional compensation for costs related to the extended duration of the shaft construction operations, provided:

1. The dollar amount estimated by the Contracting Agency has been exceeded, and;
2. The Contractor shows that the obstruction removal work represents a delay to the completion of the project based on the current progress schedule provided in accordance with Section 1-08.3.

6-17 Permanent Ground Anchors

6-17.1 Description

This Work consists of constructing permanent ground anchors.

6-17.2 Materials

Materials required, including materials for permanent ground anchors, shall be as specified in the Special Provisions.

6-17.3 Construction Requirements

The Contractor shall select the ground anchor type and the installation method, and determine the bond length and anchor diameter. The Contractor shall install ground anchors that will develop the load indicated in the Plans and verified by tests specified in Sections 6-17.3(8)A, 6-17.3(8)B, and 6-17.3(8)C.

6-17.3(1) Definitions

Anchor Devices: The anchor head wedges or nuts that grip the prestressing steel.

Bearing Plate: The steel plate that evenly distributes the ground anchor force to the Structure.

Bond Length: The length of the ground anchor that is bonded to the ground and transmits the tensile force to the soil or rock.

Ground Anchor: A system, referred to as a tieback or as an anchor, used to transfer tensile loads to soil or rock. A ground anchor includes all prestressing steel, anchorage devices, grout, coatings, sheathings, and couplers if used.

Maintaining Consistency of Load: Maintaining the test load within 5 percent of the specified value.

Minimum Guaranteed Ultimate Tensile Strength (MUTS): The minimum guaranteed breaking load of the prestressing steel as defined by the specified standard.

Tendon Bond Length: The length of the tendon that is bonded to the anchor grout.

Tendon Unbonded Length: The length of the tendon that is not bonded to the anchor grout.

Total Anchor Length: The unbonded length plus the tendon bond length.

6-17.3(2) Contractor Experience Requirements

The Contractor or Subcontractor performing this Work shall have installed permanent ground anchors for a minimum of 3 years. Prior to the beginning of construction, the Contractor shall submit a list containing at least five projects on which the Contractor has installed permanent ground anchors. A brief description of each project and a reference shall be included for each project listed. As a minimum, the reference shall include an individual's name and current phone number.

The Contractor shall assign an engineer to supervise the Work with at least 3 years of experience in the design and construction of permanently anchored Structures. The Contractor shall not use consultants or manufacturer's representatives in order to meet the requirements of this Section. Drill operators and on-site supervisors shall have a minimum of 1 year experience installing permanent ground anchors.

Contractors or Subcontractors that are specifically prequalified in Class 36 Work will be considered to have met the above experience requirements.

The Contractor shall allow up to 15 calendar days for the Engineer's review of the qualifications and staff as noted above. Work shall not be started on any anchored wall system nor materials ordered until approval of the Contractor's qualifications are given.

6-17.3(3) Submittals

The Contractor shall submit Type 2E Working Drawings consisting of details and structural design calculations for the ground anchor system or systems intended for use.

The Contractor shall submit a Type 1 Working Drawing consisting of a detailed description of the construction procedure proposed for use.

The Contractor shall submit a Type 2 Working Drawing consisting of ground anchor schedule giving:

1. Ground anchor number
2. Ground anchor factored design load
3. Type and size of tendon
4. Minimum total bond length
5. Minimum anchor length
6. Minimum tendon bond length
7. Minimum unbonded length

The Contractor shall submit a Type 2 Working Drawing detailing the ground anchor tendon and the corrosion protection system. Include details of the following:

1. Spacers and their location
2. Centralizers and their location

3. Unbonded length corrosion protection system, including the permanent rubber seal between the trumpet and the tendon unbonded length corrosion protection and the transition between the tendon bond length and the unbonded tendon length corrosion protection.
4. Bond length corrosion protection system
5. Anchorage and trumpet
6. Anchorage corrosion protection system
7. Anchors using non-restressable anchorage devices

The Contractor shall submit Type 2 Working Drawings consisting of shop plans as specified in Section 6-03.3(7) for all structural steel, including the permanent ground anchors.

The Contractor shall submit Type 1 Working Drawings consisting of the mix design for the grout conforming to Section 9-20.3(4) and the procedures for placing the grout. The Contractor shall also submit the methods and materials used in filling the annulus over the unbonded length of the anchor.

The Contractor shall submit Type 2 Working Drawings consisting of the method proposed to be followed for the permanent ground anchor testing. This shall include all necessary drawings and details to clearly describe the method proposed.

The Contractor shall submit Type 2 Working Drawings consisting of calibration data for each load cell, test jack, pressure gauge and master pressure gauge to be used. The calibration tests shall have been performed by an independent testing Laboratory and tests shall have been performed within 60 calendar days of the date submitted.

6-17.3(4) Preconstruction Conference

A permanent ground anchor preconstruction conference shall be held at least 5 working days prior to the Contractor beginning any permanent ground anchor Work at the site to discuss construction procedures, personnel, materials, and equipment to be used. Those attending shall include:

1. (representing the Contractor) The superintendent, on site supervisors, and all foremen in charge of drilling the ground anchor hole, placing the permanent ground anchor and grout, and tensioning and testing the permanent ground anchor.
2. (representing the Contracting Agency) The Engineer, key inspection personnel, and representatives from the WSDOT Construction Office and Materials Laboratory Geotechnical Services Branch.

If the Contractor's key personnel change, or if the Contractor proposes a significant revision of the approved permanent ground anchor installation plan, an additional conference shall be held before any additional permanent ground anchor operations are performed.

6-17.3(5) Tendon Fabrication

The tendons can be either shop or field fabricated. The tendon shall be fabricated as shown in the shop plans.

The Contractor shall select the type of tendon to be used. The tendon shall be sized so the factored design load does not exceed 80 percent of the minimum guaranteed ultimate tensile strength of the tendon. In addition, the tendon shall be sized so the maximum test load does not exceed 80 percent of the minimum guaranteed ultimate tensile strength of the tendon.

The Contractor shall be responsible for determining the bond length and tendon bond length necessary to develop the factored design load indicated in the Plans in accordance with Sections 6-17.3(8)A, 6-17.3(8)B, and 6-17.3(8)C. The minimum bond length shall be 10 feet in rock and 15 feet in soil.

When the Plans require the tendon bond length to be encapsulated, the tendon bond length portion of the tendon shall be corrosion protected by encapsulating the tendon in a grout-filled PE or PVC tube as specified in Section 6-17.2 as supplemented in the Special Provisions. The tendons can be grouted inside the encapsulation prior to inserting the tendon in the drill hole or after the tendon has been placed in the drill hole. Expansive admixtures can be mixed with the encapsulation grout if the tendon is grouted inside the encapsulation while outside the drill hole. The tendon shall be centralized within the bond length encapsulation with a minimum of 0.20 inches of grout cover. Spacers shall be used along the tendon bond length of multi-element tendons to separate the elements of the tendon so the prestressing steel will bond to the encapsulation grout.

Centralizers shall be used to provide a minimum of 0.5 inches of grout cover over the tendon bond length encapsulation. Centralizers shall be securely attached to the encapsulation and the center-to-center spacing shall not exceed 10 feet. In addition, the upper centralizer shall be located a maximum of 5 feet from the top of the tendon bond length and the lower centralizer shall be located a maximum of 1 foot from the bottom of the tendon bond length.

The centralizer shall be able to support the tendon in the drill hole and position the tendon so a minimum of 0.5 inches of grout cover is provided and shall permit free flow of grout.

Centralizers are not required on encapsulated, pressure-injected ground anchor tendons if the ground anchor is installed in coarse grained soils (more than 50 percent of the soil larger than the number 200 sieve) using grouting pressures greater than 150 psi.

Centralizers are not required on encapsulated, hollow-stem-augered ground anchor tendons if the ground anchor is grouted through and the hole is maintained full of a stiff grout (8-inch slump or less) during extraction of the auger.

The minimum unbonded length of the tendon shall be the greater of 15 feet or that indicated in the Plans.

Corrosion protection of the unbonded length shall be provided by a sheath completely filled with corrosion inhibiting grease or grout. If grease is used under the sheath, provisions shall be made to prevent the grease from escaping at the ends of the sheath. The grease shall completely coat the tendon and fill the voids between the tendon and the sheath.

If the sheath is not fabricated from a smooth tube, a separate bond breaker shall be provided. The bond breaker shall prevent the tendon from bonding to the anchor grout surrounding the tendon unbonded length.

The total anchor length shall not be less than that indicated in the Plans or the approved Working Drawing submittal.

Anchorage devices shall be capable of developing 95 percent of the minimum guaranteed ultimate tensile strength of the prestressing steel tendon. The anchorage devices shall conform to the static strength requirements of Section 3.1 of the Post Tensioning Institute *Specification for Unbonded Single Strand Tendons*, *First Edition – 1993*.

Non-restressable anchorage devices may be used except where indicated in the Plans.

Restressable anchorages shall be provided on those ground anchors that require reloading. The post-tensioning supplier shall provide a restressable anchorage compatible with the post-tensioning system provided.

The bearing plates shall be sized so the bending stresses in the plate do not exceed the yield strength of the steel when a load equal to 95 percent of the minimum guaranteed ultimate tensile strength of the tendon is applied, and the average bearing stress on the concrete does not exceed that recommended in Section 3.1.3 of the Post Tensioning Institute *Specification for Unbonded Single Strand Tendons*, *First Edition – 1993*.

The trumpet shall have an inside diameter equal to or larger than the hole in the bearing plate. The trumpet shall be long enough to accommodate movements of the Structure during testing and stressing. For strand tendons with encapsulation over the unbonded length, the trumpet shall be long enough to enable the tendon to make a transition from the diameter or the tendon in the unbonded length to the diameter of the tendon at the anchor head without damaging the encapsulation. Trumpets filled with corrosion-inhibiting grease shall have a permanent rubber seal provided between the trumpet and the tendon unbonded length corrosion protection. Trumpets filled with grout shall have a temporary seal provided between the trumpet and the tendon unbonded length corrosion protection or the trumpet shall overlap the tendon unbonded length corrosion protection.

6-17.3(6) Tendon Storage and Handling

Tendons shall be handled and stored in such a manner as to avoid damage or corrosion. Damage to the prestressing steel as a result of abrasions, cut, nicks, welds and weld splatter will be cause for rejection by the Engineer. The prestressing steel shall be protected if welding is to be performed in the vicinity. Grounding of welding leads to the prestressing steel is forbidden. Prestressing steel shall be protected from dirt, rust, and deleterious substances. A light coating of rust on the steel is acceptable. If heavy corrosion or pitting is noted, the Engineer will reject the affected tendons.

The Contractor shall use care in handling and storing the tendons at the site. Prior to inserting a tendon in the drill hole, the Contractor and the Engineer will examine the tendon for damage to the encapsulation and the sheathing. If, in the opinion of the Engineer, the encapsulation is damaged, the Contractor shall repair the encapsulation in accordance with the tendon supplier's recommendations and as approved by the Engineer. If, in the opinion of the Engineer, the smooth sheathing has been damaged, the Contractor shall repair it with ultra high molecular weight polyethylene (PE) tape. The tape shall be spiral wound around the tendon so as to completely seal the damaged area. The pitch of the spiral shall ensure a double thickness at all points.

6-17.3(7) Installing Permanent Ground Anchors

The Contractor shall select the drilling method, the grouting procedure, and the grouting pressure used for the installation of the ground anchor.

When caving conditions are encountered, no further drilling will be allowed until the Contractor selects a method to prevent ground movement. The Contractor may use a temporary casing. The Contractor's method to prevent ground movement shall be submitted as a Type 2 Working Drawing. The casings for the anchor holes, if used, shall be removed. The drill hole shall be located so the longitudinal axis of the drill hole and the longitudinal axis of the tendon are parallel. The ground anchor shall not be drilled in a location that requires the tendon to be bent in order to enable the bearing plate to be connected to the supported Structure. At the point of entry the ground anchor shall be installed within plus or minus 3 degrees of the inclination from horizontal shown in the Plans or the Working Drawing submittal. The ground anchors shall not extend beyond the Right of Way limits.

The tendon shall be inserted into the drill hole to the desired depth. When the tendon cannot be completely inserted without difficulty, the Contractor shall remove the tendon from the drill hole and clean or redrill the hole to permit insertion. Partially inserted tendons shall not be driven or forced into the hole.

The Contractor shall use a grout conforming to Section 6-17.2 as supplemented in the Special Provisions.

The grout equipment shall produce a grout free of lumps and undispersed cement. A positive displacement grout pump shall be used. The pump shall be equipped with a pressure gauge near the discharge end to monitor grout pressures. The pressure gauge shall be capable of measuring pressures of at least 150 psi or twice the actual grout pressures used by the Contractor, whichever is greater. The grouting equipment shall be sized to enable the grout to be pumped in one continuous operation. The mixer shall be capable of continuously agitating the grout.

The grout shall be injected from the lowest point of the drill hole. The grout may be pumped through grout tubes, casing, or drill rods. The grout can be placed before or after insertion of the tendon. The quantity of the grout and the grout pressures shall be recorded. The grout pressures and grout takes shall be controlled to prevent excessive heave in soils or fracturing of rock formations.

The Contractor shall make and cure grout cubes once per day in accordance with WSDOT T 813. These samples shall be retained by the Contractor until all associated verification, performance and proof testing of the permanent ground anchors has been successfully completed. If the Contractor elects to test the grout cubes for compressive strength, testing shall be conducted by an independent laboratory and shall be in accordance with the FOP for AASHTO T 106.

After grouting, the tendon shall not be loaded for a minimum of 3 days.

No grout shall be placed above the top of the bond length during the time the bond length grout is placed. The grout at the top of the drill hole shall not contact the back of the Structure or the bottom of the trumpet. Except as otherwise noted, only nonstructural filler shall be placed above the bond length grout prior to testing and acceptance of the anchor. The Contractor may place structural grout above the bond length grout prior to testing and acceptance of the anchor subject to the following conditions:

1. The anchor unbonded length shall be increased by 8 feet minimum.
2. The grout in the unbonded zone shall not be placed by pressure grouting methods.

The corrosion protection surrounding the unbonded length of the tendon shall extend up beyond the bottom seal of the trumpet or 1 foot into the trumpet if no trumpet seal is provided. If the protection does not extend beyond the seal or sufficiently far enough into the trumpet, the Contractor shall extend the corrosion protection or lengthen the trumpet.

The corrosion protection surrounding the no load zone length of the tendon shown in the Plans shall not contact the bearing plate or the anchor head during testing and stressing. If the protection is too long, the Contractor shall trim the corrosion protection to prevent contact.

The bearing plate and anchor head shall be placed so the axis of the tendon and the drill hole are both perpendicular to the bearing plate within plus or minus 3 degrees and the axis of the tendon passes through the center of the bearing plate at the intersection of the trumpet and the bearing plate when fully seated with the alignment load.

The trumpet shall be completely filled with corrosion inhibiting grease or grout. Trumpet grease can be placed anytime during construction. Trumpet grout shall be placed after the ground anchor has been tested. The Contractor shall demonstrate to the Engineer that the procedure selected by the Contractor for placement of either grease or grout produces a completely filled trumpet.

All anchorages permanently exposed to the atmosphere shall be covered with a corrosion inhibiting grease-filled or grout-filled cover. The Contractor shall demonstrate to the Engineer that the procedures selected by the Contractor for placement of either grease or grout produces a completely filled cover. If the Plans require restressable anchorages, corrosion inhibiting grease shall be used to fill the anchorage cover and trumpet.

6-17.3(8) Testing and Stressing

Each ground anchor shall be tested. The test load shall be simultaneously applied to the entire tendon. Stressing of single elements of multi-element tendons will not be permitted. The Engineer will record test data.

The testing equipment shall consist of a dial gauge or vernier scale capable of measuring to 0.001 inch and shall be used to measure the ground anchor movement. The movement-measuring device shall have a minimum travel equal to the theoretical elastic elongation of the total anchor length plus 1 inch. The dial gauge or vernier scale shall be aligned so that its axis is within 5 degrees from the axis of the tieback. A hydraulic jack and pump shall be used to apply the test load. The jack and pressure gauge shall be calibrated by an independent testing Laboratory as a unit. Each load cell, test jack and pressure gauge, and master pressure gauge, shall be calibrated as specified in Section 6-17.3(3). Additionally, the Contractor shall not use load cells, test jacks and pressure gauges, and master pressure gauges, greater than 60 calendar days past their most recent calibration date, until such items are re-calibrated by an independent testing Laboratory.

The pressure gauge shall be graduated in increments of either 100 psi or 2 percent of the maximum test load, whichever is less. The pressure gauge will be used to measure the applied load. The pressure gauge shall be selected to place the maximum test load within the middle ⅔ of the range of the gauge. The ram travel of the jack shall not be less than the theoretical elastic elongation of the total anchor length at the maximum test load plus 1 inch. The jack shall be independently supported and centered over the tendon so that the tendon does not carry the weight of the jack. The Contractor shall have a second calibrated jack pressure gauge at the site. Calibration data shall provide a specific reference to the jack and the pressure gauge.

The loads on the tiebacks during the performance and verification tests shall be monitored to verify consistency of load as defined in Section 6-17.3(1). Performance test loads, and verification test loads when specified in the Special Provisions, sustained for 5 minutes or less, and all proof test leads, shall be monitored by the jack pressure gauge alone. Performance test loads, and verification test loads when specified in the Special Provisions, sustained for longer than 5 minutes shall be monitored with the assistance of an electric or hydraulic load cell. The Contractor shall provide the load cell and a readout device. The load cell shall be mounted between the jack and the anchor plate. The load

cell shall be selected to place the maximum test load within the middle ⅔ of the range of the load cell. The stressing equipment shall be placed over the ground anchor tendon in such a manner that the jack, bearing plates, load cell and stressing anchorage are in alignment.

The permanent ground anchor load monitoring procedure for performance test loads, and verification test loads when specified in the Special Provisions, sustained for longer than 5 minutes shall be as follows:

1. For each increment of load, attainment of the load shall be initially established and confirmed by the reading taken from the jack gauge.
2. Once the permanent ground anchor load has been stabilized, based on the jack gauge reading, the load cell readout device shall immediately be read and recorded to establish the load cell reading to be used at this load. The load cell reading is intended only as a confirmation of a stable permanent ground anchor load, and shall not be taken as the actual load on the permanent ground anchor.
3. During the time period that the load on the permanent ground anchor is held at this load increment, the Contractor shall monitor the load cell reading. The Contractor shall adjust the jack pressure as necessary to maintain the initial load cell reading. Jack pressure adjustment for any other reason will not be allowed.
4. Permanent ground anchor elongation measurements shall be taken at each load increment as specified in Sections 6-17.3(8)A and 6-17.3(8)B.
5. Steps 1 through 4 shall be repeated at each increment of load, in accordance with the load sequence specified in Sections 6-17.3(8)A and 6-17.3(8)B.

6-17.3(8)A Verification Testing

Verification tests will be required only when specified in the Special Provisions.

6-17.3(8)B Performance Testing

Performance tests shall be done in accordance with the following procedures.
Five percent of the ground anchors or a minimum of three ground anchors, whichever is greater, shall be performance tested. The Engineer shall select the ground anchors to be performance tested. The first production anchor shall be performance tested.

The performance test shall be made by incrementally loading and unloading the ground anchor in accordance with the following schedule, consistent with the Load Resistance Factor Design (LRFD) design method. The load shall be raised from one increment to another immediately after a deflection reading.

Performance Test Schedule
Load
AL
0.25FDL
AL
0.25FDL
0.50FDL
AL
0.25FDL
0.50FDL
0.75FDL
AL
0.25FDL
0.50FDL
0.75FDL
1.00FDL
AL
Jack to lock-off load

Where:

AL is the alignment load

FDL is the factored design load.

The maximum test load in a performance test shall be held for 10 minutes. The load-hold period shall start as soon as the maximum test load is applied and the anchor movement, with respect to a fixed reference, shall be measured and recorded at 1, 2, 3, 4, 5, 6, and 10 minutes. If the anchor movement between 1 and 10 minutes exceeds 0.04 inches, the maximum test load shall be held for an additional 50 minutes. If the load-hold is extended, the anchor movement shall be recorded at 20, 30, 40, 50, and 60 minutes. If an anchor fails in creep, retesting will not be allowed. All anchors not performance tested shall be proof tested.

6-17.3(8)C Proof Testing

Proof tests shall be performed by incrementally loading the ground anchor in accordance with the following schedule, consistent with the LRFD design method. The load shall be raised from one increment to another immediately after a deflection reading. The anchor movement shall be measured and recorded to the nearest 0.001 inches with respect to an independent fixed reference point at the alignment load and at each increment of load. The load shall be monitored with a pressure gauge. At load increments other than the maximum test load, the load shall be held just long enough to obtain the movement reading.

Proof Test Schedule
Load
AL
0.25FDL
0.50FDL
0.75FDL
1.00FDL
Jack to lock-off load

Where:

AL is the alignment load

FDL is the factored design load

The maximum test load in a proof test shall be held for 10 minutes. The load-hold period shall start as soon as the maximum test load is applied and the anchor movement with respect to a fixed reference shall be measured and recorded at 1, 2, 3, 4, 5, 6, and 10 minutes. If the anchor movement between 1 and 10 minutes exceeds 0.04 inches, the maximum test load shall be held of an additional 50 minutes. If the load-hold is extended, the anchor movements shall be recorded at 20, 30, 40, 50, and 60 minutes. If an anchor fails in creep, retesting will not be allowed.

6-17.3(9) Permanent Ground Anchor Acceptance Criteria

A performance or proof tested ground anchor with a 10 minute load hold is acceptable if the:

1. Ground anchor carries the maximum test load with less than 0.04 inches of movement between 1 and 10 minutes; and
2. Total movement at the maximum test load exceeds 80 percent of the theoretical elastic elongation of the tendon unbonded length.

A verification, performance or proof tested ground anchor with a 60-minute load hold is acceptable if the:

1. Ground anchor carries the maximum test load with a creep rate that does not exceed 0.08 inches/log cycle of time and is a linear or decreasing creep rate.
2. Total movement at the maximum test load exceeds 80 percent of the theoretical elastic elongation of the tendon unbonded length.

If the total movement of the ground anchors at the maximum test load does not exceed 80 percent of the theoretical elastic elongation of the tendon unbonded length, the Contractor shall replace the ground anchor at no additional cost to the Contracting Agency. Retesting of a ground anchor will not be allowed.

When a ground anchor fails, the Contractor shall modify the design, the construction procedures, or both. These modifications may include, but are not limited to, installing replacement ground anchors, modifying the installation methods, increasing the bond length or changing the ground anchor type. Any modification that requires changes to

the Structure shall have prior approval of the Engineer. Any modifications of design or construction procedures shall be at the Contractor's expense.

Upon completion of the test, the load shall be adjusted to the lock-off load indicated in the Plans and transferred to the anchorage device. The ground anchor may be completely unloaded prior to lock-off. After transferring the load and prior to removing the jack a lift-off reading shall be made. The lift-off reading shall be within 10 percent of the specified lock-off load.

If the load is not within 10 percent of the specified lock-off load, the anchorage shall be reset and another lift-off reading shall be made. This process shall be repeated until the desired lock-off load is obtained.

6-17.4 Measurement

Permanent ground anchors will be measured per each for each permanent ground anchor installed and accepted.

Permanent ground anchor performance tests will be measured per each for each anchor performance tested.

The permanent ground anchor verification testing program will not be measured but will be paid for on a lump sum basis.

6-17.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Permanent Ground Anchor", per each.

All costs in connection with furnishing and installing permanent ground anchors shall be included in the unit Contract price per each for "Permanent Ground Anchor", including proof testing of the installed anchor as specified

"Permanent Ground Anchor Performance Test", per each.

"Permanent Ground Anchor Verification Test", lump sum.

6-18 Shotcrete Facing

6-18.1 Description

This Work consists of constructing shotcrete facing as shown on the Plans. Shotcrete constructed as concrete slope protection shall be constructed in accordance with Section 8-16.

6-18.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Portland Cement Concrete	9-03.1
Premolded Joint Filler	9-04.1(2)
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Concrete Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Ground Granulated Blast Furnace Slag	9-23.10
Microsilica Fume	9-23.11
Water	9-25

Other materials required, including materials for shotcrete, shall be as specified in the Special Provisions.

6-18.3 Construction Requirements

6-18.3(1) Submittals

The Contractor shall submit Type 2 Working Drawings consisting of the following:

1. The shotcrete mix design with compressive strength test results.
2. Method and equipment used to apply, finish and cure the shotcrete facing.
3. Documentation of the experience of the nozzle operators in applying shotcrete.

6-18.3(2) Mix Design

Shotcrete shall be proportioned to produce a 4,000 psi compressive strength at 28 days.

Admixture shall be used only after receiving permission from the Engineer. If admixtures are used to entrain air, to reduce water-cement ratio, to retard or accelerate setting time, or to accelerate the development of strength, the admixtures shall be used at the rate specified by the manufacturer.

6-18.3(3) Testing

The Contractor shall make shotcrete test panels for evaluation of shotcrete quality, strength, and aesthetics. Both preproduction and production test panels shall be prepared. The Contractor shall remove at least three cores from shotcrete test panels in accordance with ASTM C1604, except all cores obtained for the purpose of shotcrete strength testing shall meet the following:

1. The core diameter shall be at least 3.0 times the maximum aggregate size, but not less than 4 inches.
2. The core length shall be a minimum of 2.0 times the core diameter.
3. Cores shall be taken at a minimum distance of 1 inch from edge of core to edge of test panel and a minimum clear distance of 1 inch between them.
4. Test panels shall be sized to meet the core spacing specified above, but in no case shall be smaller than 12 by 12 inch.

Cores removed from the panels shall be wiped off to remove surface drill water and immediately wrapped in wet burlap and sealed in a plastic bag. Cores shall be clearly marked to identify from where they were taken and whether they are for preproduction or production testing. If for production testing, the section of the wall represented by the cores shall be clearly marked on the cores. Cores shall be delivered to the Engineer within 2 hours of coring. The remainder of the panels shall remain the property of the Contractor.

6-18.3(3)A Preproduction Testing

At least three cores for each mix design shall be prepared for evaluation and testing of the shotcrete quality and strength. One 48 by 48-inch qualification panel shall be prepared for evaluation and approval of the proposed method for shotcrete installation, finishing, and curing. Both the test panel and the 48-inch qualification panels shall be constructed using the same methods and initial curing proposed to construct the shotcrete facing, except that the test panel shall not include wire reinforcement. The test panel shall be constructed to the minimum thickness necessary to obtain the required core samples. The 48-inch qualification panel shall be constructed to the same thickness as proposed for the production facing. Production shotcrete Work shall not begin until satisfactory test results are obtained and the panels are accepted by the Engineer.

6-18.3(3)B Production Testing

The Contractor shall provide three cores for each section of facing shot. The production panels shall be constructed using the same methods and initial curing used to construct the shotcrete wall, but without wire reinforcement. The panels shall be constructed to the minimum thickness necessary to obtain the required core samples. If the production shotcrete is found to be unsuitable based on the results of the test panels, the section(s) of the wall represented by the test panel(s) shall be repaired or replaced to the satisfaction of the Engineer at no additional cost to the Contracting Agency. Core acceptance testing for the 28-day compressive strength will be performed in accordance with ASTM C1604.

6-18.3(4) Qualifications of Contractor's Personnel

All nozzle operators shall have had at least 1 year of experience in the application of shotcrete. Each nozzle operator will be qualified, by the Engineer, to place shotcrete, after successfully completing one test panel for each shooting position and surface type which will be encountered.

Qualification will be based on a visual inspection of the shotcrete density, void structure, and finished appearance along with a minimum 7-day compressive strength of 2,500 psi determined from the average test results from two cores taken from each test panel. The 7-day core compressive strength shall be tested by the Contractor in accordance with ASTM C1604.

The Contractor shall notify the Engineer not less than 2 days prior to the shooting of a qualification panel. The mix design for the shotcrete shall be the same as that slated for the wall being shot.

Shotcrete shall be placed only by personnel qualified by the Engineer.

If shotcrete finish Alternative B or C is specified, evidence shall be provided that all shotcrete crew members have completed at least three projects in the last 5 years where such finishing, or sculpturing and texturing of shotcrete was performed.

6-18.3(5) Placing Wire Reinforcement

Reinforcement of the shotcrete shall be placed as shown in the Plans. The wire reinforcement shall be securely fastened to the steel reinforcing bars so that it will be 1 to 1.5 inches from the face of the shotcrete at all locations, unless otherwise shown in the Plans. Wire reinforcement shall be lapped 1.5 squares in all directions, unless otherwise shown in the Plans.

6-18.3(6) Alignment Control

The Contractor shall install non-corroding alignment wires and thickness control pins to establish thickness and plane surface. The Contractor shall install alignment wires at corners and offsets not established by formwork. The Contractor shall ensure that the alignment wires are tight, true to line, and placed to allow further tightening. The Contractor shall remove the alignment wires after facing construction is complete.

6-18.3(7) Shotcrete Application

A clean, dry supply of compressed air sufficient for maintaining adequate nozzle velocity for all parts for the Work and for simultaneous operation of a blow pipe for cleaning away rebound shall be maintained at all times. Thickness, method of support, air pressure, and rate of placement of shotcrete shall be controlled to prevent sagging or sloughing of freshly applied shotcrete.

The shotcrete shall be applied from the lower part of the area upwards. Surfaces to be shot shall be damp, but free of standing water.

The nozzles shall be held at an angle approximately perpendicular to the working face and at a distance that will keep rebound at a minimum and compaction will be maximized. Shotcrete shall emerge from the nozzle in a steady uninterrupted flow. If, for any reason, the flow becomes intermittent, the nozzle shall be diverted from the Work until a steady flow resumes.

Surface defects shall be repaired as soon as possible after initial placement of the shotcrete. All shotcrete which lacks uniformity; which exhibits segregation, honeycombing, or lamination; or which contains any dry patches, slugs, voids, or sand pockets, shall be removed and replaced with fresh shotcrete by the Contractor, to the satisfaction of the Engineer at no cost to the Contracting Agency.

Construction joints in the shotcrete shall be uniformly tapered over a minimum distance of twice the thickness of the shotcrete layer. The surface of the joints shall be cleaned and thoroughly wetted before adjacent shotcrete is placed. Shotcrete shall be placed in a manner that provides a finish with uniform texture and color across the construction joint.

The shotcrete shall be cured by applying a clear curing compound in accordance with Section 9-23.2. The curing compound shall be applied immediately after final gunning. Two coats of curing compound shall be applied to the shotcrete surface immediately after finishing. When shotcrete is specified in the Plans as the final fascia finish, the curing requirements specified in Section 6-02.3(11) shall apply.

If field inspection or testing, by the Engineer, indicates that any shotcrete produced, fails to meet the requirements, the Contractor shall immediately modify procedures, equipment, or system, as necessary to produce Specification Material. All substandard shotcrete already placed shall be repaired by the Contractor, to the satisfaction of the Engineer, at no additional cost to the Contracting Agency. Such repairs may include removal and replacement of all affected materials.

6-18.3(8) Shotcrete Finishing

When the shotcrete facing is an interim coating to be covered by a subsequent shotcrete coating or a cast-in-place concrete fascia later under the same Contract, the Contractor shall strike off the surface of the shotcrete facing with a roughened surface as specified in Section 6-02.3(12). The grooves of the roughened surface shall be either vertical or horizontal.

When the shotcrete facing provides the finished exposed final surface, the shotcrete face shall be finished using the alternative aesthetic treatment shown in the Plans. The alternatives are as follows:

- **Alternative A** – After the surface has taken its initial set (crumbling slightly when cut), the surface shall be broom finished to secure a uniform surface texture.
- **Alternative B** – Shotcrete shall be applied in a thickness a fraction beyond the alignment wires and forms. The shotcrete shall stiffen to the point where the surface does not pull or crack when screeded with a rod or trowel. Excess material shall be trimmed, sliced, or scraped to true lines and grade. Alignment wires shall be removed and the surface shall receive a steel trowel finish, leaving a smooth uniform texture and color. Once the shotcrete has cured, pigmented sealer shall be applied to the

shotcrete face. The shotcrete surface shall be completed to within a tolerance of ½ inch of true line and grade.

- **Alternative C** – Shotcrete shall be hand-sculptured, colored, and textured to simulate the relief, jointing, and texture of the natural backdrop surrounding the facing. The ends and base of the facing shall transition in appearance as appropriate to more nearly match the color and texture of the adjoining Roadway fill slopes. This may be achieved by broadcasting fine and coarse aggregates, rocks, and other native materials into the final surface of the shotcrete while it is still wet, allowing sufficient embedment into the shotcrete to become a permanent part of the surface.

6-18.4 Measurement

Shotcrete facing will be measured by the square foot surface area of the completed facing measured to the neat lines of the facing as shown in the Plans.

6-18.5 Payment

Payment will be made for each of the following Bid items when they are included in the Proposal:

"Shotcrete Facing", per square foot.

All costs in connection with constructing shotcrete facing as specified shall be included in the unit Contract price per square foot for "Shotcrete Facing" including all steel reinforcing bars, premolded joint filler, polyethylene bond breaker strip, joint sealant, PVC pipe for weep holes, exterior surface finish, and pigmented sealer (when specified).

6-19 Shafts

6-19.1 Description

This work consists of constructing the shafts, including concrete-filled steel tube (CFST) shafts, in accordance with the Plans, these Specifications, and as designated by the Engineer.

6-19.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Curing Materials and Admixtures	9-23
Fly Ash	9-23.9
Ground Granulated Blast Furnace Slag	9-23.10
Microsilica Fume	9-23.11
Water for Concrete	9-25.1
Permanent Casing	9-36.1(1)
Temporary Casing	9-36.1(2)
Mineral Slurry	9-36.2(1)
Synthetic Slurry	9-36.2(2)
Water Slurry	9-36.2(3)
Steel Reinforcing Bar Centralizers	9-36.3
Access Tubes and Caps	9-36.4
Grout for Access Tubes	9-36.5

6-19.3 Construction Requirements

6-19.3(1) Quality Assurance

6-19.3(1)A Shaft Construction Tolerances

Shafts shall be constructed so that the center at the top of the shaft is within the following horizontal tolerances:

Shaft Diameter (feet)	Tolerance (inches)
Less than or equal to 2	3
Greater than 2 and less than 5	4
5 or larger	6

Shafts shall be within 1.5 percent of plumb. For rock excavation, allowable tolerance can be increased to 2 percent maximum.

During drilling or excavation of the shaft, the Contractor shall make frequent checks on the plumbness, alignment, and dimensions of the shaft. Any deviation exceeding the allowable tolerances shall be corrected with a procedure approved by the Engineer.

Shaft steel reinforcing bar placement tolerances shall conform to Section 6-02.3(24)C. The elevation of the top of the reinforcing cage for drilled shafts shall be within +6 inches and -3 inches from the elevation shown in the Plans.

6-19.3(1)B Nondestructive Testing of Shafts

6-19.3(1)B1 Nondestructive Quality Assurance (QA) Testing of Shafts

Unless otherwise specified in the Special Provisions, the Contractor shall perform nondestructive QA testing of shafts, except for those constructed completely in the dry. Either crosshole sonic log (CSL) testing in accordance with ASTM D 6760 or thermal integrity profiling (TIP) testing in accordance with ASTM D 7949 shall be used.

6-19.3(1)B2 Nondestructive Quality Verification (QV) Testing of Shafts

The Contracting Agency may perform QV nondestructive testing of shafts that have been QA tested by the Contractor. The Contracting Agency may test up to ten percent of the shafts. The Engineer will identify the shafts selected for QV testing and the testing method the Contracting Agency will use.

The Contractor shall accommodate the Contracting Agency's nondestructive testing.

6-19.3(1)C Shaft Preconstruction Conference

A shaft preconstruction conference shall be held at least 5 working days prior to the Contractor beginning any shaft construction work at the site to discuss construction procedures, personnel, and equipment to be used, and other elements of the approved shaft installation narrative as specified in Section 6-19.3(2)B. Those attending shall include:

1. (Representing the Contractor) – The superintendent, on site supervisors, and all foremen in charge of excavating the shaft, placing the casing and slurry as applicable, placing the steel reinforcing bars, and placing the concrete. If synthetic slurry is used to construct the shafts, the slurry manufacturer's representative or approved Contractor's employees trained in the use of the synthetic slurry shall also attend.
2. (Representing the Contracting Agency) – The Engineer, key inspection personnel, and representatives from the WSDOT Construction Office and Materials Laboratory, Geotechnical Division.

If the Contractor proposes a significant revision of the approved shaft installation narrative, as determined by the Engineer, an additional conference shall be held before any additional shaft construction operations are performed.

6-19.3(2) Shaft Construction Submittal

The shaft construction submittal shall be comprised of the following four components: construction experience; shaft installation narrative; shaft slurry technical assistance; and nondestructive QA testing personnel. The submittals shall be Type 2 Working Drawings, except the shaft slurry technical assistance and nondestructive QA testing personnel submittals shall be Type 1.

6-19.3(2)A Construction Experience

The Contractor shall submit a project reference list to the Engineer for approval verifying the successful completion by the Contractor of at least three separate foundation projects with shafts of diameters and depths similar to or larger than those shown in the Plans, and ground conditions similar to those identified in the Contract. A brief description of each listed project shall be provided along with the name and current phone number of the project owner or the owner's Contractor.

The Contractor shall submit a list identifying the on-site supervisors and drill rig operators potentially assigned to the project to the Engineer. The list shall contain a brief description of each individual's experience in shaft excavation operations and placement of assembled steel reinforcing bar cages and concrete in shafts. The individual experience lists shall be limited to a single page for each supervisor or operator.

1. On-site supervisors shall have a minimum 2 years experience in supervising construction of shaft foundations of similar size (diameter and depth) and scope to those shown in the Plans, and similar geotechnical conditions to those described in the boring logs and summary of geotechnical conditions. Work experience shall be direct supervisory responsibility for the on-site shaft construction operations. Project management level positions indirectly supervising on-site shaft construction operations is not acceptable for this experience requirement.
2. Drill rig operators shall have a minimum of 1 year experience in construction of shaft foundations.

The Engineer may suspend the shaft construction if the Contractor substitutes unapproved personnel. The Contractor shall be fully liable for the additional costs resulting from the suspension of work, and no adjustments in contract time resulting from the suspension of work will be allowed.

6-19.3(2)B Shaft Installation Narrative

The Contractor shall submit a shaft installation narrative to the Engineer. In preparing the narrative, the Contractor shall reference the available subsurface data provided in the contract test hole boring logs, the Summary of Geotechnical Conditions provided in the Appendix to the Special Provisions, and the geotechnical report(s) prepared for this project. This narrative shall provide at least the following information:

1. Proposed overall construction operation sequence.
2. Description, size, and capacities of proposed equipment, including but not limited to, cranes, drills, auger, bailing buckets, final cleaning equipment, and drilling unit. The

narrative shall describe why the equipment was selected, and describe equipment suitability to the anticipated site conditions and work methods. The narrative shall include a project history of the drilling equipment demonstrating the successful use of the equipment on shafts of equal or greater size in similar soil/rock conditions. The narrative shall also include details of shaft excavation and cleanout methods.

3. Details of the method(s) to be used to ensure shaft stability (i.e., prevention of caving, bottom heave, using temporary casing, slurry, or other means) during excavation (including pauses and stoppages during excavation) and concrete placement. If permanent casings are required, casing dimensions and detailed procedures for installation shall be provided.

4. A slurry mix design, including all additives and their specific purpose in the slurry mix, with a discussion of its suitability to the anticipated subsurface conditions, shall be submitted and include the procedures for mixing, using, and maintaining the slurry.

   A detailed plan for quality control of the selected slurry, including tests to be performed, test methods to be used, and minimum and/or maximum property requirements which must be met to ensure the slurry functions as intended, considering the anticipated subsurface conditions and shaft construction methods, in accordance with the slurry manufacturer's recommendations and these Special Provisions shall be included. As a minimum, the slurry quality control plan shall include the following tests:

Property	Test Method
Density	Mud Weight (Density), API 13B-1, Section 1
Viscosity	Marsh Funnel and Cup, API 13B-1, Section 2.2
PH	Glass Electrode, pH Meter, or pH Paper
Sand Content	Sand, API 13B-1, Section 5

5. Description of the method used to fill or eliminate all voids below the top of shaft between the plan shaft diameter and excavated shaft diameter, when permanent casing is specified.

6. Details of concrete placement, including proposed operational procedures for pumping methods, and a sample uniform yield form to be used by the Contractor for plotting the approximate volume of concrete placed versus the depth of shaft for all shaft concrete placement (except concrete placement in the dry).

7. When shafts are constructed in water, the submittal shall include seal thickness calculations, seal placement procedure, and descriptions of provisions for casing shoring dewatering and flooding.

8. Description and details of the storage and disposal plan for excavated material and drilling slurry (if applicable).

9. Reinforcing steel shop drawings with details of reinforcement placement, including bracing, centering, and lifting methods, and the method to ensure the reinforcing cage position is maintained during construction, including use of bar boots and/or rebar cage base plates, and including placement of rock backfill below the bottom of shaft elevation, provided the conditions of Section 6-19.3(5)D are satisfied.

   The reinforcing steel shop drawings and shaft installation narrative shall include, at a minimum:

   a. Procedure and sequence of steel reinforcing bar cage assembly.

   b. The tie pattern, tie types, and tie wire gages for all ties on permanent reinforcing and temporary bracing.

   c. Number and location of primary handling steel reinforcing bars used during lifting operations.

   d. Type and location of all steel reinforcing bar splices.

   e. Details and orientation of all internal cross-bracing, including a description of connections to the steel reinforcing bar cage.

   f. Description of how temporary bracing is to be removed.

   g. Location of support points during transportation.

   h. Cage weight and location of the center of gravity.

   i. Number and location of pick points used for lifting for installation and for transport (if assembled off-site).

   j. Crane charts and a description and/or catalog cuts for all spreaders, blocks, sheaves, and chockers used to equalize or control lifting loads.

   k. The sequence and minimum inclination angle at which intermediate belly rigging lines (if used) are released.

   l. Pick point loads at 0, 45, 60, and 90 degrees and at all intermediate stages of inclination where rigging lines are engaged or slackened.

   m. Methods and temporary supports required for cage splicing.

   n. For picks involving multiple cranes, the relative locations of the boom tips at various stages of lifting, along with corresponding net horizontal forces imposed on each crane.

10. Methods and equipment used to clean the interior surfaces of the CFST permanent casing, including pressure flushing, brushing and scraping, prior to placing steel reinforcing bars and concrete.

11. Methods, equipment, weld details, and welding procedures for installing shear rings at the top of CFST permanent casing when shown in the Plans.

The Engineer will evaluate the shaft installation narrative for conformance with the Plans, Specifications, and Special Provisions, within the review time specified. If deemed necessary by the Engineer, a Shaft Installation Narrative Submittal Teleconference Meeting will be scheduled by the Contracting Agency following review of the Contractor's initial submittal of the narrative and prior to Contracting Agency's formal response to the initial submittal. Teleconference participants shall include the following:

1. (Representing the Contractor) – The superintendent, on-site supervisors, and other Contractor personnel involved in the preparation of the shaft installation narrative.
2. (Representing the Contracting Agency) – The Engineer, key inspection personnel, and representatives from the Materials Laboratory, Geotechnical Division, and the WSDOT Construction Office.

6-19.3(2)C Shaft Slurry Technical Assistance

If slurry other than water slurry is used to construct the shafts, the Contractor shall provide or arrange for technical assistance in the use of the slurry as specified in Section 6-19.3(4)A. The Contractor shall submit the following to the Engineer:

1. The name and current phone number of the slurry manufacturer's technical representative assigned to the project, and the frequency of scheduled visits to the project site by the synthetic slurry manufacturer's representative.
2. The name(s) of the Contractor's personnel assigned to the project and trained by the slurry manufacturer in the proper use of the slurry. The submittal shall include a signed training certification letter from the slurry manufacturer for each trained Contractor's employee listed, including the date of the training.

6-19.3(2)D Nondestructive QA Testing Organization and Personnel

The Contractor shall submit the names of the testing organizations, and the names of the personnel who will conduct nondestructive QA testing of shafts. The submittal shall include documentation that the qualifications specified below are satisfied. For TIP testing, the testing organization is the group that performs the data analysis and produces the final report. The testing organizations and the testing personnel shall meet the following minimum qualifications:

1. The testing organization shall have performed nondestructive tests on a minimum of three deep foundation projects in the last two years.
2. Personnel conducting the tests for the testing organization shall have a minimum of one year experience in nondestructive testing and interpretation.
3. The experience requirements for the organization and personnel shall be consistent with the testing methods the Contractor has selected for nondestructive testing of shafts.
4. Personnel preparing test reports shall be a Professional Engineer, licensed under Title 18 RCW, State of Washington, and shall seal the report in accordance with WAC 196-23-020.

6-19.3(3) Shaft Excavation

Shafts shall be excavated to the required depth as shown in the Plans. Shaft excavation operations shall conform to this section and the shaft installation narrative.

Shaft excavation shall not be started until the Contractor has received the Engineer's acceptance for the reinforcing steel centralizers required when the casing is to be pulled during concrete placement.

Except as otherwise noted, the Contractor shall not commence subsequent shaft excavations until receiving the Engineer's acceptance of the first shaft, based on the results and analysis of the nondestructive testing for the first shaft. The Contractor may commence subsequent shaft excavations prior to receiving the Engineer's acceptance of the first shaft, provided the following condition is satisfied:

> The Engineer permits continuing with shaft construction based on the Engineer's observations of the construction of the first shaft, including, but not limited to, conformance to the shaft installation narrative in accordance with Section 6-19.3(2)B, and the Engineer's review of Contractor's daily reports and Inspector's daily logs concerning excavation, steel reinforcing bar placement, and concrete placement.

6-19.3(3)A Conduct of Shaft Excavation Operations

Once the excavation operation has been started, the excavation shall be conducted in a continuous operation until the excavation of the shaft is completed, except for pauses and stops as noted, using approved equipment capable of excavating through the type of material expected. Pauses during this excavation operation, except for casing splicing, tooling changes, slurry maintenance, and removal of obstructions, are not allowed.

Pauses, defined as momentary interruptions of the excavation operation, will be allowed only for casing splicing, tooling changes, slurry maintenance, and removal of obstructions. Shaft excavation operation interruptions not conforming to this definition shall be considered stops. Stops for uncased excavations (including partially cased excavations) shall not exceed 16 hours duration. Stops for fully cased excavations, excavations in rock, and excavations with casing seated into rock, shall not exceed 65 hours duration.

For stops exceeding the time durations specified above, the Contractor shall stabilize the excavation using one or both of the following methods:

1. For an uncased excavation, before the end of the work day, install casing in the hole to the depth of the excavation. The outside diameter of the casing shall not be smaller than 6 inches less than either the plan diameter of the shaft or the actual excavated diameter of the hole, whichever is greater. Prior to removing the casing and resumption of shaft excavation, the annular space between the casing and the excavation shall be sounded. If the sounding operation indicates that caving has occurred, the casing shall not be removed and shaft excavation shall not resume until the Contractor has stabilized the excavation in accordance with the shaft installation narrative conforming to Section 6-19.3(2)B, item 3.

2. For both a cased and uncased excavation, backfill the hole with either CDF or granular material. The Contractor shall backfill the hole to the ground surface, if the excavation is not cased, or to a minimum of 5 feet above the bottom of casing (temporary or permanent), if the excavation is cased. Backfilling of shafts with casing fully seated into rock, as determined by the Engineer, will not be required.

During stops, the Contractor shall stabilize the shaft excavation to prevent bottom heave, caving, head loss, and loss of ground. The Contractor bears full responsibility for selection and execution of the method(s) of stabilizing and maintaining the shaft excavation, in accordance with Section 1-07.13. Shaft stabilization shall conform to the shaft installation narrative in accordance with Section 6-19.3(2)B, item 3.

If slurry is present in the shaft excavation, the Contractor shall conform to the requirements of Section 6-19.3(4)B of this Special Provision regarding the maintenance of the slurry and the minimum level of drilling slurry throughout the stoppage of the shaft excavation operation, and shall recondition the slurry to the required slurry properties in accordance with Section 9-36.2 prior to recommencing shaft excavation operations.

6-19.3(3)B Temporary and Permanent Shaft Casing

The Contractor shall furnish and install required temporary and permanent shaft casings as shown in the Plans and as specified in the Special Provisions.

6-19.3(3)B1 General Shaft Casing Requirements

Shaft casing shall be watertight and clean prior to placement in the excavation.

The outside diameter of the casing shall not be less than the specified diameter of the shaft, except when metric casing is specified for 4, 5, and 10 foot nominal shaft diameters, the outside diameter of the casing shall not be less than the specified diameter of the shaft minus 2 inches. The inside diameter of the casing shall not be greater than the specified diameter of the shaft plus 6 inches, except as otherwise noted for shafts 5 feet or less in diameter, and as otherwise noted in Section 6-19.3(3)B4 for temporary telescoping casing. The inside diameter of casings for shafts 5 feet or less in diameter shall not be greater than the specified diameter of the shaft plus 1 foot.

6-19.3(3)B2 Permanent Shaft Casing

Permanent casing is defined as casing designed as part of the shaft structure and installed to remain in place after construction is complete. All permanent casing shall be of ample strength to resist damage and deformation from transportation and handling, installation stresses, and all pressures and forces acting on the casing. Where the minimum thickness of permanent casing is specified in the Plans, it is specified to satisfy structural design requirements only. The Contractor shall increase the casing thickness as necessary to satisfy the requirements of this section.

For permanent casing for CFST shafts, see Section 6-19.3(3)J.

6-19.3(3)B3 Temporary Shaft Casing

Temporary casing is defined as casing installed to facilitate shaft construction only, which is not designed as part of the shaft structure, and which shall be completely removed after shaft construction is complete unless otherwise shown in the Plans. All temporary casing shall be of ample strength to resist damage and deformation from transportation and handling, installation and extraction stresses, and all pressures and forces acting on the casing. The casing shall be capable of being removed without deforming and causing damage to the completed shaft and without disturbing the surrounding soil.

To maintain stable excavations and to facilitate construction, the Contractor may furnish and install temporary casing in addition to the required casing specified in the Special Provisions. The Contractor shall provide temporary casing at the site in sufficient quantities to meet the needs of the anticipated construction method.

6-19.3(3)B4 Temporary Telescoping Shaft Casing

Where the acceleration coefficient used for seismic design of the structure, as specified in the General Notes of the Structure Plans, is less than or equal to 0.16, the Contractor may use temporary telescoping casing for the shafts at any bridge intermediate or interior pier, subject to the following conditions:

1. The Contractor shall submit the request to use temporary telescoping casing as a Type 2 Working Drawing. The request shall specify the diameters of the temporary telescoping casing, and shall specify the shafts where use is requested. The Contractor shall not proceed with the use of temporary telescoping casing until receiving the Engineer's approval.
2. The minimum diameter of the shaft shall be as shown in the Plans.
3. The temporary telescoping casing shall conform to Sections 6-19.3(3)B1, 6-19.3(3)B3, and 9-36.1(2).

The Contractor may use temporary telescoping casing for the shafts of any bridge end pier, regardless of the acceleration coefficient used for the seismic design of the structure, subject to conditions 2 and 3 specified above and the following two additional conditions:

4. A maximum of two telescoping casing diameter changes will be allowed.
5. The maximum diameter change at each casing diameter transition shall be 12 inches.

6-19.3(3)B5 Permanent Slip Casing

Permanent slip casing is defined as casing installed vertically inside the temporary casing within the limits of the column-shaft splice zone, and wet-set into the shaft concrete no more than 3 feet below the column-shaft construction joint, allowing subsequent removal of the temporary casing. The casing diameter requirements of Section 6-19.3(3)B1 do not apply to permanent slip casing, but the inside diameter of the permanent slip casing shall provide the steel reinforcing bar clearance specified in Section 6-19.3(5)C.

6-19.3(3)C Conduct of Shaft Casing Installation and Removal and Shaft Excavation Operations

The Contractor shall conduct casing installation and removal operations and shaft excavation operations such that the adjacent soil outside the casing and shaft excavation for the full height of the shaft is not disturbed. Disturbed soil is defined as soil whose geotechnical properties have been changed from those of the original in situ soil, and whose altered condition adversely affects the structural integrity of the shaft foundation. In no case shall shaft excavation and casing placement extend below the bottom of shaft excavation as shown in the Plans.

6-19.3(3)D Bottom of Shaft Excavation

The Contractor shall use appropriate means such as a cleanout bucket or air lift to clean the bottom of the excavation of all shafts. No more than 2 inches of loose or disturbed material shall be present at the bottom of the shaft just prior to placing concrete.

The excavated shaft shall be inspected and accepted by the Engineer prior to proceeding with construction. The bottom of the excavated shaft shall be sounded with an airlift pipe, a tape with a heavy weight attached to the end of the tape, or other means acceptable to the Engineer to determine that the shaft bottom meets the requirements in the Contract.

6-19.3(3)E Shaft Obstructions

When obstructions are encountered, the Contractor shall notify the Engineer promptly. An obstruction is defined as a specific object (including, but not limited to, boulders, logs, and man made objects) encountered during the shaft excavation operation which prevents or hinders the advance of the shaft excavation. When efforts to advance past the obstruction to the design shaft tip elevation result in the rate of advance of the shaft drilling equipment being significantly reduced relative to the rate of advance for the portion of the shaft excavation in the geological unit that contains the obstruction, then the Contractor shall remove, break up, or push aside the obstruction under the provisions of Section 6-19.5. The method of dealing with such obstructions, and the continuation of excavation shall be as proposed by the Contractor and accepted by the Engineer.

6-19.3(3)F Voids Between Permanent Casing and Shaft Excavation

When permanent casing is specified, excavation shall conform to the specified outside diameter of the shaft. After the casing has been filled with concrete, all void space occurring between the casing and shaft excavation shall be filled with a material which approximates the geotechnical properties of the in situ soils, in accordance with the shaft installation narrative specified in Section 6-19.3(2)B, item 5.

6-19.3(3)G Operating Shaft Excavation Equipment From an Existing Bridge

Drilling equipment shall not be operated from an existing bridge, except as otherwise noted. If necessary and safe to do so, and if the Contractor submits a Type 2 Working Drawing consisting of a written request in accordance with Section 6-01.6, the Engineer may permit operation of drilling equipment on a bridge.

6-19.3(3)H Seals for Shaft Excavation in Water

When shafts are constructed in water and the Plans show a seal between the casing shoring and the upper portion of the permanent casing of the shaft, the Contractor shall construct a seal in accordance with the shaft installation narrative specified in Section 6-19.3(2)B, item 7.

Concrete for the casing shoring seal shall be Class 4000W conforming to Section 6-02.

The seal thickness shown in the Plans is designed to resist the hydrostatic uplift force with the corresponding seal weight and adhesion of the seal to the permanent casing and the casing shoring of 20 psi, based on the casing shoring dimension and the seal vent water surface elevation specified in the Plans. If the Contractor uses a casing shoring diameter other than that specified in the Plans, the Contractor shall submit a revised seal design in accordance with Section 6-19.3(2)B, item 7.

6-19.3(3)I Required Use of Slurry in Shaft Excavation

The Contractor shall use slurry, in accordance with Section 6-19.3(4), to maintain a stable excavation during excavation and concrete placement operations once water begins to enter the shaft excavation at an infiltration rate of 12 inches of depth or more in 1 hour. If concrete is to be placed in the dry, the Contractor shall pump all accumulated water in the shaft excavation down to a 3-inch maximum depth prior to beginning concrete placement operations.

6-19.3(3)J Permanent Shaft Casing for Concrete-Filled Steel Tube (CFST) Shafts

CFST shafts are concrete shafts with permanent steel casing designed to function as a composite structural shaft. The soil within CFST shafts is removed either to the permanent casing tip or to the elevation shown in the Plans. The excavated void within CFST shafts is filled either with unreinforced structural concrete or reinforced structural concrete.

6-19.3(3)J1 Common Requirements for Shop Welding and Field Welding

Welded splices shall conform to Section 6-05.3(6) and as specified herein. A complete penetration groove weld between welded edges is required.

Welding for CFST shaft permanent casing shall conform to AWS D1.1/D1.1M, latest edition, Structural Welding Code, and Section 6-03.3(25), except that all weld filler metal shall be low hydrogen material selected from Table 4.1 in AASHTO/AWS D1.5M/D1.5, latest edition, Bridge Welding Code.

Welding and joint geometry for CFST shaft permanent casing seams, whether it be longitudinal, helical, or girth, shall be qualified in accordance with Clause 4, Qualification, of the AWS D1.1/D1.1M, latest edition, Structural Welding Code.

In addition, charpy V-notch (CVN) testing in accordance with Clause 4, Part D, of the AWS D1.1/D1.1M, latest edition, Structural Welding Code, shall be performed. CVN testing shall include five tests at 0°F. The acceptance threshold for the five samples shall meet an average value of 20-foot-pounds CVN for the set of test coupons and a minimum value of 15-foot-pounds CVN for any individual test coupon. The Contractor may submit documentation of prior qualification to the Engineer to satisfy this requirement.

The Contractor shall submit a Type 2 Working Drawing consisting of the weld procedure (WPS) and associated qualification testing. For ASTM A252 material, mill certification for each lot of steel to be welded shall accompany the Working Drawing submittal.

Skelp splices in spiral welded (helical seam) casing shall not be located within 12 inches of a girth shop or field weld.

Weld repairs shall conform to Section 5.25 of the AWS D1.1/D1.1M, latest edition, Structural Welding Code, using approved repair and weld procedures.

6-19.3(3)J2 Fabricating CFST Shaft Casing

The Contractor shall provide a minimum 14-day notice to the Engineer prior to the start of any CFST shaft permanent casing shop fabrication welding. Quality control for shop fabrication welding shall be conducted by an AWS Certified Welding Inspector (CWI).

Dimensional tolerances for CFST shaft permanent casing shall conform to the following requirements:

1. Out-of-roundness shall be within 1-percent of the nominal outside diameter.
2. Deviation from a straight line, parallel to the centerline of the pile, shall not exceed 0.001 times the length of the casing.
3. The maximum radial offset of the strip/plate edges shall be ⅛-inch. The offset shall be transitioned with a taper weld and the slope shall not be less than a 1 in 2.5 taper.
4. The bead height of weld reinforcement shall not exceed 3⁄16-inch.
5. Misalignment of weld beads for double-sided welded casing shall not exceed ⅛-inch.
6. The wall thickness shall not be less than 95-percent nor greater than 110-percent of the specified nominal thickness.

All seams, girth and skelp splices shall be complete penetration welds. All girth and skelp splices shall be 100 percent radiographically or ultrasonically inspected in accordance with either API 5L Annex E Section E.4 or E.5, or Table 6.2 and Clause 6 Part E, F or G in AWS D1.1/D1.1M, latest edition, Structural Welding Code. Additionally, 10-percent of the total length of seam welds for both longitudinal and helical welded casing, and one casing diameter length of seam centered on any skelp splice intersection, shall be randomly inspected as specified above. If repairs are required in more than 10-percent of the welds examined, additional inspection shall be performed. The additional inspection shall be made on both sides of the repair for a length equal to 10-percent of the length of the casing outside circumference. If repairs are required in more than 10-percent of welds

examined in the second sample, 100-percent of the entire seam on the casing shall be inspected.

All seams, girth and skelp splices shall be 100 percent visually inspected in accordance with the acceptance criteria for statically loaded non-tubular connections in Table 6.1 of the AWS D1.1/D1.1M, latest edition, Structural Welding Code.

6-19.3(3)J3 Field Welding CFST Shaft Casing

The Contractor may perform field welding of CFST shaft permanent casing, provided a Type 2 Working Drawing of a field welding plan has been submitted to and accepted by the Engineer. The field welding plan shall include, at a minimum, the following:

1. Justification and description of need for the field welding operation.
2. Materials and equipment used to conduct the field welding operation.
3. Field welding procedures.

Ends of CFST shaft permanent casing shall be prepared for splicing in accordance with AWS D1.1/D1.1M, latest edition, Structural Welding Code. The ends shall also meet the fit-up requirements of AWS D1.1/D1.1M, latest edition, Structural Welding Code Section 9.24.1 Girth Weld Alignment (Tubular).

All splices shall be complete penetration groove welds using continuous backing rings of ¼ inch minimum thickness. Tack welds shall be located in the root of the complete penetration groove weld.

Field splice welds and welders shall be further qualified, tested and inspected as follows:

1. Welder qualification shall be performed on sample full girth sections of CFST shaft permanent casing to be used, or on a section of casing of the same diameter and with a minimum outside perimeter length of 2-feet, in the same position and using the same weld joint as for production CFST shaft permanent casing splicing.
2. Weld qualification tests shall be conducted in the presence of the Contractor's CWI and a representative of the Contracting Agency.
3. Unless otherwise specified in the Plans, field splices shall be 100-percent visually and ultrasonically inspected (UT) in accordance with the acceptance criteria for statically loaded non-tubular connections in Table 6.1 and the acceptance criteria in Table 6.2 in AWS D1.1/D1.1M, latest edition, Structural Welding Code.

The Contractor may submit a Type 1 Working Drawing of prior welder qualification performed on a CFST of the same diameter or smaller within the last six-months as a substitute for the above welder field weld qualification testing.

Quality control for field welding shall be conducted by an AWS CWI. The Contractor shall not begin splicing operations until receiving the CWI's approval of the joint fit-up. The CWI shall inspect 100 percent of all field welds in accordance with the criteria and requirements specified above. All field splices shall have received the CWI's approval prior to Engineer acceptance.

The CWI shall prepare a Type 1 Working Drawing documenting the results of the nondestructive quality control inspection of all field welds, and shall submit the report to the Engineer within five working days of the completion of the final splice in the project or as otherwise requested by the Engineer.

6-19.3(3)J4 Installing CFST Shaft Casing

Permanent casing for CFST shafts shall be open-ended, installed during shaft excavation operations to the depth shown in the Plans. Excavation in advance of the CFST permanent casing tip shall be limited to that specified in the accepted Shaft Installation Narrative Working Drawing and any limitations specified in the Plans, except in no case below the shaft tip elevation shown in the Plans.

6-19.3(3)J5 Interior Cleaning of CFST Shaft Casing

Prior to placing steel reinforcing bars and concrete, the interior surfaces of the CFST shaft permanent casing shall be cleaned. The cleaning methods and procedure shall be as described in the Shaft Construction Narrative Working Drawing submitted in accordance with Section 6-19.3(2). The cleaning shall remove native soils from the exposed interior surfaces of the CFST shaft permanent casing.

6-19.3(4) Slurry Installation Requirements

6-19.3(4)A Slurry Technical Assistance

If slurry other than water slurry is used, the manufacturer's representative, as identified to the Engineer in accordance with Section 6-19.3(2)C, shall:

1. Provide technical assistance for the use of the slurry,
2. Be at the site prior to introduction of the slurry into the first drilled hole requiring slurry, and
3. Remain at the site during the construction of at least the first shaft excavated to adjust the slurry mix to the specific site conditions.

After the manufacturer's representative is no longer present at the site, the Contractor's employee trained in the use of the slurry, as identified to the Engineer in accordance with Section 6-19.3(2)C, shall be present at the site throughout the remainder of shaft slurry operations for this project to perform the duties specified in items 1 through 3 above.

6-19.3(4)B Minimum Level of Slurry in the Excavation

When slurry is used in a shaft excavation the following is required:

1. The height of the slurry shall be as required to provide and maintain a stable hole to prevent bottom heave, caving, or sloughing of all unstable zones.
2. The Contractor shall provide casing, or other means, as necessary to meet these requirements.

3. The slurry level in the shaft while excavating shall be maintained above the groundwater level the greater of the following dimensions:
   a. Not less than 5 feet for mineral slurries.
   b. Not less than 10 feet for water slurries.
   c. Not less than 10 feet for synthetic slurries.
4. The slurry level in the shaft throughout all stops as specified in Section 6-19.3(3)A and during concrete placement as specified in Section 6-19.3(7) shall be no lower than the water level elevation outside the shaft.

6-19.3(4)C Slurry Sampling and Testing

Mineral slurry and synthetic slurry shall be mixed and thoroughly hydrated in slurry tanks, ponds, or storage areas. The Contractor shall draw sample sets from the slurry storage facility and test the samples for conformance with the specified viscosity and pH properties before beginning slurry placement in the drilled hole. Mineral slurry shall conform to the material specifications in Section 9-36.2(1). Synthetic slurry shall conform to Section 9-36.2(2), the quality control plan included in the shaft installation narrative in accordance with Section 6-19.3(2)B, item 4. A sample set shall be composed of samples taken at mid-height and within 2 feet of the bottom of the storage area.

When synthetic slurry is used, the Contractor shall keep a written record of all additives and concentrations of the additives in the synthetic slurry. These records shall be submitted as a Type 1 Working Drawing once the slurry system has been established in the first drilled shaft on the project. The Contractor shall provide revised data to the Engineer if changes are made to the type or concentration of additives during construction.

The Contractor shall sample and test all slurry in the presence of the Engineer, unless otherwise directed. The date, time, names of the persons sampling and testing the slurry, and the results of the tests shall be recorded. A copy of the recorded slurry test results shall be submitted to the Engineer at the completion of each shaft, and during construction of each shaft when requested by the Engineer.

Sample sets of all slurry, composed of samples taken at mid-height and within 2 feet of the bottom of the shaft and the storage area, shall be taken and tested once every 4 hours minimum at the beginning and during drilling shifts and prior to cleaning the bottom of the hole to verify the control of the viscosity and pH properties of the slurry. Sample sets of all slurry shall be taken and tested at least once every 2 hours if the previous sample set did not have consistent viscosity and pH properties. All slurry shall be recirculated, or agitated with the drilling equipment, when tests show that the sample sets do not have consistent viscosity and pH properties. Cleaning of the bottom of the hole shall not begin until tests show that the samples taken at mid-height and within 2 feet of the bottom of the hole have consistent viscosity and pH properties.

Sample sets of all slurry, as specified, shall be taken and tested to verify control of the viscosity, pH, density, and sand content properties after final cleaning of the bottom of the hole just prior to placing concrete. Placement of the concrete shall not start until tests show that the samples taken at mid-height and within 2 feet of the bottom of the hole have consistent specified properties.

6-19.3(4)D Maintenance of Required Slurry Properties

The Contractor shall clean, recirculate, de-sand, or replace the slurry to maintain the required slurry properties.

6-19.3(4)E Maintenance of a Stable Shaft Excavation

The Contractor shall demonstrate to the satisfaction of the Engineer that stable conditions are being maintained. If the Engineer determines that stable conditions are not being maintained, the Contractor shall immediately take action to stabilize the shaft. The Contractor shall submit a revised shaft installation narrative that addresses the problem and prevents future instability. The Contractor shall not continue with shaft construction until the damage that has already occurred is repaired in accordance with the specifications, and until receiving the Engineer's review of the revised shaft installation narrative.

When mineral slurry conforming to Section 9-36.2(1) is used to stabilize the unfilled portion of the shaft, the Contractor shall remove the excess slurry buildup inside of the shaft diameter prior to continuing with concrete placement. The Contractor shall use the same methods of shaft excavation and the same diameter of drill tools to remove the excess slurry buildup as was used to excavate the shaft to its current depth.

6-19.3(4)F Disposal of Slurry and Slurry Contacted Spoils

The Contractor shall manage and dispose of the slurry wastewater in accordance with Section 8-01.3(1)C. Slurry-contacted spoils shall be disposed of as specified in the shaft installation narrative in accordance with Section 6-19.3(2)B, item 8, and in accordance with the following requirements:

1. Uncontaminated spoils in contact with water-only slurry may be disposed of as clean fill.
2. Uncontaminated spoils in contact with water slurry mixed with flocculants approved in Section 8-01.3(1)C3 may be disposed of as clean fill away from areas that drain to surface waters of the state.
3. Spoils in contact with synthetic slurry or water slurry with polymer-based additives or flocculants not approved in Section 8-01.3(1)C3 shall be disposed of in accordance with Section 2-03.3(7)C. With permission of the Engineer, the Contractor may re-use these spoils on-site.
4. Spoils in contact with mineral slurry shall be disposed of in accordance with Section 2-03.3(7)C. With permission of the Engineer, the Contractor may re-use these spoils on-site.

6-19.3(5) Assembly and Placement of Reinforcing Steel

6-19.3(5)A Steel Reinforcing Bar Cage Assembly

The reinforcing cage shall be rigidly braced to retain its configuration during handling and construction. Individual or loose bars will not be permitted. The Contractor shall show bracing and any extra reinforcing steel required for fabrication of the cage on the shop drawings. Shaft reinforcing bar cages shall be supported on a continuous surface to the extent possible. All rigging connections shall be located at primary handling bars, as identified in the reinforcing steel assembly and installation plan. Internal bracing is required at each support and lift point.

The reinforcement shall be carefully positioned and securely fastened to provide the minimum clearances listed below, and to ensure no displacement of the reinforcing steel bars occurs during placement of the concrete. The steel reinforcing bars shall be securely held in position throughout the concrete placement operation.

6-19.3(5)B Steel Reinforcing Bar Cage Centralizers

The Contractor shall submit details of the proposed reinforcing cage centralizers along with the shop drawings. The reinforcing steel centralizers at each longitudinal space plane shall be placed at least at the quarter points around the circumference of the steel reinforcing bar cage, and at a maximum longitudinal spacing of either 2.5 times the shaft diameter or 20 feet, whichever is less. The Contractor shall furnish and install additional centralizers as required to maintain the specified concrete cover throughout the length of the shaft.

6-19.3(5)C Concrete Cover Over Steel Reinforcing Bars

Steel reinforcing bars shall be placed as shown in the Plans with minimum concrete cover as shown below:

Shaft Diameter (feet)	Minimum Concrete Cover, and Concrete Cover Tolerance, Except at Permanent Slip Casing (inches)	Minimum Concrete Cover at Permanent Slip Casing (inches)
Less than or equal to 3	3, -1½	1½
Greater than 3 and less than 4	4, -2	1½
Greater than or equal to 4 and less than 5	4, -2	2
5 or larger	6, -3	3

The concrete cover tolerances specified above apply to the concrete cover specified in the Plans, even if it exceeds the minimum concrete cover.

6-19.3(5)D Steel Reinforcing Bar Cage Support at Base of Shaft Excavation

For shafts with temporary casing within 15 feet of the bottom of shaft elevation as specified in the Plans, the Contractor may place quarry spalls or other rock backfill acceptable to the Engineer into the shaft below the specified bottom of shaft elevation as a means to support the steel reinforcing bar cage, provided that the materials and means to accomplish this have been addressed by the shaft installation narrative, as specified in Section 6-19.3(2)B, item 9. The use of bar boots and/or rebar cage base plates is required when quarry spalls or other rock backfill is placed at the base of the shaft excavation.

6-19.3(6) Contractor Furnished Accessories for Nondestructive QA Testing

6-19.3(6)A Shafts Requiring Access Tubes

The Contractor shall furnish and install access tubes in all shafts receiving CSL testing or the thermal probe method of TIP testing, except as otherwise noted in Section 6-19.3(1)B1.

6-19.3(6)B Orientation and Assembly of the Access Tubes

The Contractor shall securely attach the access tubes to the interior of the reinforcement cage of the shaft. One access tube shall be furnished and installed for each foot of shaft diameter, rounded to the nearest whole number, as shown in the Plans. The number of access tubes for shaft diameters specified as “X feet 6 inches” shall be rounded up to the next higher whole number. The access tubes shall be placed around the shaft, inside the spiral or hoop reinforcement, and bundled with the vertical reinforcement. Where circumferential components of the rebar cage bracing system prevent bundling the access tubes directly to the vertical reinforcement, the access tubes shall be placed inside the circumferential components of the rebar cage bracing system as close as possible to the nearest vertical steel reinforcement bar.

The access tubes shall be installed in straight alignment and as near to parallel to the vertical axis of the reinforcement cage as possible. The access tubes shall extend from the bottom of the reinforcement cage to at least 2 feet above the top of the shaft. Splice joints in the access tubes, if required to achieve full length access tubes, shall be watertight. The Contractor shall clear the access tubes of all debris and extraneous materials before installing the access tubes. The tops of access tubes shall be deburred. Care shall be taken to prevent damaging the access tubes during reinforcement cage installation and concrete placement operations in the shaft excavation.

6-19.3(6)C Care for Access Tubes From Erection Through Nondestructive QA Testing

The access tubes shall be filled with potable water before concrete placement, and the top watertight PVC caps shall be reinstalled and secured in accordance with Section 9-36.4. The Contractor shall keep all of a shaft's access tubes full of water through the completion of nondestructive QA testing of that shaft. When temperatures below freezing are possible, the Contractor shall protect the access tubes against freezing by wrapping the exposed tubes with insulating material, adding antifreeze to the water in the tubes, or other methods acceptable to the Engineer.

6-19.3(6)D Shafts Requiring Thermal Wire

The Contractor shall furnish and install thermal wire in all shafts receiving the thermal wire method of TIP testing, except as otherwise noted in Section 6-19.3(1)B1.

6-19.3(6)E Thermal Wire and Thermal Access Points (TAPs)

The thermal wire and associated couplers shall be obtained from the source specified in the Special Provisions.

The Contractor shall securely attach the thermal wire to the interior of the reinforcement cage of the shaft in conformance with the supplier's instructions. At a minimum, one thermal wire shall be furnished and installed for each foot of shaft diameter, rounded to the nearest whole number, as shown in the Plans. The number of thermal wires for shaft diameters specified as "X feet 6 inches" shall be rounded up to the next higher whole number. The thermal wires shall be placed around the shaft, inside the spiral or hoop reinforcement, and tied to the vertical reinforcement with plastic "zip" ties at a maximum spacing of 2-feet. Steel tie wire shall not be used.

The thermal wire shall be installed in straight alignment and taut, but with enough slack to not be damaged during reinforcing cage lofting. The wires shall be as near to parallel to the vertical axis of the reinforcement cage as possible. The thermal wire shall extend from the bottom of the reinforcement cage to the top of the shaft, with a minimum of 5-feet of slack wire provided above the top of shaft. All thermal wires in a shaft shall be equal lengths. Care shall be taken to prevent damaging the thermal wires during reinforcement cage installation and concrete placement operations in the shaft excavation.

After completing shaft reinforcement cage fabrication at the site and prior to installation of the cage into the shaft excavation, the Contractor shall install and connect thermal access points (TAPs) to the thermal wires. The TAPs shall record data for at least one hour after the cage is placed in the excavation to measure the slurry temperature and enable the steel and slurry temperatures to equilibrate prior to placing concrete in the shaft. The TAPs shall record and store data every 15 minutes. The TAPs shall remain active for a minimum of 36 hours.

Prior to beginning concrete placement the TAPs shall be checked to ensure they are recording data and that the wires have not been damaged. If a TAP unit is not functioning due to a damaged wire, the Contractor shall repair or replace the wire. If a TAP unit fails or a wire breaks after concrete placement has started, the Contractor shall not stop the concrete placement operation to repair the wire.

6-19.3(6)F Use of Access Tubes for TIP Testing Under the Thermal Probe Method

The Contractor may use access tubes for TIP testing under the thermal probe method. Access tubes shall be cared for in accordance with Section 6-19.3(6)C. Prior to TIP testing under the thermal probe method, the water in each tube shall be removed, collected, and stored in an insulated container. The access tube shall be blown dry and swabbed to remove residual water. After TIP testing, the collected and stored tube water shall be introduced back into the access tube. New potable water may be used, provided the water temperature is not more than 10°F cooler than the average concrete temperature measured by the probe.

6-19.3(7) Placing Concrete

6-19.3(7)A Concrete Class for Shaft Concrete

Shaft concrete shall be Class 5000P conforming to Section 6-02.

6-19.3(7)B Concrete Placement Requirements

Concrete placement shall commence immediately after completion of excavation by the Contractor and inspection by the Engineer. Immediately prior to commencing concrete placement, the shaft excavation and the properties of the slurry (if used) shall conform to Sections 6-19.3(3)D and 6-19.3(4), respectively. Concrete placement shall continue in one operation to the top of the shaft, or as shown in the Plans. The Contractor shall place concrete between the upper construction joint of the shaft and the top of the shaft in the dry.

During concrete placement, the Contractor shall monitor, and minimize, the difference in the level of concrete inside and outside of the steel reinforcing bar cage. The Contractor shall conduct concrete placement operations to maintain the differential concrete head as 1-foot maximum.

If water is not present, the concrete shall be deposited through the center of the reinforcement cage by a method that prevents segregation of aggregates and splashing of concrete on the reinforcement cage. The concrete shall be placed such that the free-fall is vertical down the center of the shaft without hitting the sides, the steel reinforcing bars, or the steel reinforcing bar cage bracing. The Section 6-02.3(6) restriction for 5 feet maximum free fall shall not apply to placement of concrete into a shaft.

6-19.3(7)C Concrete Vibration Requirements

When placing concrete in the dry, only the top 5 feet of concrete shall be vibrated, in accordance with Section 6-02.3(9), except that the entire depth of concrete placed in the shaft-column steel reinforcing bar splice zone shall be vibrated. If a temporary casing is used, it shall be removed before vibration. This requirement may be waived if a temporary casing is used and removed with a vibratory hammer during the concrete placement operation. Vibration of concrete does not affect the maximum slump allowed for the concrete class specified.

6-19.3(7)D Requirements for Placing Concrete Underwater

When placing concrete underwater, including when water in a shaft excavation exceeds 3 inches in depth, the Contractor shall place the concrete by pressure feed using a concrete pump, with a watertight tube having a minimum diameter of 4 inches. The discharge end of the tube on the concrete pump shall include a device to seal out water while the tube is first filled with concrete. Alternatively, the Contractor may use a plug that is inserted at the hopper of the concrete pump and travels through the tremie to keep the concrete separated from the water and slurry. Concrete placement by gravity feed is not allowed.

Throughout the underwater concrete placement operation, the discharge end of the tube shall remain submerged in the concrete at least 5 feet and the tube shall always contain enough concrete to prevent water from entering. The concrete placement shall be continuous until the work is completed, resulting in a seamless, uniform shaft.

6-19.3(7)E Testing and Repair of Shaft Concrete Placed Underwater

If the underwater concrete placement operation is interrupted, the Engineer may require the Contractor to prove by core drilling or other tests that the shaft contains no voids or horizontal joints. If testing reveals voids or joints, the Contractor shall repair them or replace the shaft at no expense to the Contracting Agency. Responsibility for coring costs, and calculation of time extension, shall be in accordance with Section 6-19.3(9)H.

6-19.3(7)F Cleaning and Removal of Previously Placed Shaft Concrete

Before placing any fresh concrete against concrete deposited in water or slurry, the Contractor shall remove all scum, laitance, loose gravel, and sediment on the upper surface of the concrete deposited in water or slurry and chip off any high spots on the upper surface of the existing concrete that would prevent the steel reinforcing bar cage from being placed in the position required by the Plans.

Prior to performing any of the crosshole sonic log testing operations specified in Section 6-19.3(9), the Contractor shall remove the concrete at the top of the shaft down to sound concrete.

6-19.3(7)G Protection of Fresh and Curing Concrete From Vibration

The Contractor's construction operation in the vicinity of a shaft excavation with freshly placed concrete and curing concrete shall conform to Section 6-02.3(6)D.

6-19.3(7)H Uniform Yield Form

Except for shafts where the shaft concrete is placed in the dry, the Contractor shall complete a uniform yield form, consistent with the sample form submitted to the Engineer as part of the shaft installation narrative as specified in Section 6-19.3(2)B, item 6, for each shaft and shall submit the completed form to the Engineer within 24 hours of completing the concrete placement in the shaft.

6-19.3(7)I Requirements for Placing Concrete Above the Top of Shaft

Concrete shall not be placed above the top of shaft (for column splice zones, columns, footings, or shaft caps) until the Contractor receives the Engineer's acceptance of nondestructive QA testing, if performed at that shaft, and acceptance of the shaft.

6-19.3(8) Casing Removal

6-19.3(8)A Concrete Head Requirements During Temporary Casing Removal

As the temporary casing is withdrawn, the Contractor shall maintain the concrete and slurry inside the casing at a level sufficient to balance the hydrostatic pressure outside the casing.

6-19.3(8)B Removing Portions of Permanent Casing Above the Top of Shaft

Tops of permanent casings for the shafts shall be removed to the top of the shaft or finished groundline, whichever is lower, unless directed otherwise by the Engineer. For those shafts constructed within a permanent body of water, tops of permanent casings for shafts shall be removed to the low water elevation, unless directed otherwise by the Engineer.

6-19.3(8)C Requirements for Leaving Temporary Casing in Place

The Contractor shall completely remove all temporary casings, except as noted. The Contractor may leave some or all of the temporary casing in place provided all the following conditions are satisfied:

1. The Contractor shall submit a Type 2E Working Drawing of the following information:
    a. The Contractor shall completely describe the portion of the temporary casing to remain.
    b. The Contractor shall specify the reason(s) for leaving the portion of the temporary casing in place.
    c. The Contractor shall submit structural calculations, using the design specifications and design criteria specified in the General Notes of the structure Plans, indicating that leaving the temporary casing in place is compatible with the structure as designed in the Plans.

6-19.3(9) Nondestructive QA Testing of Shafts

The Contractor shall provide nondestructive QA testing and analysis on all shafts with access tubes or thermal wires and TAPs facilitating the testing (See Section 6-19.3(1)B). The testing and analysis shall be performed by the testing organizations identified by the Contractor's submittal in accordance with Section 6-19.3(2)D.

The Engineer may direct that additional testing be performed at a shaft if anomalies or a soft bottom are detected by the Contractor's testing. If additional testing at a shaft confirms the presence of a defect(s) in the shaft, the testing costs and the delay costs resulting from the additional testing shall be borne by the Contractor in accordance with Section 1-05.6. If the additional testing indicates that the shaft has no defect, the testing costs and the delay costs resulting from the additional testing will be paid by the Contracting Agency in accordance with Section 1-05.6, and, if the shaft construction is on the critical path of the Contractor's schedule, a time extension equal to the delay created by the additional testing will be granted in accordance with Section 1-08.8.

6-19.3(9)A TIP Testing Using Thermal Probes or CSL Testing

If selected as the nondestructive QA testing method by the Contractor, TIP testing using thermal probes, or CSL testing shall be performed after the shaft concrete has cured at least 96 hours. Additional curing time prior to testing may be required if the shaft concrete contains admixtures, such as set retarding admixture or water-reducing admixture, added in accordance with Section 6-02.3(3). The additional curing time prior to testing required under these circumstances shall not be grounds for additional compensation or extension of time to the Contractor in accordance with Section 1-08.8.

6-19.3(9)B Inspection of Access Tubes

After placing the shaft concrete and before beginning the crosshole sonic log testing of a shaft, the Contractor shall inspect the access tubes. Each access tube that the test probe cannot pass through shall be replaced, at the Contractor's expense, with a 2-inch diameter hole cored through the concrete for the entire length of the shaft. Unless directed otherwise by the Engineer, cored holes shall be located approximately 6 inches inside the reinforcement and shall not damage the shaft reinforcement. The Contractor shall submit a Type 2 Working Drawing describing the conduct of the core hole drilling operation including measures to ensure core hole verticality and avoidance of reinforcement. Descriptions of inclusions and voids in cored holes shall be logged and a copy of the log shall be submitted to the Engineer. Findings from cored holes shall be preserved, identified as to location, and made available for inspection by the Engineer.

6-19.3(9)C TIP Testing With Thermal Wires and TAPs

If selected as the nondestructive QA testing method by the Contractor, TIP testing with thermal wires and TAPs (See Section 6-19.3(6)E) shall be performed. The TIP testing shall commence at the beginning of the concrete placement operation, recording temperature readings at 15-minute intervals until the peak temperature is captured in the data. Additional curing time may be required if the shaft concrete contains admixtures, such as set retarding admixture or water-reducing admixture, added in accordance with Section 6-02.3(3). The additional curing time required under these circumstances shall not be grounds for additional compensation or extension of time to the Contractor in accordance with Section 1-08.8.

TIP testing shall be conducted at all shafts in which thermal wires and TAPs have been installed for thermal wire analysis (Section 6-19.3(6)A).

6-19.3(9)D Nondestructive QA Testing Results Submittal

The Contractor shall submit the results and analysis of the nondestructive QA testing for each shaft tested. The Contractor shall submit the test results within three working days of testing. Results shall be a Type 2E Working Drawing presented in a written report.

TIP reports shall include:

1. A map or plot of the wire/tube location within the shaft and their position relative to a known and identifiable location, such as North.
2. Graphical displays of temperature measurements versus depth of each wire or tube for the analysis time selected, overall average temperature with depth, shaft radius or diameter with depth, concrete cover versus cage position with depth, and effective radius.
3. The report shall identify unusual temperatures, particularly significantly cooler local deviations from the overall average.
4. The report shall identify the location and extent where satisfactory or questionable concrete is identified.
    a. Satisfactory (S) – 0 to 6 percent Effective Radius Reduction and Cover Criteria Met
    b. Questionable (Q) – Effective Local Radius Reduction > 6 percent, Effective Local Average Diameter Reduction > 4 percent, or Cover Criteria Not Met
5. Variations in temperature between wire/tubes (at each depth) which in turn correspond to variations in cage alignment.
6. Where shaft specific construction information is available (e.g. elevations of the top of shaft, bottom of casing, bottom of shaft, etc.), these values shall be noted on all pertinent graphical displays.

CSL reports shall include:

1. A map or plot of the tube location within the shaft and their position relative to a known and identifiable location, such as North.
2. Graphical displays of CSL Energy versus Depth and CSL signal arrival time versus depth or velocity versus depth.
3. The report shall identify the location and extent where good, questionable, and poor concrete is identified, where no signal was received, or where water is present.
   a. Good (G) – No signal distortion and decrease in signal velocity of 10 percent or less is indicative of good quality concrete.
   b. Questionable (Q) – Minor signal distortion and a lower signal amplitude with a decrease in signal velocity between 10 percent and 20 percent.
   c. Poor (P) – Severe signal distortion and much lower signal amplitude with a decrease in signal velocity of 20 percent or more.
   d. No Signal (NS) – No signal was received.
   e. Water (W) – A measured signal velocity of nominally V = 4,800 to 5,000 fps.

All QA test reports will provide a recommendation to accept the shaft as-is, recommendation for further review by the Engineer, or will provide a plan for further testing, investigation or repair to address any deficiencies identified by the testing.

6-19.3(9)E Vacant

6-19.3(9)F Contractor's Investigation and Remedial Action Plan

For all shafts determined to be unacceptable, the Contractor shall submit a Type 2 Working Drawing consisting of a plan for further investigation or remedial action. All modifications to the dimensions of the shafts, as shown in the Plans, required by the investigation and remedial action plan shall be supported by calculations and working drawings. All investigation and remedial correction procedures and designs shall be submitted.

6-19.3(9)G Rejection of Shafts and Revisions to Concrete Placement Operations

If the Engineer determines that the concrete placed under slurry for a given shaft is structurally inadequate, that shaft will be rejected. The placement of concrete under slurry shall be suspended until the Contractor submits to the Engineer written changes to the methods of shaft construction needed to prevent future structurally inadequate shafts, and receives the Engineer's written approval of the submittal.

6-19.3(9)H Cored Holes

At the Engineer's request, the Contractor shall drill a corehole in any questionable quality shaft (as determined from crosshole sonic log testing and analysis or by observation of the Engineer) to explore the shaft condition.

Prior to beginning coring, the Contractor shall submit Type 2 Working Drawings consisting of the method and equipment used to drill and remove cores from shaft concrete. The coring method and equipment shall provide for complete core recovery and shall minimize abrasion and erosion of the core.

If a defect is confirmed, the Contractor shall pay for all coring costs in accordance with Section 1-05.6. If no defect is encountered, the Contracting Agency will pay for all coring costs in accordance with Section 1-05.6, and, if the shaft construction is on the critical path of the Contractor's schedule, compensation for the delay will be granted by an appropriate time extension in accordance with Section 1-08.8. Materials and Work necessary, including engineering analysis and redesign, to effect corrections for shaft defects shall be furnished to the Engineer's satisfaction at no additional cost to the Contracting Agency.

6-19.3(9)I Requirements for Access Tubes and Cored Holes After CSL Testing

All access tubes and cored holes shall be dewatered and filled with grout conforming to Section 9-36.5 after tests are completed. The access tubes and cored holes shall be filled using grout tubes that extend to the bottom of the tube or hole or into the grout already placed.

6-19.3(10) Engineer's Final Acceptance of Shafts

The Engineer will determine final acceptance of each shaft, based on the nondestructive QA test results and analysis for the tested shafts, and will provide a response to the Contractor within 3 working days after receiving the test results and analysis submittal.

6-19.4 Measurement

Constructing shafts will be measured by the linear foot. The linear foot measurement will be calculated using the top of shaft elevation and the bottom of shaft elevation for each shaft as shown in the Plans.

Rock excavation for shaft, including haul, will be measured by the linear foot of shaft excavated. The linear feet measurement will be computed using the top of the rock line, defined as the highest bedrock point within the shaft diameter, and the bottom elevation shown in the Plans.

QA shaft test will be measured once per shaft tested.

6-19.5 Payment

Payment will be made for the following Bid items when they are included in the Proposal:

"Constructing___Diam. Shaft", per linear foot.

The unit Contract price per linear foot for "Constructing___Diam. Shaft" shall be full pay for performing the Work as specified, including:

1. Soil excavation for shaft, including all costs in connection with furnishing, mixing, placing, maintaining, containing, collecting, and disposing of all mineral, synthetic and water slurry, and disposing of groundwater collected by the excavated shaft.
2. Furnishing and placing temporary shaft casing, including temporary casing in addition to the required casing specified in the Special Provisions, and including all costs in connection with completely removing the casing after completing shaft construction.
3. Furnishing permanent casing for shaft.
4. Placing permanent casing for shaft.
5. Casing shoring, including all costs in connection with furnishing and installing casing shoring above the specified upper limit for casing shoring but necessary to provide for sufficient water head pressure to resist artesian water pressure present in the shaft excavation, removing casing shoring, and placing seals when required.
6. Furnishing and placing steel reinforcing bar and epoxy-coated steel reinforcing bar, including furnishing and installing steel reinforcing bar centralizers.
7. Installation of CSL tubes or thermal wires.
8. Furnishing, placing and curing concrete to the top of shaft or to the construction joint at the base of the shaft-column splice zone as applicable.

Payment for "Constructing___Diam. Shaft" will be made upon Engineer acceptance of the shaft, including completion of satisfactory QA shaft tests as applicable.

"Rock Excavation For Shaft Including Haul", per linear foot.

When rock excavation is encountered, payment for rock excavation is in addition to the unit Contract price per linear foot for "Constructing___Diam. Shaft"

"Shoring Or Extra Excavation Cl. A - ___", lump sum.

The lump sum Contract price for "Shoring Or Extra Excavation Cl. A - ___" shall be full pay for performing the Work as specified, including all costs in connection with all excavation outside the limits specified for soil and rock excavation for shaft including haul, all temporary telescoping casings, and all temporary casings beyond the limits of required temporary casing specified in the Special Provisions.

"QA Shaft Test", per each.

The unit Contract price per each for "QA Shaft Test" shall be full pay for performing the Work as specified, including operating all associated accessories necessary to record and process data and develop the summary QA test reports. Section 1-04.6 does not apply to this bid item.

"Removing Shaft Obstructions", estimated.

Payment for removing, breaking-up, or pushing aside shaft obstructions, as defined in Section 6-19.3(3)E, will be made for the changes in shaft construction methods necessary to deal with the obstruction. The Contractor and the Engineer shall evaluate the effort made and reach agreement on the equipment and employees utilized, and the number of hours involved for each. Once these cost items and their duration have been agreed upon, the payment amount will be determined using the rate and markup methods specified in Section 1-09.6. For the purpose of providing a common proposal for all Bidders, the Contracting Agency has entered an amount for the item "Removing Shaft Obstructions" in the Bid Proposal to become a part of the total Bid by the Contractor.

If drilled shaft tools, cutting teeth, casing or Kelly bar is damaged as a result of the obstruction removal work, the Contractor will be compensated for the costs to repair this equipment in accordance with Section 1-09.6.

If shaft construction equipment is idled as a result of the Work required to deal with the obstruction and cannot be reasonably reassigned within the project, then standby payment for the idled equipment will be added to the payment calculations. If labor is idled as a result of the Work required to deal with the obstruction and cannot be reasonably reassigned within the project, then all labor costs resulting from Contractor labor agreements and established Contractor policies will be added to the payment calculations.

The Contractor shall perform the amount of obstruction Work estimated by the Contracting Agency within the original time of the Contract. The Engineer will consider a time adjustment and additional compensation for costs related to the extended duration of the shaft construction operations, provided:

1. The dollar amount estimated by the Contracting Agency has been exceeded, and
2. The Contractor shows that the obstruction removal Work represents a delay to the completion of the project based on the current progress schedule provided in accordance with Section 1-08.3.

6-20 Buried Structures

6-20.1 Description

This Work consists of designing and constructing buried structures of the various types including associated approach slabs, footings, headwalls, wingwalls, and connected barriers, rails and fall protection in accordance with the Contract documents. Potential uses for these buried structures include but are not limited to water crossings, vehicular crossings, pedestrian crossings, animal crossings, utility crossings, etc.

6-20.1(1) Definitions

Buried Structure: A Structure consisting of one of the types defined below:

Concrete Three Sided Structure: A precast or cast-in-place reinforced concrete structure with vertical walls and an integral top slab placed on reinforced concrete foundations. It may be arched or corded and may contain chamfers or fillets.

Concrete Box Culvert: A precast or cast-in-place reinforced concrete structure with vertical walls, an integral top slab and an integral bottom slab. The top and bottom slabs are usually flat and at 90-degrees to the walls forming a rectangular structure. The corners may contain chamfers or fillets.

Concrete Split Box Culvert: A concrete box culvert split into upper and lower units by horizontal joints in the vertical walls. The upper unit may be prestressed.

Structural Plate Pipe: A steel or aluminum structural plate around the entire circumference of a pipe shape. Structural plate pipes may contain external reinforcing members and multiple radiuses and plate thicknesses. Structural plate pipe shapes include but are not limited to round, ellipse, underpass, pipe-arch and pear.

Structural Plate Arch: A steel or aluminum structural plate arch shape placed on reinforced concrete foundations. Structural plate arches may contain external reinforcing members and multiple radiuses and plate thicknesses.

Structural Plate Box: A steel or aluminum structural plate box shape that meets the requirements of the AASHTO LRFD Bridge Design Specifications Section 12.9 (or Section 12.8.9 for deep corrugated structural plate structures with ratio of crown radius to haunch radius > 5).

Headwall: Structure elements that are end treatments connected to buried structures, including, at a minimum, parapets, slope collars, cutoff walls and inverts.

Structure Free Zone (SFZ): An imaginary prism defined in the Contract documents which represents the minimum boundary within which no part of the buried structure including foundations, headwalls and wingwalls shall be allowed. For a Contracting Agency Supplied Design the SFZ shall be defined by the interior horizontal and vertical dimensions and the length of the structure shown in the Contract documents, unless noted otherwise.

Wingwall: A retaining wall structure element adjacent to or above a buried structure end or headwall.

6-20.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
AASHTO Grading No. 57	9-03.1(4)C
Aggregates for Ballast and Crushed Surfacing	9-03.9
Streambed Aggregates	9-03.11
Gravel Backfill	9-03.12
Borrow	9-03.14
Joint Sealing Materials	9-04
Structural Plate Pipes, Arches and Boxes	9-05.6
Deformed Steel Bars	9-07.2
Epoxy-Coated Steel Reinforcing Bars	9-07.3
Galvanizing Repair Paint, High Zinc Dust Content	9-08.1(2)B
Primer, Zinc-Rich, Single-Component, Moisture-Cured Polyurethane	9-08.1(2)F
Grout Type 2 for Nonshrink Applications	9-20.3(2)
Mortar	9-20.4
Concrete Curing Materials and Admixtures	9-23
Water	9-25

Concrete class shall be as specified but in no case shall be less than class 4000.

6-20.3 Construction Requirements

6-20.3(1) Design

6-20.3(1)A Design Delivery Method

Buried structures shall be considered a Contractor Supplied Design when the Contract documents do not include a complete set of design details for a Structure (consisting of, at a minimum, defining material requirements, shapes, dimensions, reinforcing details, joint and connection details, etc.).

Buried structures shall be considered a Contracting Agency Supplied Design when the Contract documents include a complete set of design details for a Structure.

6-20.3(1)A1 Contractor Supplied Design

The Contractor shall prepare the design in accordance with Sections 6-20.3(1)C through 6-20.3(1)I. All submittal requirements of Section 6-20.3(2) shall apply.

The buried structure, headwalls and wingwalls shall be located as specified in the Contract documents, including but not limited to the alignment, length, profile and elevation. The buried structure shall accommodate the geometry required in the Contract documents. No part of the buried structure, including but not limited to foundations, headwalls and wingwalls, shall be allowed within the structure free zone. The buried

structure and wall types shall be as specified in the Contract documents. Other buried structure types not defined in Section 6-20.1(1) may be accepted by the Engineer.

6-20.3(1)A2 Contracting Agency Supplied Design

The buried structure design shall be as presented in the Contract documents. The requirements of Sections 6-20.3(1)C through 6-20.3(1)I, 6-20.3(2)A and 6-20.3(2)B shall not apply for the Structure. All other submittal requirements of Section 6-20.3(2) shall apply.

When allowed by the Engineer, the Contractor may propose an alternate structure to replace a Contracting Agency Supplied Design. No part of the alternate structure, including but not limited to foundations, headwalls and wingwalls, shall be allowed within the structure free zone. When the alternate structure is located as specified in the Contract documents, is of the same type as specified in the Contract documents, is the same length as specified in the Contract documents and does not affect other portions of the design except adjustments to interface location with headwalls and wingwalls, it is not required to follow the requirements of Section 1-04.4(2). Otherwise, the alternate structure proposal shall meet the requirements of Section 1-04.4(2).

The Contractor shall prepare the alternate structure design in accordance with Section 6-20.3(1)A1. The Contractor shall be responsible for the entire design of an alternate structure and associated structure elements including, at a minimum, approach slabs, headwalls, wingwalls and connected barriers, rails and fall protection.

6-20.3(1)B Buried Structure Class

The Structural Clear Span of a buried structure shall be used to determine the buried structure class. When supporting a Roadway, the Structural Clear Span shall be the widest horizontal opening from interior face to interior face of the end walls measured parallel to the roadway centerline. When not supporting a Roadway, the Structural Clear Span shall be the widest horizontal opening from interior face to interior face of the end walls measured perpendicular to the buried structure centerline.

Structure Class	Structural Clear Span
Class 1	Less than 20.0 feet
Class 2	20.0 feet and greater

6-20.3(1)C General Design Criteria

Buried structures and associated headwalls, wingwalls and connected barriers, rails and fall protection shall be designed in accordance with the WSDOT *Geotechnical Design Manual* M 46-03, WSDOT Bridge Design Manual LRFD M 23-50, AASHTO LRFD Bridge Design Specifications and the AASHTO LRFD Bridge Construction Specifications. The AASHTO operational classification load modifier for the buried structure shall be that for typical bridges unless noted otherwise.

Buried structures shall be designed for a minimum service life of 75-years. Corrosion and abrasion shall be considered as specified in the WSDOT *Bridge Design Manual LRFD* M 23-50.

Class 2 buried structures, as specified in Section 6-20.3(1)B, and associated headwalls and wingwalls, as defined in Section 6-20.1(1), shall include seismic design and ground failure mitigation in accordance with the WSDOT *Bridge Design Manual LRFD* M 23-50 and WSDOT *Geotechnical Design Manual* M 46-03. This includes, at a minimum, design for seismic loads in accordance with the AASHTO Technical Manual for Design and Construction of Road Tunnels – Civil Elements, Chapter 13, for the seismic effects of transient racking deformations. The AASHTO LRFD Bridge Design Specifications exemption from seismic loading shall not apply.

6-20.3(1)D Geotechnical Considerations

The Contractor shall use the Geotechnical Report prepared for the buried structure and available through the source(s) specified in the Special Provisions under Section 1-02.4(2).

The Contractor shall complete any additional geotechnical investigation and design necessary for this Work as directed by the Engineer. This includes but is not limited to performing any additional permitting, surveying, field investigation, subsurface borings, analysis and modeling. The type, compacted density, and strength properties of the fill adjacent to the buried structure shall be established.

6-20.3(1)E Hydraulic Considerations

The Contractor shall complete any additional hydraulic investigation and design necessary for this Work as directed by the Engineer. This includes but is not limited to performing any additional permitting, surveying, field investigation, subsurface borings, analysis and modeling.

All buried structures and associated headwalls and wingwalls shall be designed for scour from the design flood (100 year flood event) and the check flood (500 year flood event) in accordance with the WSDOT Bridge Design Manual LRFD M 23-50 and the AASHTO LRFD Bridge Design Specifications unless additional design criteria is documented in the Final Hydraulic Design report. Channel migration shall be considered.

The bottoms of foundations of buried structures and associated headwalls and wingwalls shall be a minimum of 2 feet below the maximum anticipated depth of scour based on the check flood (500 year flood event). Alternative methods of protection against scour may be used with the concurrence of the Engineer.

6-20.3(1)F Fall Protection

Fall protection shall be provided at the top of all buried structures and associated headwalls and wingwalls in accordance with the WSDOT Design Manual. Worker fall protection shall be of the standard guardrail type, as described in the Washington Administrative Code (WAC) 296-155. Timber shall not be used as a material type for standard guardrail. For fall protection components that are adjacent to public pedestrian features such as sidewalks, the design shall be in accordance with Chapter 13 of the AASHTO LRFD Bridge Design Specifications for pedestrian railing. Rigid fall protection systems shall not be used within the roadway clear zone as described in the WSDOT *Design Manual*.

6-20.3(1)G Traffic Barrier and Guardrail

Traffic barrier shall be designed for a minimum Test Level Four (TL-4) impact load, unless otherwise specified.

When traffic barrier or guardrail is connected to the buried structure, the supporting structure shall be designed for the loads transferred from the barrier or guardrail to the Structure.

6-20.3(1)H Concrete Structures

When the buried structure is located in a marine or non-marine: corrosive environment as defined in the WSDOT Bridge Design Manual LRFD M 23-50, corrosion-resistant reinforcement defined in the WSDOT Bridge Design Manual LRFD M 23-50 shall be used. The minimum cover requirements for direct exposure to salt water and coastal situations of the AASHTO LRFD Bridge Design Specifications shall apply.

When the total backfill and surfacing depth above the top of the buried structure is less than 2 feet at any point above the Structure, all reinforcement in the top slab shall be corrosion-resistant as defined in the WSDOT Bridge Design Manual LRFD M 23-50. Reinforcement in the top slab need not be corrosion-resistant when a concrete deck meeting the requirements for a Type 4 Bridge Deck Protection System as defined in the WSDOT *Bridge Design Manual LRFD* M 23-50 is provided.

When the top of the buried structure is directly exposed to vehicular traffic, a concrete or HMA overlay or reinforced concrete deck shall be provided. For an HMA overlay, the minimum concrete cover from the top surface of the buried structure to the top mat of reinforcement shall be 2½ inches. For a concrete overlay or reinforced concrete deck, the minimum concrete cover from the top surface of the buried structure to the top mat of reinforcement shall be 2 inches. When the top of the buried structure is directly exposed to vehicular traffic, bridge approach slabs shall be provided.

All reinforcement in a precast unit shall be of the same type.

Joints between precast units shall be designed to transfer all design loads, keep adjacent units aligned, provide stability at all construction stages and in service, accommodate the installation sequence and shall be sealed to prevent water and soil movement through the joint.

Where the top of the top slab is less than two feet from the Roadway surface, a method of shear transfer shall be provided between the top slabs of adjacent precast units to equalize deflections by incorporating one of the following:

1. A structural connection between adjacent precast units capable of transferring the imposed shear and equalizing deflections. The structural connection shall include cast-in-place reinforced concrete closures or grouted shear keys.
2. A 5 inch minimum thickness composite cast-in-place reinforced concrete slab, meeting the requirements of a Type 4 Protection System in the WSDOT *Bridge Design Manual LRFD* M 23-50.

6-20.3(1)I Structural Plate Structures

Steel structural plate shall not be used in locations conforming to marine or non-marine: corrosive environments as defined in the *Bridge Design Manual LRFD* M 23-50 Section 6.7.

Galvanizing and zinc coatings shall not be used below the 100 year mean recurrence interval water surface.

Minimum backfill cover over the top of the structure and the minimum backfill width on each side of the structure shall be in accordance with the AASHTO LRFD Bridge Design Specifications.

6-20.3(2) Submittals

6-20.3(2)A Plans, Specifications and Calculations

For a Contractor Supplied Design the Contractor shall submit Type 3E Working Drawings consisting of site specific plans, specifications and supporting calculations for the buried structure and associated headwalls, wingwalls and other components. The recommendations and requirements contained in the Geotechnical Report and Final Hydraulic Design report for the Structure shall be met. The site specific plans may also function as the required fabrication Shop Drawings, if sufficiently detailed.

At a minimum, the Working Drawings shall:

1. Include a plan view, an elevation view, a cross section and complete site specific details for each structure.
2. Include materials, equipment and installation methods.
3. Include all of the geometric information necessary to fabricate, construct, and place the structure including all alignments, horizontal and vertical curve data, offsets, dimensions, elevations, profiles, and grades. Final ground lines shall be shown.
4. Include cross sections showing the structure and the structural backfill envelope. In fill sections, the cross sections shall show the limits and extent of backfill material placed above original ground.
5. Include all details for foundations and leveling pads, including details for steps in the foundations or leveling pads.
6. Include all details for construction of the approach slabs, headwalls, wingwalls, roadway de-icing salt and chloride protection and other associated components.

At a minimum, the calculations shall:

1. State all applicable design criteria. Provide references to sources of design requirements.
2. Clearly describe geotechnical design parameters, groundwater conditions, hydraulic and scour design parameters, sequencing considerations, and governing assumptions.

3. Include load and surcharge conditions associated with geometry, adjacent structures, construction and roadways as shown in the Plans. Construction loads or surcharges shall be provided by the Contractor or verified by the Contractor.
4. Address all aspects of service, strength and extreme event limit states, including load and resistance factors and stability checks.
5. Include detailed explanations of any symbols, design input, material property values, design tables, and computer program input and output.
6. Demonstrate how the minimum service life of 75-years shall be achieved.

6-20.3(2)B Load Rating Report

For a Contractor Supplied Design for a Class 2 buried structure, the Contractor shall submit a load rating report except in the following cases:

1. For a simple span (single barrel) structure, when the buried structure Structural Clear Span is less than or equal to 24 feet and the minimum fill depth above the top of the buried structure is greater than 13 feet.
2. For a simple span (single barrel) structure, when the buried structure Structural Clear Span is greater than 24 feet and the minimum fill depth above the top of the buried structure exceeds the buried structure Structural Clear Span.
3. For a multiple span (multiple barrel) structure, when the depth of fill above the top of the buried structure exceeds the widest opening between interior faces of the end walls measured perpendicular to the buried structure centerline.

The load rating report shall be submitted as a Type 2E Working Drawing prepared in accordance with the AASHTO Manual for Bridge Evaluation and the WSDOT *Bridge Design Manual LRFD* M 23-50 Chapter 13. Soil parameters shall be in accordance with the design requirements, the WSDOT *Geotechnical Design Manual* M 46-03 and the Geotechnical Report prepared for the project.

6-20.3(2)C Fabrication Shop Drawings

The Contractor shall submit a Type 2 Working Drawing consisting of fabrication shop drawings for precast concrete components, structural plate components and other proprietary buried structure systems. All components of the buried structure system shall be submitted simultaneously as a comprehensive submittal.

In addition to the content requirements specified in Section 6-02.3(9)A, the Working Drawing submittal for precast concrete components shall also contain the installation and backfill procedure.

6-20.3(2)D Dewatering System

If water is expected to be present in the excavation, or is found to be present once excavation begins, the Contractor shall submit a Type 2 Working Drawing consisting of a dewatering plan.

6-20.3(2)E Manufacturer's Installation Instructions

For Class 1 structural plate structures and other Class 1 proprietary buried structure systems, the Contractor shall submit a Type 1 Working Drawing consisting of the manufacturer's installation instructions for the Structure prior to the preconstruction conference and construction. The instructions shall provide step-by-step directions for construction of the Structure.

6-20.3(2)F Installation Plan

For Class 2 buried structures, prior to the preconstruction conference, the Contractor shall submit a Type 2E Working Drawing consisting of an installation plan, including the manufacturer's installation instructions, Working Drawings and substantiating calculations. The installation plan shall cover all aspects of installation, including but not limited to bedding and foundation construction, unit identifier and placement location, assembly, bolting requirements, backfilling requirements and shape control during backfilling. The installation plan shall address any bracing requirements and how the structure is monitored during and after construction and backfilling to insure the finished product meets all design and construction requirements and all geometric tolerances. Minimum backfill cover over the structure to support construction equipment loadings shall be specified.

6-20.3(3) Tolerances

Tolerances for cast-in-place concrete components of buried structures shall be in accordance with Section 6-02.3(7). Reinforcement placement shall meet the tolerances specified in Section 6-02.3(24)C.

For the buried structure location:

1. Horizontal deviation from alignment or work line: ±2.0 inches
2. Vertical deviation from profile grade: ±1 inch

6-20.3(3)A Concrete Structures

Precast concrete buried structures shall conform to the fabrication tolerances of Section 6-02.3(9)F.

Fabrication tolerances for precast concrete three sided structures shall be as follows:

1. Internal Dimensions – The internal dimension shall not vary more than 1 percent or 2 inches, whichever is less, from the specified dimensions. The haunch dimensions shall not vary more than ¾ inch from the specified dimensions.
2. Slab and Wall Thickness – The slab and wall thickness shall not be less than that specified by more than 5 percent or ½ inch, whichever is greater. A thickness more than that specified will not be a cause for rejection if proper joining is not affected.
3. Length of Opposite Surfaces – Variations in lengths of two opposite surfaces of the three-sided section shall not be more than ¾ inch unless beveled sections are being used to accommodate a curve in the alignment.

Fabrication tolerances for precast concrete box culverts and precast concrete split box culverts shall be as follows:

1. Internal Dimensions – The internal dimensions shall not vary more than 1 percent from the specified dimensions. If haunches are used, the haunch dimensions shall not vary more than ¼ inch from the specified dimensions.
2. Slab and Wall Thickness – The slab and wall thickness shall not be less than that specified by more than 5 percent or 3⁄16 inch, whichever is greater. A thickness more than that specified will not be a cause for rejection.
3. Length of Opposite Box Segments – Variations in lengths of two opposite surfaces of the box segments shall not be more than ⅛ inch per foot of internal span, with a maximum of ⅝ inch for all sizes through 7 feet internal span, and a maximum of ¾ inch for internal spans greater than 7 feet, except where beveled sections are being used to accommodate a curve in the alignment.
4. Length of Box Segments – The underrun in length of a segment shall not be more than ⅛ inch per foot of length with a maximum of ½ inch in any box segment.
5. Length of Legs and Slabs – The variation in length of the legs shall not be more than ⅛ inch per foot of the rise of the leg per leg with a maximum of ⅝ inches. The differential length between opposing legs of the same segment shall not be more than ½ inch. Length of independent top slab spans shall not vary by more than ⅛ inch per foot of span of the top slab, with a maximum of ⅝ inches.

Placement and erection tolerances for precast components shall be as follows:

1. Maximum offset in alignment of matching edges: ±0.5 inches, not to exceed the width of the joint.
2. Joint width: ±0.5 inches

6-20.3(3)B Structural Plate Structures

Tolerances for structural plate pipes, arches and boxes shall be in accordance with the AASHTO LRFD Bridge Construction Specifications Section 26 and the manufacturer's recommendations, whichever is more restrictive.

All Class 2 structural plate buried structures shall meet the structure dimension tolerances for the assembly of long span structures defined in the AASHTO LRFD Bridge Design Specifications.

6-20.3(4) Preconstruction Conference

Class 1 buried structures shall have a preconstruction conference when required by the Engineer. All Class 2 buried structures shall have a preconstruction conference.

All submittals required in Section 6-20.3(2), except for the Section 6-20.3(2)B Load Rating Report, shall be submitted at least 5 working days before holding the preconstruction conference.

The preconstruction conference shall be held at least 5 working days prior to the Contractor beginning any buried structure construction at the site to discuss safety, maintenance of traffic, environmental compliance, construction procedures, critical functions during backfilling, quality control steps to control loads and shape and movement, personnel, equipment to be used, and other elements of construction. Those attending shall include:

Representing the Contractor: The superintendent, on site supervisors, and all foremen in charge of safety, traffic, environmental, excavation, structure construction, and backfilling.

Representing the Manufacturer: For Class 2 buried structures, a qualified and experienced manufacturer's representative conforming to Section 6-20.3(4)A.

6-20.3(4)A Manufacturer's Representative

A manufacturer's representative shall be provided for Class 2 buried structures. The manufacturer's representative shall be a qualified and experienced representative able to resolve construction problems. The manufacturer's representative shall be present at the preconstruction conference, on site during initial installation and available at other times as needed throughout construction. Recommendations made by the manufacturer's representative shall be followed by the Contractor unless the recommendations deviate from the Contract requirements. In the instance where a recommendation deviates from the Contract, the Contractor shall request acceptance from the Engineer for the Change.

6-20.3(5) Excavation

Excavation shall conform to Section 2-09.3(3). The Contractor shall excavate to the lines and grades identified in the Plans and Working Drawings. The excavation limits shall be increased to account for the placement of buried structure bedding materials and structural backfill.

Material at the bottom of the excavation that is unstable or unsuitable shall be removed in accordance with Section 2-09.3(1)C. If the excavation is dry enough that replacement material can be compacted without causing pumping or further degradation of the material exposed in the bottom of the excavation (after unstable removal), the unstable material shall be replaced in accordance with Section 2-09.3(1)C.

If the bottom of the excavation is too wet for compaction to occur, the Contractor shall place Construction Geosynthetic for Soil Stabilization Class C on the exposed bottom of the excavation. Geosynthetic shall be overlapped as required by the manufacturer, but not less than 1 foot at seams. The Contractor shall stretch out the geosynthetic to ensure that no slack or wrinkles exist in the geosynthetic prior to backfilling. Backfill consisting of Crushed Surfacing Base Course (CSBC) or AASHTO Grading No. 57 shall be placed on top of the Geosynthetic to reestablish lines and grade. Compaction of the CSBC or AASHTO Grading No. 57 shall be by static methods or by track walking and shall impart only enough energy to seat the granular materials together and provide a stable, non-shifting, working surface. Controlled density fill (CDF) or lean concrete may be used with no geosynthetic and no compaction.

Upon completing the excavation, the Contractor shall notify the Engineer. No other permanent part of the buried structure or associated headwalls or wingwalls shall be placed until the Engineer has given permission to proceed.

If water is present within the excavation, the Contractor shall dewater the excavated area in accordance with the Section 6-20.3(2)D Working Drawing submittal before placing the bedding material.

Existing structures and obstructions shall be removed in accordance with Section 2-02.3.

6-20.3(5)A Construction Dewatering

The Contractor shall design, install, operate, maintain, and remove a construction dewatering system. The construction dewatering system shall be used to remove precipitation from the work area, surface water that enters the work area, and seepage when excavations extend below groundwater. The system shall be capable of handling surface water, precipitation, and groundwater flow associated with seasonal groundwater variations and storm events. The system shall provide for a reasonably dry excavation free of standing water that impedes construction or degrades the working surface of the excavation. Discharge from the dewatering system shall be handled in accordance with Section 8-01.3(1)C1.

6-20.3(6) Bedding and Foundations

6-20.3(6)A Bedding

Buried structure bedding material shall be placed in accordance with the Contract documents and the submittals of Sections 6-20.3(2)A, 6-20.3(2)C, 6-20.3(2)E, and 6-20.3(2)F.

Cast-in-place reinforced concrete foundation elements require a 6-inch minimum thickness layer of buried structure bedding material, defined as either Crushed Surfacing Base Course (CSBC) or AASHTO Grading No. 57. Precast reinforced concrete foundation elements require a 6-inch minimum thickness layer of buried structure bedding material, defined as either Crushed Surfacing Base Course (CSBC) or Crushed Surfacing Top Course (CSTC). The plan limits of the buried structure bedding material shall extend 1-foot beyond the plan limits of the foundation or the structure as applicable. The buried structure bedding material shall be compacted in accordance with the Section 2-09.3(1)E requirements for backfill supporting Structures.

All buried structure bedding material adjacent to structural plate structures shall meet the material requirements for backfill material in Section 6-20.3(9).

Structures with a curved, nonplanar bottom, such as structural plate pipes, require buried structure bedding material with a minimum thickness of twice the corrugation depth, but not less than 6 inches. The buried structure bedding material shall be shaped to conform to the bottom of the structure and shall provide a uniform bearing throughout the buried structure length. The buried structure bedding material shall be centered beneath the structure and shall have a minimum width of one-third the Structural Clear Span for horizontal elliptic shapes and one-half the Structural Clear Span otherwise. The buried

structure bedding material shall be loosely placed (not compacted), to cushion the invert and allow corrugations to nest or seat into it.

Rock, in either ledge or boulder formation, hard pan, or cemented gravel occurring in the base material shall be excavated to below the buried structure bedding material.

6-20.3(6)B Foundations

Cast-in-place concrete foundations and components of foundations shall be constructed in accordance with Section 6-02.

Precast concrete foundations shall be constructed in accordance with Section 6-02.3(9).

6-20.3(7) Fabrication

Welding of steel shall be in accordance with Section 6-03.3(25). Welding of steel structural plate structures shall comply with the AWS D1.1/D1.1M Structural Welding Code.

Welding of aluminum shall conform to the ANSI/AWS D1.2/D1.2M Structural Welding Code – Aluminum.

6-20.3(7)A Precast Concrete Structures

Except as otherwise noted by these specifications, precast concrete buried structures shall conform to all requirements of Section 6-02.3(9).

Precast prestressed units shall be fabricated and transported in accordance with Section 6-02.3(25).

For Class 2 precast concrete three sided structures and precast concrete split box culverts, unless otherwise shown in the Plans, the Contractor shall, at a minimum for each set of forms used, progressively shop assemble the top and bottom units of the first 3 adjacent units for inspection of fit up. Units shall not be disassembled prior to receiving the Engineer's acceptance. If the Engineer accepts the initial assembly then no additional shop assembly will be required unless the Contractor changes forms, the forms show signs of damage, or there is a geometric change to the forms. If issues are found during progressive shop assembly, the Contractor shall make corrections and continue progressive shop assembly until three consecutive units have been successfully shop assembled. The shop assembly shall be done on a flat level surface at the fabrication plant. Bunking or shimming will not be allowed during the shop assembly.

The following information shall be legibly and permanently marked on one inside face of each precast unit by indentation, waterproof paint or other means acceptable to the Engineer:

1. Span and rise dimensions
2. Date of fabrication
3. Name or trademark of the fabricator
4. WSDOT Contract Number

5. Unit identifier shown in the Plans or Working Drawings. If the precast culvert fabricator modifies the finished precast culvert units for shop fit up then the fabricator shall sequentially number all of the precast culvert units for field assembly. The Contractor shall assemble the precast culvert units according to the sequential number.

6-20.3(7)B Structural Plate Structures

The following information shall be legibly and permanently marked on the inside face of each structural plate by waterproof paint or other means acceptable to the Engineer:

1. Plate thickness or gage
2. Date of fabrication
3. Name or trademark of the fabricator
4. WSDOT Contract Number
5. Unit identifier shown in the Plans or Working Drawings

6-20.3(8) Placement and Assembly

Buried structures shall be placed and assembled in accordance with the Contract documents and the submittals of Sections 6-20.3(2)A, 6-20.3(2)C, 6-20.3(2)E, and 6-20.3(2)F.

Components with identified pick points or lifting locations shall be handled using those locations. Component pieces shall be set into their final position in a manner that preserves the lines and grade established for the structure. Base units, precast foundations, and bearing surfaces may be slid on grade to adjust their position, but if sliding results in grade changes, misalignment, or foundation material pushed into joints between components, the component shall be removed and the grade adjusted. Grade shall be adjusted such that components can be assembled in accordance with the required tolerances.

Shims used by the Contractor to position components for assembly shall be removed unless the shims are specified as permanent in the Plans or Working Drawings.

Components that are not self-supporting shall be braced or supported by the Contractor during assembly.

Construction of cast-in-place concrete components shall be in accordance with Section 6-02.

6-20.3(8)A Precast Concrete Structures

For structures that are expected to support traffic within 7 days after the placement of prefabricated segments is complete, the Contractor shall designate an individual to verify and record conformance to the erection tolerances for each segment as it is placed.

Components with weld-ties shall be connected by welding the weld-tie anchors in accordance with Section 6-03.3(25). The welding ground shall be attached directly to the

plates being welded. After connecting the weld-tie anchors, the Contractor shall paint the exposed metal surfaces with one coat of primer, zinc-rich, single-component, moisture-cured polyurethane. Keyways shall be filled with grout type 2 for nonshrink applications, unless specified otherwise.

The Contractor shall install a continuous strip of butyl rubber sealant within all tongue and groove joints prior to connecting the precast elements together. The butyl rubber sealant shall be sized per the manufacturer's recommendations, but shall not have a cross section smaller than ½-inch by 1½-inch.

The Contractor shall wrap all exterior joints along the top and sides of precast concrete structures (except top surfaces that will have a waterproof membrane and HMA overlay, a concrete overlay or a concrete deck) with a 12-inch wide strip of external sealing band centered about the joint and adhesively bonded to the concrete surface.

6-20.3(8)B Structural Plate Structures

Construction of structural plate pipes, arches and boxes shall conform to the AASHTO LRFD Bridge Construction Specifications, Section 26.

Plates at longitudinal and circumferential seams shall be configured with the seams staggered so that not more than three barrel plates come together at any one point.

When required, temporary bracing shall be installed and shall remain in place as long as necessary to protect workers and to maintain structure shape during placement and assembly.

Bolts and bolted connections shall conform to the requirements of AASHTO M 167 for steel and AASHTO M 219 for aluminum. Bolts shall be sufficiently torqued to avoid backing out while compacting backfill.

Where aluminum will contact concrete or grout, two coats of paint shall be applied to the aluminum at the contact surface in accordance with Section 7-08.3(2)D.

Where the galvanized coating on structural plate has been damaged in handling or installing, such damaged areas shall be thoroughly painted with galvanizing repair paint, high zinc dust content.

6-20.3(9) Backfilling

The backfill outside of buried structures shall be granular material meeting the requirements in the Working Drawings, meeting the buried structure manufacturer's requirements and conforming to the requirements of AASHTO M 145 A-1 or A-3. Granular material shall consist of a crushed rock and/or processed angular material. On site granular soils may be considered for backfill around the structure if the material meets the requirements in this specification.

The following backfill materials generally meet the AASHTO M 145 A-1 or A-3 requirements. Additional gradation requirements by the structure manufacturer may apply.

1. Section 9-03.9(1) Ballast
2. Section 9-03.9(3) Crushed Surfacing (Top and Base Course)
3. Section 9-03.9(4) Maintenance Rock
4. Section 9-03.12(1)A Gravel Backfill for Foundations Class A
5. Section 9-03.12(3) Gravel Backfill for Pipe Zone Bedding
6. Section 9-03.14(1) Gravel Borrow
7. Section 9-03.14(2) Select Borrow
8. Section 9-03.14(4) Gravel Borrow for Structural Earth Wall

Backfilling shall conform to Section 2-09.3(1)E and the Working Drawings. Backfill of buried structures to the minimum cover level specified for the structure shall be considered to be supporting the structure for determining backfill placement layer thicknesses and compaction densities. Backfill shall be brought up incrementally on each side of the structure to balance the loading until the top of the structure is reached. The difference in backfill height on opposing sides of the Structure shall not exceed 2 feet.

Equipment used to compact backfill within 3 feet from sides of buried structures shall have received the Engineer's acceptance prior to use. Sheepsfoot rollers or rollers with protrusions for compacting shall not be used until there is more than two feet of compacted backfill over the structure.

Where backfill material is placed against dissimilar materials not meeting backfill material requirements, a suitable geotextile shall be provided to avoid migration.

When specified in the Contract documents or Working Drawings, the Contractor shall place and compact materials within the buried structure. The Contractor may place and compact materials prior to finishing assembly provided the placement and compaction does not damage or distort the Structure or hinder the achievement of the specified tolerances.

6-20.3(9)A Backfilling of Structural Plate Structures

The structural backfill envelope shall include the backfill outside of the buried structure within the following limits:

1. Vertically, from the lowest elevation of the structural plate up to the lesser of the minimum cover height over the structural plate, the bottom of asphalt pavement or the top of a reinforced concrete pavement as defined in the AASHTO LRFD Bridge Design Specifications.
2. Horizontally, between the outer edges of the minimum structural backfill widths on each side of the structural plate as defined in the AASHTO LRFD Bridge Design Specifications.

All water and backfill materials inside or adjacent to a structural plate buried structure or within the structural backfill envelope shall meet the following requirements:

1. pH in accordance with WSDOT T 417 shall be within the range of 6.0 and 10.0 for galvanized steel buried structures and within the range of 4.0 and 9.0 for aluminum buried structures and shall also meet the requirement to provide a minimum 75 year service life
2. Resistivity in accordance with WSDOT T 417 shall be 2,500 ohm-cm minimum for galvanized steel buried structures and 500 ohm-cm minimum for aluminum buried structures but shall not be less than that required to provide a minimum 75 year service life
3. Chlorides in accordance with AASHTO T 291 shall be 100 ppm maximum
4. Sulfates in accordance with AASHTO T290 shall be 200 ppm maximum
5. Organics shall be 1% or less by dry weight.

When required, temporary bracing shall be installed and shall remain in place as long as necessary to protect workers and to maintain structure shape during backfilling.

Structure shape shall be checked regularly by the Contractor during backfilling to verify acceptability of the construction methods used. The magnitude of allowable shape change shall meet the manufacturer's requirements as well as the requirements in Section 6-20.3(3). For Class 2 buried structures, a manufacturer's representative shall assist as described in Section 6-20.3(4)A.

Installation deflection inspections by direct measurement shall be performed by the Contractor immediately after construction and 30 days or more after construction. Inspection results shall be reported to the Contracting Agency within 2 working days of performing the inspection. Installation deflections shall meet the requirements of Section 6-20.3(3).

6-20.3(10) Wingwalls and Headwalls

The Contractor shall construct wingwalls and headwalls associated with buried structures in conformance with the Contract documents and Working Drawing submittals.

For buried structures crossing water, portions of headwalls and wingwalls below the 100 year mean recurrence interval water surface shall be reinforced concrete or have a reinforced concrete fascia.

Structural Earth Wall wingwalls shall not use metallic ground reinforcement below the 100 year mean recurrence interval water surface unless the pH, in accordance with WSDOT T 417, of the water in front of the wall and of the groundwater are within the range of 5.0 and 10.0.

Cast-in-place concrete components of headwalls and wingwalls shall be constructed in accordance with Section 6-02.

Precast concrete construction shall conform to Sections 6-02.3(9) and 6-11.3(3).

Bedding material shall be furnished, placed, and compacted in accordance with Section 6-20.3(6).

6-20.4 Vacant

6-20.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Agency Designed Buried Structure No. _____", lump sum.

The lump sum Contract price for "Agency Designed Buried Structure No. _____" shall be full payment to perform the Work as specified in Section 6-20.3.

The approximate quantities of materials and work for the lump sum item "Agency Designed Buried Structure No. _____" may be provided in the Contract documents. If so, the quantities listed are only for the convenience of the Contractor in determining the volume of work involved and are not guaranteed to be accurate. Quantities may vary depending on the Contractor's Work methods, order of work, suitability of excavated materials, and structure dimensions. The prospective bidders shall verify these quantities before submitting a bid. No adjustments other than for accepted changes will be made in the lump sum Contract price for "Agency Designed Buried Structure No. _____" even though the actual quantities required may deviate from those listed.

"Contractor Designed Buried Structure No. _____", lump sum.

The lump sum Contract price for "Contractor Designed Buried Structure No. _____" shall be full payment to perform the Work as specified in Section 6-20.3.

The approximate quantities of materials and work for the lump sum item "Contractor Designed Buried Structure No. _____" may be provided in the Contract documents. If so, the quantities listed are only for the convenience of the Contractor in determining the volume of work involved and are not guaranteed to be accurate. Quantities may vary depending on the Contractor's Work methods, order of work, suitability of excavated materials, and structure dimensions. The prospective bidders shall verify these quantities before submitting a bid. No adjustments other than for accepted changes will be made in the lump sum Contract price for "Contractor Designed Buried Structure No. _____" even though the actual quantities required may deviate from those listed.

"Shoring or Extra Excavation Cl. A _____", lump sum.

Division 7 Drainage Structures, Storm Sewers, Sanitary Sewers, Water Mains, and Conduits

7-01 Drains

7-01.1 Description

This Work consists of constructing drain pipe and underdrain pipe in accordance with the Plans, these Specifications and *Standard Plans*, at the locations staked.

7-01.2 Materials

Materials shall meet the requirements of the following sections:

Gravel Backfill for Drains	9-03.12(4)
Concrete Drain Pipe	9-05.1(1)
Zinc Coated (Galvanized) or Aluminum Coated (Aluminized) Corrugated Iron or Steel Drain Pipe	9-05.1(2)
Corrugated Aluminum Alloy Drain Pipe	9-05.1(3)
Polyvinyl Chloride (PVC) Drain Pipe, Couplings and Fittings	9-05.1(5)
Corrugated Polyethylene (PE) Drain Pipe, Couplings and Fittings (up to 10 inch)	9-05.1(6)
Corrugated Polyethylene (PE) Drain Pipe, Couplings and Fittings (12 through 60 inch)	9-05.1(7)
Perforated Concrete Underdrain Pipe	9-05.2(2)
Zinc Coated (Galvanized) or Aluminum Coated (Aluminized) Corrugated Iron or Steel Underdrain Pipe	9-05.2(4)
Perforated Corrugated Aluminum Alloy Underdrain Pipe	9-05.2(5)
Perforated Polyvinyl Chloride (PVC) Underdrain Pipe, 8-inch diameter maximum	9-05.2(6)
Perforated Corrugated Polyethylene (PE) Underdrain Pipe (up to 10 inch)	9-05.2(7)
Perforated Corrugated Polyethylene (PE) Underdrain Pipe (12 through 60 inch)	9-05.2(8)

Drain pipes may be concrete, zinc coated (galvanized) corrugated iron, aluminum coated (aluminized) corrugated iron, zinc coated (galvanized) steel, aluminum coated (aluminized) steel, corrugated aluminum alloy, polyvinyl chloride (PVC), or corrugated polyethylene (PE) at the option of the Contractor unless the Plans specify the type to be used.

Underdrain pipe, other than AASHTO M36 Type III Class IV, shall be perforated. They may be concrete, bituminized fiber, zinc coated (galvanized) corrugated iron, aluminum coated (aluminized) corrugated iron, zinc coated (galvanized) steel, aluminum coated (aluminized) steel, corrugated aluminum alloy, polyvinyl chloride (PVC), or corrugated polyethylene (PE) at the option of the Contractor unless the Plans specify the type to be used.

It is not necessary that all drain or underdrain pipes on any one project be of the same kind of material; however, all contiguous pipe shall be of the same kind.

7-01.3 Construction Requirements

A trench of the dimensions shown in the Plans or as specified by the Engineer shall be excavated to the grade and line given by the Engineer.

7-01.3(1) Drain Pipe

Drain pipe shall be laid in conformity with the line and grades as shown in the Plans. The drain pipe shall be laid with soiltight joints unless otherwise specified. Concrete drain pipe shall be laid with the bell or larger end upstream. PVC drain pipe shall be jointed with a bell and spigot joint using a flexible elastomeric seal as described in Section 9-04.8. The bell shall be laid upstream. PE drain pipe shall be jointed with snap-on, screw-on, bell and spigot, or wraparound coupling bands as recommended by the manufacturer of the tubing.

7-01.3(2) Underdrain Pipe

When underdrain pipe is being installed as a means of intercepting ground or surface water, the trench shall be fine-graded in the existing soil 3 inches below the grade of the pipe as shown in the Plans. Gravel backfill shall be used under the pipe. Gravel backfill shall be placed to the depth shown in the Plans or as designated by the Engineer. All backfill shall be placed in 12-inch maximum layers and be thoroughly compacted with three passes of a vibratory compactor for each layer. The Contractor shall use care in placing the gravel backfill material to prevent its contamination.

Class 2 perforations shall be used unless otherwise specified. When Class 1 perforations are specified the perforated pipe shall be laid with the perforations down. Upon final acceptance of the Work, all drain pipes shall be open, clean, and free draining. Perforated pipe does not require a watertight joint. PVC underdrain pipe shall be jointed using either the flexible elastomeric seal as described in Section 9-04.8 or solvent cement as described in Section 9-04.9, at the option of the Contractor unless otherwise specified in the Plans. The bell shall be laid upstream. PE drainage tubing underdrain pipe shall be jointed with snap-on, screw-on, bell and spigot, or wraparound coupling bands, as recommended by the manufacturer of the tubing.

7-01.4 Measurement

The length of drain or underdrain pipe will be the number of linear feet of completed installation measured along the invert. Pipe placed in excess of the length designated by the Engineer will not be measured or paid for.

Excavation of the trench will be measured as Structure excavation Class B or Structure excavation Class B including haul by the cubic yard as specified in Section 2-09.

Gravel backfill for drains will be measured by the volume placed within the neatline limits of Structure excavation Class B.

7-01.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Drain Pipe ____ In. Diam.", per linear foot.

"Underdrain Pipe ____ In. Diam.", per linear foot.

"Gravel Backfill for Drain", per cubic yard.

"Structure Excavation Class B", per cubic yard.

"Structure Excavation Class B Incl. Haul", per cubic yard.

7-02 Culvert Pipe

7-02.1 Description

This Work consists of constructing culvert pipes of the various types and classes in accordance with the Plans, these Specifications, and the *Standard Plans*, at the locations staked.

Culvert pipes may be used for transverse drains under the Roadway or as conduits for water pipe or other utilities passing under the Roadway.

7-02.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates for Concrete	9-03.1
Gravel Backfill for Pipe Zone Bedding	9-03.12(3)
Butyl Rubber Sealant	9-04.11
External Sealing Band	9-04.12
Plain Concrete Culvert Pipe	9-05.3(1)
Reinforced Concrete Culvert Pipe	9-05.3(2)
Beveled Concrete End Sections	9-05.3(3)
Steel Culvert Pipe and Pipe Arch	9-05.4
Steel Nestable Pipe and Pipe Arch	9-05.4(8)
Steel End Sections	9-05.4(9)
Aluminum Culvert Pipe	9-05.5
Aluminum End Sections	9-05.5(6)
Solid Wall PVC Culvert Pipe	9-05.12(1)
Profile Wall PVC Culvert Pipe	9-05.12(2)
Corrugated Polyethylene Culvert Pipe	9-05.19
Steel Rib Reinforced Polyethylene Culvert Pipe	9-05.21
High-Density Polyethylene (HDPE) Pipe	9-05.23
Polypropylene Culvert Pipe	9-05.24
Steel Reinforcing Bar	9-07.2
Epoxy-Coated Steel Reinforcing Bar	9-07.3
Welded Wire Reinforcement	9-07.7
Deformed Wire	9-07.8
Cold Drawn Wire	9-07.9
Grout	9-20.3(2)
Mortar	9-20.4
Concrete Curing Materials and Admixtures	9-23

Where steel or aluminum are referred to in this section in regard to a kind of culvert pipe, pipe arch, or end sections, it shall be understood that steel is zinc coated (galvanized) or aluminum coated (aluminized) corrugated iron or steel, and aluminum is corrugated aluminum alloy as specified in Sections 9-05.4 and 9-05.5.

Thermoplastic culvert pipe includes solid wall PVC culvert pipe, profile wall PVC culvert pipe, corrugated polyethylene culvert pipe, and polypropylene culvert pipe.

It is not necessary that all culvert pipe on any one project be of the same kind of material. However, all contiguous pipe shall be of the same size, material, thickness, class, and treatment and shall be that required for the maximum height of cover.

Measurement for payment of the Bid items associated with the drainage installation will be based on the diameter of the culvert pipe described by the Bid item in the Proposal.

When schedule A, B, C, or D culvert pipe is specified in the Plans, the Contractor shall provide the specified schedule and diameter but has the option of furnishing any of the acceptable materials shown in the Culvert Pipe Schedules Table.

The use of tongue and groove concrete pipe shall only be allowed under side road connections. All tongue and groove pipe shall be joined with cement mortar.

Culvert Pipe Schedules					
Schedule (Fill Height)	**Diameter in inches**	**Concrete**	**Steel 2⅔″ × ½″**	**Aluminum 2⅔″ × ½″**	**Thermoplastic PE[1], PVC[2], or PP[3]**
A 2′ - 15′	12, 18, 24	Class III	.064″ (16 Ga.)	.060″ (16 Ga.)	PE, PVC, or PP
	30, 36	Class III	.064″ (16 Ga.)	.075″ (14 Ga.)	PE, PVC, or PP
	42, 48	Class III	.064″ (16 Ga.)	.105″ (12 Ga.)	PE, PVC, or PP
B 15′ - 25′	12, 18, 24	Class V	.064″ (16 Ga.)	.060″ (16 Ga.)	PE, PVC, or PP
	30, 36	Class IV	.064″ (16 Ga.)	.075″ (14 Ga.)	PE, PVC, or PP
	42, 48	Class IV	.064″ (16 Ga.)	.105″ (12 Ga.)	PE, PVC, or PP
C 25′ - 40′	12, 18, 24	Class V	.064″ (16 Ga.)	.060″ (16 Ga.)	None
	30, 36	Class V	.064″ (16 Ga.)	.075″ (14 Ga.)	None
	42, 48	Class V	.064″ (16 Ga.)	.105″ (12 Ga.)	None
D 40′ - 60′	12, 18	None	.064″ (16 Ga.)	.060″ (16 Ga.)	None
	24	None	.064″ (16 Ga.)	.075″ (14 Ga.)	None
	30, 36	None	.064″ (16 Ga.)	.105″ (12 Ga.)	None
	42, 48	None	.079″ (14 Ga.)	.135″ (10 Ga.)	None

[1]Corrugated polyethylene pipe.
[2]Polyvinyl chloride pipe. Solid wall or profile wall for diameters through 27 inches Profile wall for diameters larger than 27 inches.
[3]Polypropylene pipe, 12 inch to 30 inch diameters approved for Schedule A and Schedule B, and 36 inch to 60 inch diameters approved for Schedule A only.

7-02.3 Construction Requirements

Culvert pipes shall be constructed in accordance with Section 7-08.3.

7-02.3(1) Placing Culvert Pipe – General

A dike or plug of impervious material shall be placed near the intake end of the culvert pipe to prevent piping. The dike shall be 2 feet long and adequately surround the pipe to form an impervious barrier. When suitable impervious materials are not available at the site, suitable backfill shall be obtained as provided in Section 2-09.3(1)E.

The ends of the pipe or pipe arch shall be rigidly supported to prevent movement before and during the construction of end walls or headers.

Culvert pipes shall not be left extending beyond the staked limits unless approved by the Engineer.

All thermoplastic pipe shall be beveled to match the embankment or ditch slope but shall not be beveled flatter than 4:1. The minimum length of each section of pipe that is to be beveled shall be at least six times the diameter of the pipe when measured from the toe of the bevel to the joint.

7-02.3(2) Installation of Metal End Sections

Metal end sections shall be installed in accordance with the requirements of the *Standard Plans*, the Plans, and applicable portions of these Specifications.

When flared metal end sections are installed on concrete pipe, Design B end sections will be used on the inlet end only. Design C end sections will be used on the outlet ends only according to the following schedule:

Concrete Pipe Nominal Dia. in inches	End Section Nominal Dia. in inches
12	15
18	24
24	30
30	36
36	42
42	48
48	60
54	66
60	72
66	78
72	84

7-02.3(3) Headwalls

If headwalls are specified in the Plans, they shall be constructed as soon as the embankment has been completed to a sufficient height over the Structure to allow the required Work. Headwalls shall be constructed in accordance with applicable portions of Section 6-02.

7-02.3(4) Removing and Relaying Culvert Pipes

Where shown in the Plans or where designated by the Engineer, existing culvert pipes shall be removed and relaid in accordance with these Specifications. Any culvert pipe damaged by the Contractor's operations shall be replaced by the Contractor at no expense to the Contracting Agency. In the case of concrete pipe, all joints of the pipe before being relaid shall be cleaned so as to be free from all adhering material, including old mortar placed as a collar or seal in the original construction.

All culvert pipe sections removed and not relaid shall become the property of the Contractor.

7-02.3(5) Safety Bars for Culvert Pipe

When shown in the Plans, safety bars for culvert pipe shall be constructed in accordance with the *Standard Plans* and shall meet the requirements of Section 9-05.18.

7-02.4 Measurement

The length of culvert pipe or pipe arch will be the number of linear feet of completed installation measured along the invert. Pipe placed in excess of the length designated by the Engineer will not be measured or paid for.

Beveled end sections will be considered as part of the culvert pipe and shall be measured as culvert pipes.

Flared steel and aluminum end sections will be measured by the number of integral units of the dimension specified including toe plate extensions if called for in the Plans.

The pipe connector section of end section Design A shall be fabricated as a part of the integral unit of the end section but will be measured as linear feet of pipe or pipe arch of the treatment, thickness and dimensions of pipe to which it is attached. If there is no Bid item for pipe of the proper dimensions for the end sections, the pipe connector sections will be considered as part of the integral unit and will not be measured as pipe.

Pipe connector sections of end section Design B will be considered part of the integral unit and measurement will be by number of integral units of the type and dimension specified.

The length of safety bars for culvert pipe will be the number of linear feet of each safety bar installed.

Tapered end section with safety bars will be measured by the unit per each.

7-02.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Schedule ____ Culv. Pipe ____ In. Diam.", per linear foot.

"Plain Conc. Culv. Pipe ____ In. Diam.", per linear feet.

"Cl. ____ Reinf. Conc. Culv. Pipe ____ In. Diam.", per linear foot.

"Plain St. Culv. Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Tr. ____ St. Culv. Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Plain St. Culv. Pipe Arch ____ In. Th. ____ In. Span", per linear foot.

"Tr. ____ St. Culv. Pipe Arch ____ In. Th. ____ In. Span", per linear foot.

"Plain Nestable St. Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Tr. ____ Nestable St. Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Plain Al. Culv. Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Plain Al. Culv. Pipe Arch ____ In. Th. ____ In. Span", per linear foot.

"Relaying (type of Pipe and Size)", per linear foot.

"Solid Wall PVC Culv. Pipe ____ In. Diam.", per linear foot.

"Profile Wall PVC Culv. Pipe ____ In. Diam.", per linear foot.

"Corrugated Polyethylene Culv. Pipe ____ In. Diam.", per linear foot.

"St. Rib Reinf Polyethylene Culv. Pipe ____ In. Diam.", per linear foot.

"High-Density Polyethylene (HDPE) Pipe ____ In. Diam.", per linear foot.

"Polypropylene Culvert Pipe ____ In. Diam.", per linear foot.

Where culvert pipes are to be removed but are not to be relaid, all costs in connection with the removal shall be included in the unit Contract price per cubic yard for "Structure Excavation Class B" or "Structure Excavation Class B Incl. Haul".

"Flared End Section ____ In. Diam.", per each.

"Flared End Section ____ In. Span", per each.

"Safety Bars for Culvert Pipe Type ____", per linear foot.

"Tapered End Sect. with Type ____ Safety Bars ____ In. Diam.", per each.

7-03 Vacant

7-04 Storm Sewers

7-04.1 Description

This Work consists of constructing storm sewer lines in accordance with the Plans, these Specifications, and the *Standard Plans*, as staked.

7-04.2 Materials

Materials shall meet the requirements of the following sections:

Plain Concrete Storm Sewer Pipe	9-05.7(1)
Reinforced Concrete Storm Sewer Pipe	9-05.7(2)
Steel Spiral Rib Storm Sewer Pipe	9-05.9
Steel Storm Sewer Pipe	9-05.10
Aluminum Storm Sewer Pipe	9-05.11
Solid Wall PVC Storm Sewer Pipe	9-05.12(1)
Profile Wall PVC Storm Sewer Pipe	9-05.12(2)
Aluminum Spiral Rib Storm Sewer Pipe	9-05.17
Corrugated Polyethylene Storm Sewer Pipe	9-05.20
Steel Rib Reinforced Polyethylene Storm Sewer Pipe	9-05.22
High-Density Polyethylene (HDPE) Pipe	9-05.23
Polypropylene Storm Sewer Pipe	9-05.24

Where steel or aluminum are referred to in this section in regard to a kind of storm sewer pipe, it shall be understood that steel is zinc coated (galvanized) or aluminum coated (aluminized) corrugated iron or steel and aluminum is corrugated aluminum alloy as specified in Sections 9-05.4 and 9-05.5.

Thermoplastic storm sewer pipe includes solid wall PVC storm sewer pipe, profile wall PVC storm sewer pipe, corrugated polyethylene storm sewer pipe, and polypropylene storm sewer pipe.

Measurement for payment of the Bid items associated with the storm sewer installation will be based on the diameter of the storm sewer pipe described by the Bid item in the Plans.

It is not necessary that all storm sewer pipe on any one project be of the same kind of material. However, all contiguous pipe shall be of the same size, material, thickness, class, and treatment and shall be that required for the maximum height of cover.

When schedule A or B storm sewer pipe is specified in the Plans, the Contractor shall provide the specified schedule and diameter but has the option of furnishing any of the acceptable materials shown in the Storm Sewer Pipe Schedules Table.

7-04.3 Construction Requirements

Storm sewers shall be constructed in accordance with Section 7-08.3.

7-04.3(1) Cleaning and Testing

7-04.3(1)A General

The requirements of Section 7-17.3(2)A shall apply to storm sewers.

7-04.3(1)B Exfiltration Test – Storm Sewers

Prior to making exfiltration leakage tests, the Contractor may fill the pipe with clear water to permit normal absorption into the pipe walls.

Leakage shall be no more than 1 gallon per hour per inch of diameter per 100 feet of storm sewer pipe, with a minimum test pressure of 6 feet of water column above the crown at the upper end of the pipe or above the active ground water table, whichever is higher as determined by the Engineer. The length of pipe tested shall be limited so that the pressure on the invert of the lower end of the Section tested shall not exceed 16 feet of water column. For each increase in pressure of 2 feet above a basic 6 feet measured above the crown at the lower end of the test section, the allowable leakage shall be increased by 10 percent.

Storm Sewer Pipe Schedules							
						Aluminum	
Schedules (Fill Ht.)	Dia. (In.)	Concrete	PVC[1]	PE[2] PP[4]	Steel[3] 2⅔″ × ½″ or Spiral Rib	2⅔″ × ½″ Corr. • Tr. 5 • Plain With Gasketed Seams	Spiral Rib • Tr. 5 • Plain With Gasketed Seams
A 2′ – 15′	12	Plain or Cl. IV	SW or PW	Allowed	0.064″ (16 Ga.)	0.060″ (16 Ga.)	0.060″ (16 Ga.)
	18	Plain or Cl. IV	SW or PW	Allowed	0.064″ (16 Ga.)	0.060″ (16 Ga.)	0.060″ (16 Ga.)
	24	Plain or Cl. IV	SW or PW	Allowed	0.064″ (16 Ga.)	0.060″ (16 Ga.)	0.060″ (16 Ga.)
	30	Class III	PW	Allowed	0.064″ (16 Ga.)	0.075″ (14 Ga.)	0.060″ (16 Ga.)
	36	Class III	PW	Allowed	0.064″ (16 Ga.)	0.075″ (14 Ga.)	0.060″ (16 Ga.)
	42	Class III	PW	Allowed	0.064″ (16 Ga.)	0.105″ (12 Ga.)	0.075″ (14 Ga.)
	48	Class III	PW	Allowed	0.064″ (16 Ga.)	0.105″ (12 Ga.)	0.075″ (14 Ga.)
B 15′ – 25′	12	Class V	SW or PW	Allowed	0.064″ (16 Ga.)	0.060″ (16 Ga.)	0.060″ (16 Ga.)
	18	Class V	SW or PW	Allowed	0.064″ (16 Ga.)	0.060″ (16 Ga.)	0.060″ (16 Ga.)
	24	Class V	SW or PW	Allowed	0.064″ (16 Ga.)	0.060″ (16 Ga.)	0.060″ (16 Ga.)
	30	Class V	PW	Allowed	0.064″ (16 Ga.)	0.075″ (14 Ga.)	0.075″ (14 Ga.)
	36	Class V	PW	Allowed	0.064″ (16 Ga.)	0.075″ (14 Ga.)	0.105″ (12 Ga.)
	42	Class V	PW	Allowed	0.064″ (16 Ga.)	0.105″ (12 Ga.)	0.105″ (12 Ga.)
	48	Class V	PW	Allowed	0.064″ (16 Ga.)	0.105″ (12 Ga.)	0.105″ (12 Ga.)

[1]PVC = Polyvinyl Chloride Pipe, SW = Solid Wall PVC, PW = Profile Wall PVC

[2]PE = Corrugated Polyethylene Pipe

[3]Steel pipe options for either 2⅔″ × ½″ corrugations or spiral rib include: Tr. 5 galvanized, Tr. 2 galvanized with gasketed seams, Tr. 5 aluminized, or plain aluminized with gasketed seams.

[4]PP = Polypropylene Pipe, 12 inch to 30 inch approved for Schedule A and Schedule B and 36 inch to 60 inch diameters approved for Schedule A only.

7-04.3(1)C Infiltration Test – Storm Sewers

Whenever the ground water table is above the crown of the higher end of the pipe section at the time of testing, an infiltration test may be performed in lieu of the exfiltration test upon written permission of the Engineer. The maximum allowable limit for infiltration shall be 0.8 gallon per hour per inch of diameter per 100 feet of length with no allowance for external hydrostatic head.

7-04.3(1)D Other Test Allowances – Storm Sewers

Other allowances for infiltration and exfiltration tests shall be in accordance with Section 7-17.3(2)D.

7-04.3(1)E Low Pressure Air Test for Storm Sewers Constructed of Air Permeable Materials

When air permeable pipe is subjected to a low-pressure air test, all of the provisions of Section 7-17.3(2)E shall apply, except that the time in seconds for the pressure drop shall be equal to or greater than the required time as shown in the table below:

Time in Seconds for Pressure Drop										
Pipe Dia. (in)	Pipe Length (ft)									
	50	100	150	200	250	300	350	400	450	500
4	5	9	14	18	22	27	31	36	40	45
6	10	20	30	40	50	60	70	80	85	85
8	18	36	54	71	89	107	114	114	114	114
10	28	56	84	111	139	142	142	142	143	159
12	40	80	120	160	170	170	170	183	206	228
15	63	125	188	213	213	214	250	286	320	360
18	90	180	255	255	257	310	360	410	460	520
21	123	245	298	298	350	420	490	560	630	700
24	160	320	340	370	460	550	640	730	830	920
27	203	390	390	460	580	700	810	930	1040	1160
30	250	430	430	570	720	860	1000	1140	1290	1430

All time values listed in the table are in seconds. If a section to be tested includes more than one pipe size, the total time required can be found by adding the time values for each size of pipe and its corresponding length. Interpolate between valves for pipe lengths not shown.

Pipe over 30 inches in diameter shall be tested one joint at a time in accordance with ASTM C1103.

7-04.3(1)F Low Pressure Air Test for Storm Sewers Constructed of Non Air Permeable Materials

When non air permeable pipe is subjected to a low-pressure air test, all of the provisions of Section 7-17.3(2)E shall apply, except that the time in seconds for the pressure drop shall be equal to or greater than four times the time shown in the table listed in Section 7-04.3(1)E.

Pipe over 30 inches in diameter shall be tested one joint at a time in accordance with ASTM C1103.

Reaches of thermoplastic pipe containing no joints shall be exempt from testing requirements.

7-04.4 Measurement

The length of storm sewer pipe will be the number of linear feet of completed installation measured along the invert and will include the length through elbows, tees, and fittings. The number of linear feet will be measured from the center of manhole to center of manhole or to the inside face of catch basins and similar type Structures.

The length of testing storm sewer pipe in conformance with Section 7-17.3(2)A will be the number of linear feet of completed installation actually tested.

7-04.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Plain Conc. Storm Sewer Pipe ____ In. Diam.", per linear foot.

"Class ____ Reinf. Conc. Storm Sewer Pipe ____ In. Diam.", per linear foot.

"Tr. ____ St. Storm Sewer Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Tr. ____ Al. Storm Sewer Pipe ____ In. Th. ____ In. Diam.", per linear foot.

"Solid Wall PVC Storm Sewer Pipe ____ In. Diam.", per linear foot.

"Profile Wall PVC Storm Sewer Pipe ____ In. Diam.", per linear foot.

"Corrugated Polyethylene Storm Sewer Pipe ____ In. Diam.", per linear foot.

"Schedule ____ Storm Sewer Pipe ____ In. Diam.", per linear foot.

"St. Rib Reinf Polyethylene Storm Sewer Pipe ____ In. Diam", per linear foot.

"High-Density Polyethylene (HDPE) Pipe ____ In. Diam.", per linear foot.

"Polypropylene Storm Sewer Pipe ____ In. Diam.", per linear foot.

The unit Contract price per linear foot for storm sewer pipe of the kind and size specified shall be full pay for all Work to complete the installation, including adjustment of inverts to manholes.

"Testing Storm Sewer Pipe", per linear foot.

7-05 Manholes, Inlets, Catch Basins, and Drywells

7-05.1 Description

This Work consists of constructing manholes, inlets, drywells, and catch basins and connecting to existing Structures of the types and sizes designated in accordance with the Plans, these Specifications, and the *Standard Plans*, in conformity with the lines and grades staked.

7-05.2 Materials

Materials shall meet the requirements of the following sections:

Concrete	6-02
Crushed Surfacing Base Course	9-03.9(3)
Gravel Backfill for Drywells	9-03.12(5)
Rubber Gaskets	9-04.4
Flexible Plastic Gaskets	9-04.5
Metal Castings	9-05.15
Grate Inlets and Drop Inlets	9-05.16
Reinforcing Steel	9-07
Concrete Blocks	9-12.1
Concrete Brick	9-12.2
Precast Concrete Manhole	9-05.50(2)
Precast Concrete Catch Basins	9-05.50(3)
Precast Concrete Inlets	9-05.50(4)
Precast Concrete Drywells	9-05.50(5)
Underground Drainage Geotextile, Moderate Survivability	9-33.1
Mortar	9-20.4

7-05.3 Construction Requirements

The excavation for all manholes, inlets, and catch basins shall be sufficient to leave 1 foot in the clear between their outer surfaces and the earth bank.

The excavation for drywells shall be in accordance with the *Standard Plans*. The drywell and gravel backfill for drywell shall be completely encased in moderate survivability underground drainage geotextile in accordance with the *Standard Plans* and in conformance with Section 2-12.3. During construction of the drywell, all necessary precautions shall be taken to prevent debris and eroded material from entering the drywell.

The cover or grating of a manhole, catch basin, or inlet shall not be grouted to final grade until the final elevation of the pavement, gutter, ditch, or sidewalk in which it is to be placed has been established, and until permission thereafter is given by the Engineer to grout the cover or grating in place. Covers shall be seated properly to prevent rocking. Leveling and adjustment devices that do not modify the structural integrity of the metal frame, grate or cover, and do not void the originating foundry's compliance to these specifications and warranty are allowed. Leveling and adjusting devices that interfere

with the backfilling, backfill density, grouting and asphalt density will not be allowed. The hardware for leveling and adjusting devices shall be completely removed when specified by the Engineer.

The channels in manholes shall conform accurately to the sewer grade.

Ladder rungs shall be grouted in the precast concrete walls. Rungs shall be uniformly spaced at 12 inches and be vertically aligned.

In the event any pipe enters the manhole through the precast concrete units, the Contractor shall make the necessary cut through the manhole wall and steel mesh. The steel shall be cut flush with the face of the concrete and shall be cut in such a manner that it will not loosen the reinforcement in the manhole wall.

The ends of all pipes shall be trimmed flush with the inside walls.

Rubber gaskets or flexible plastic gaskets may be used in tongue and groove joints of precast units. Joints between precast manhole units used for sanitary sewers shall be rubber gasketed. All other joints and all openings cut through the walls shall be grouted and watertight. Mortar shall conform to the requirements of Section 9-20.4(3).

If gaskets are used, handling of the precast units after the gasket has been affixed shall be done carefully to avoid disturbing or damaging the gasket or contaminating it with foreign material. Care shall be exercised to attain proper alignment before the joints are entirely forced home. During insertion of the tongue or spigot, the units shall be partially supported to minimize unequal lateral pressure on the gasket and to maintain concentricity until the gasket is properly positioned.

Rigid pipes connecting to sanitary sewer manholes shall be provided with a flexible joint at a distance from the face of the manhole of not more than 1½ times the nominal pipe diameter or 18 inches, whichever is greater.

Flexible pipes connecting to sanitary sewer manholes shall be provided with an entry coupling or gasket approved by the Engineer. No pipe joint in flexible pipe shall be placed within 10 feet of the manhole.

Backfilling around the Work will not be allowed until the concrete or mortar has thoroughly set.

Catch basins, manholes, and inlets shall be watertight.

Catch basin, grate inlet, and drop inlet connections to a sewer shall be so placed that the connecting pipe may be easily rodded over its entire length. After the connections are made, the Contractor shall rod all inlet and outlet pipes. All connections that cannot be successfully rodded shall be removed and new connections made.

Backfilling of manholes, inlets, catch basins, and drywells shall be done in accordance with the provisions of Section 2-09.

Manholes, catch basins, inlets, and drywells shall be constructed on a compacted or undisturbed level foundation. If the Contractor elects to use a separate cast-in-place base,

the concrete shall be Class 4000. Upon final acceptance of the Work, all manholes, catch basins, inlets, drywells, and other drainage Structures shall conform to the requirements of the *Standard Plans* except as approved by the Engineer.

Any shoring or extra excavation required shall meet the requirements of Section 2-09.3.

7-05.3(1) Adjusting Manholes and Catch Basins to Grade

Where shown in the Plans or where directed by the Engineer, the existing manholes, catch basins, or inlets shall be adjusted to the grade as staked or otherwise designated by the Engineer.

The existing cast iron ring and cover on manholes and the catch basin and inlet frame and grate shall first be removed and thoroughly cleaned for reinstalling at the new elevation. From that point, the existing Structure shall be raised or lowered to the required elevation. The materials and method of construction shall conform to the requirements specified above, and the finished Structure shall conform to the requirements of the *Standard Plans* except as approved by the Engineer.

7-05.3(2) Abandon Existing Manholes

Where it is required that an existing manhole be abandoned, the Structure shall be broken down to a depth of at least 4 feet below the revised surface elevation, all connections plugged, and the manhole filled with sand and compacted to 90 percent density as specified in Section 2-03.3(14)C. Debris resulting from breaking the upper part of the manhole may be mixed with the sand subject to the approval of the Engineer. The ring and cover shall be salvaged and all other surplus material disposed of.

7-05.3(3) Connections to Existing Manholes

The Contractor shall verify invert elevations prior to construction. The crown elevation of laterals shall be the same as the crown elevation of the incoming pipe unless specified. The existing base shall be reshaped to provide a channel equivalent to that specified for a new manhole.

The Contractor shall excavate completely around the manhole to prevent unbalanced loading. The manhole shall be kept in operation at all times and the necessary precautions shall be taken to prevent debris or other material from entering the sewer, including a tight pipeline bypass through the existing channel if required. Water used for flushing and testing shall not be allowed to enter the sewer.

All damage to the manhole resulting from the Contractor's operation shall be repaired at no expense to the Contracting Agency.

7-05.3(4) Drop Manhole Connection

Drop manhole connections shall be constructed in accordance with the Plans. One length of ductile iron pipe shall be provided outside the manhole.

7-05.4 Measurement

Manholes will be measured per each. In addition to the measurement per each, manholes in excess of 10 feet in height will be measured per linear foot for each additional foot of height over 10 feet. Measurement of manhole heights for payment purposes will be the distance from the flow line of the outlet pipe to the top of the manhole ring measured to the nearest foot.

Catch basins and inlets, will be measured per each.

Adjustment of manholes, catch basins, and inlets will be per each.

Structure excavation Class B and Structure excavation Class B including haul will be measured by the cubic yard as specified in Section 2-09.

Abandon existing manholes will be measured per each.

Connections to existing drainage Structures will be measured per each.

Shoring or extra excavation will be measured as specified in Section 2-09.4.

Drop manhole connections will be measured per each.

Precast concrete drywell will be measured per each.

7-05.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Manhole ____ In. Diam. Type ____", per each.

"Manhole Additional Height ____ In. Diam. Type ____", per linear foot.

"Catch Basin Type ____", per each.

"Catch Basin Type 2 ____ In. Diam.", per each.

"Grate Inlet Type ____", per each.

"Drop Inlet Type ____", per each.

"Concrete Inlet", per each

All costs associated with furnishing and installing gravel backfill for bedding manholes, inlets and catch basins shall be included in the unit Contract price for the item installed.

"Precast Concrete Drywell", per each.

The unit Contract price per each for "Precast Concrete Drywell" shall be full pay for furnishing and installing the drywell, including all Structure excavation, gravel backfill for drywell, crushed surfacing base course, and drainage geotextile.

"Combination Inlet", per each.

All costs associated with furnishing and installing gravel backfill for bedding manholes, inlets, and catch basins shall be in the unit Contract price for the item installed.

“Adjust Manhole”, per each.

“Adjust Catch Basin”, per each.

“Adjust Inlet, per each.

The unit Contract price per each for “Adjust Manhole”, “Adjust Catch Basin”, or “Adjust Inlet” shall be full pay for all costs necessary to make the adjustment including restoration of adjacent areas in a manner acceptable to the Engineer.

“Structure Excavation Class B”, per cubic yard.

“Structure Excavation Class B Incl. Haul”, per cubic yard.

Structure excavation for concrete inlets is considered incidental to the cost of the inlets and shall be included in the unit Contract price for the concrete inlet.

“Abandon Existing Manhole”, per each.

“Connection to Drainage Structure”, per each.

“Shoring or Extra Excavation Class B”, per square foot.

“Drop Manhole Connection”, per each.

The price paid per drop connection is in addition to the price paid for manholes and for the specified sewer pipe that is replaced with ductile iron pipe.

7-06 Vacant

7-07 Cleaning Existing Drainage Structures

7-07.1 Description

This Work consists of cleaning, removing, and disposing of all debris and obstructions from existing culvert pipes, storm sewer pipes, drains, inlet Structures, manholes, box culverts, grates, trash racks, or other drainage features within the limits of the project.

7-07.2 Vacant

7-07.3 Construction Requirements

All pipes and drainage Structures that require cleaning are identified in the Plans. They shall be cleaned by flushing, rodding, or whatever means are necessary to provide unobstructed drainage. All catch basin sumps, manholes, inlet and outlet Structures, and debris racks shall also be freed of all dirt, rock, and debris. Existing drainage facilities shall be cleaned as a first order of Work to enhance natural drainage off and through the project. They shall be kept clean throughout the life of the project and be clean upon final acceptance of the Work.

Material to be removed shall be disposed of in the following manner:

1. Structures specifically noted in the Contract that are suspected to contain contaminated sediment shall be disposed of at a licensed disposal facility.
2. While performing the Work, if drainage water and/or soil appear oily, exhibit an unusual color or odor, or if staining or corrosion is observed, the Contractor shall stop work and immediately notify the Engineer. Additional work necessary in handling materials shall be in accordance with Section 1-04.4.
3. If sediment and water from structures does not meet the conditions described in 1 or 2 above, material may be placed in an upland area with no possibility of surface runoff to waters of the State, including wetlands.

While performing the Work, the Contractor shall implement all necessary best management practices and measures to meet the conditions of Section 1-07.5.

7-07.4 Vacant

7-07.5 Payment

Payment will be made for the following Bid item when it is included in the Proposal:

“Cleaning Existing Drainage Structure”, lump sum.

The lump sum Contract price for “Cleaning Existing Drainage Structure” shall be full pay for performing all Work as specified. In the event the Contract does not include a Bid item for cleaning existing drainage Structure, such Work, if required, shall be performed by the Contractor in accordance with Section 1-04.4.

7-08 General Pipe Installation Requirements

7-08.1 Description

This Work includes installing culverts, storm sewers, and sanitary sewers. The Contractor shall also follow Section 7-02, 7-04, or 7-17 as it applies to the specific kind of Work.

7-08.2 Materials

Gravel Backfill for Foundations	9-03.12(1)
Gravel Backfill for Pipe Zone Bedding	9-03.12(3)

7-08.3 Construction Requirements

7-08.3(1) Excavation and Preparation of Trench

7-08.3(1)A Trenches

The length of trench excavation in advance of pipe laying shall be kept to a minimum. Excavations shall either be closed up at the end of the day or protected per Section 1-07.23(1).

The trench width shall be as specified in Section 2-09.4 and shall be excavated to the depth and grade as staked by the Engineer.

Trenches must be of sufficient width in the pipe zone to permit proper installation and bedding of the pipe and to provide the required compaction of backfill. Above the top of the pipe zone, the Contractor may excavate to any width.

All ledgerock, boulders, and stones shall be removed to provide a minimum of 6 inches clearance under all portions of the pipe.

Placement of bedding material shall precede the installation of all pipe. This shall include necessary leveling of the native trench bottom or the top of the foundation material as well as placement and compaction of required bedding material to a uniform grade so that the entire length of pipe will be supported on a uniformly dense unyielding foundation.

When, after excavating to the foundation level, the material remaining in the trench bottom is determined to be unsuitable by the Engineer, excavation shall be continued to such additional depth and width as required by the Engineer. Unsuitable foundation materials shall be disposed of at an approved site. The trench foundation shall be backfilled to the bottom of the pipe zone with gravel backfill for foundations, gravel backfill for pipe zone bedding, or other suitable material, and compacted to form a uniformly dense, unyielding foundation.

All material excavated from trenches and piled adjacent to the trench shall be maintained so that the toe of the slope is at least 2 feet from the edge of the trench. It shall be piled to cause a minimum of inconvenience to public travel, and provision shall be made for merging traffic where necessary. Free access shall be provided to all fire hydrants, water valves, and meters; and clearance shall be left to enable free flow of storm water in gutters, conduits, or natural watercourses.

If any part of the excavated material meets the Specifications of Section 9-03.12(3), the Engineer may require that such material, in the quantity required, be selectively removed, stockpiled separately, and used as pipe bedding instead of quantities of gravel backfill for pipe zone bedding. If material so stockpiled becomes contaminated, the Contractor shall furnish suitable material in an amount equal to that lost by contamination at no expense to the Contracting Agency. All costs involved in storing, protecting, re-handling, and placing the material shall be included in other items of Work on the project.

Excavation for manholes and other Structures connected to the pipelines shall be sufficient to provide a minimum of 12 inches between their surfaces and the sides of the excavation.

The Contractor shall furnish, install, and operate all necessary equipment to keep excavations above the foundation level free from water during construction, and shall dewater and dispose of the water so as not to cause injury to public or private property or nuisance to the public. Sufficient pumping equipment in good working condition shall be available at all times for all emergencies, including power outage, and shall have available at all times competent workers for the operation of the pumping equipment.

Where pipe is to be placed in a new embankment, the embankment shall be constructed as shown in the Plans or as designated by the Engineer for a distance each side of the pipe location of not less than five times the diameter and to a minimum height equal to ½ of the outside diameter of the pipe. The embankment material shall be compacted to 95 percent of maximum density and the moisture content at the time of compaction shall be between optimum and 3 percentage points below optimum as determined by the Compaction Control Tests specified in Section 2-03.3(14)D. The trench shall then be excavated to a width as specified in Section 2-09.4, and the pipe installed in accordance with the *Standard Plans*.

7-08.3(1)B Shoring

The Contractor shall provide all materials, labor, and equipment necessary to shore trenches to protect the Work, existing property, utilities, pavement, etc., and to provide safe working conditions in the trench. The Contractor may elect to use any combination of shoring and overbreak, tunneling, boring, sliding trench shield, or other method of accomplishing the Work consistent with applicable local, State, or Federal safety codes.

If workers enter any trench or other excavation 4 feet or more in depth that does not meet the open pit requirements of Section 2-09.3(3)B, it shall be shored. The Contractor alone shall be responsible for worker safety, and the Contracting Agency assumes no responsibility.

Upon completing the Work, the Contractor shall remove all shoring unless the Plans or the Engineer direct otherwise.

Shoring to be removed, or moveable trench shields or boxes, shall be located at least 2½ pipe diameters away from metal or thermoplastic pipe if the bottom of the shoring, shield, or box extends below the top of the pipe, unless a satisfactory means of reconsolidating the bedding or side support material disturbed by shoring removal can be demonstrated.

Damages resulting from improper shoring or failure to shore shall be the sole responsibility of the Contractor.

7-08.3(1)C Bedding the Pipe

Pipe zone bedding material shall provide uniform support along the entire pipe barrel, without load concentration at joint collars or bells. All adjustment to line and grade shall be made by scraping away or filling in with bedding material under the body of the pipe and not by blocking or wedging. Bedding disturbed by pipe movement, or by removal of shoring movement of a trench shield or box, shall be reconsolidated prior to backfill.

Pipe zone bedding shall be as specified in the *Standard Plans* and shall be placed in loose layers and compacted to 90 percent maximum density. Bedding shall be placed, spread, and compacted before the pipe is installed so that the pipe is uniformly supported along the barrel. Lifts of not more than 6 inches in thickness shall be placed and compacted along the sides of the pipe to the height shown in the *Standard Plans*. Material shall be worked carefully under the pipe haunches and then compacted.

If the Engineer determines that the material existing in the bottom of the trench is satisfactory for bedding the pipe, the bedding material specified in the *Standard Plans* is not required, provided the existing material is loosened, regraded, and compacted to form a dense, unyielding base.

7-08.3(2) Laying Pipe

7-08.3(2)A Survey Line and Grade

Survey line and grade control hubs will be placed in a manner consistent with accepted practices.

The Contractor shall transfer line and grade into the trench where they shall be carried by means of a laser beam or taut grade line supported on firmly set batter boards at intervals of not more than 30 feet. Not less than three batter boards shall be in use at one time. Grades shall be constantly checked and in the event the batter boards do not line up, the Work shall be immediately stopped, the Engineer notified, and the cause remedied before proceeding with the Work. Any other procedure shall have the written approval of the Engineer.

7-08.3(2)B Pipe Laying – General

After an accurate grade line has been established, the pipe shall be laid in conformity with the established line and grade in the properly dewatered trench. Mud, silt, gravel, and other foreign material shall be kept out of the pipe and off the jointing surfaces.

All pipe laid in the trench to the specified line and grade shall be kept in longitudinal compression until the backfill has been compacted to the crown of the pipe. All pipe shall be laid to conform to the prescribed line and grade shown in the Plans, within the limits that follow.

Pipe shall be laid to a true line and grade at the invert of the pipe and the Contractor shall exercise care in matching pipe joints for concentricity and compatibility. In no case shall two pipes be joined together with ends having the maximum manufacturer's tolerance. The invert line may vary from the true line and grade within the limits stated to develop uniformity, concentricity, and uniform compression of jointing material provided such variance does not result in a reverse sloping invert. The limit of the variance at the invert shall not exceed plus or minus 0.03 feet at the time of backfill. Checking of the invert elevation of the pipe may be made by calculations from measurements on the top of the pipe.

The pipe, unless otherwise approved by the Engineer, shall be laid up grade from point of connection on the existing pipe or from a designated starting point. The pipe shall be installed with the bell end forward or upgrade. When pipe laying is not in progress, the forward end of the pipe shall be kept tightly closed with an approved temporary plug.

Where pipe joints must be deflected within the manufacturer's recommended limits to accommodate required horizontal or vertical curvature, it shall first be joined in straight alignment and then deflected as required.

Where pipe joints must be deflected to an amount greater than the manufacturer's recommended limits to accommodate required horizontal or vertical curvature, the curves shall be achieved with a series of tangents and shop fabricated bends, subject to the approval of the Engineer.

Upon final acceptance of the Work, all pipe and appurtenances shall be open, clean, and free draining.

7-08.3(2)C Pipe Laying – Concrete

For concrete pipe with elliptical reinforcement, the markings indicating the minor axis of the reinforcement shall be placed in a vertical plane (top or bottom) when the pipe is laid.

7-08.3(2)D Pipe Laying – Steel or Aluminum

Pipe with riveted or resistance spot welded seams shall be laid in the trench with the outside laps of circumferential joints upgrade and with longitudinal laps positioned other than in the invert, and firmly joined together with approved bands.

Aluminum pipe or pipe arch used in cement concrete shall be painted with two coats of paint. The paint shall cover all the surfaces in contact with the cement concrete and extend one inch beyond the point of contact. The aluminum pipe to be painted shall be cleaned with solvent to remove contaminants. After cleaning, the pipe shall be painted with two coats of paint conforming to Federal Specification TT-P-645 (primer, paint, zinc chromate, alkyd vehicle). Aluminized steel pipe will not require painting when placed in Controlled Density Fill (CDF) or when in contact concrete head walls.

All costs of cleaning and painting the aluminum surfaces as specified shall be included in the unit Contract price per linear foot for the aluminum pipe or pipe arch.

7-08.3(2)E Rubber Gasketed Joints

In laying pipe with rubber gaskets, the pipe shall be handled carefully to avoid knocking the gasket out of position or contaminating it with foreign material. Any gasket so disturbed shall be removed, cleaned, relubricated if required, and replaced before joining the sections.

The pipe shall be properly aligned before joints are forced home. Sufficient pressure shall be applied in making the joint to ensure that the joint is home, as defined in the standard installation instructions provided by the pipe manufacturer. The Contractor may use any method acceptable to the Engineer for pulling the pipe together, except that driving or ramming by hand or machinery will not be permitted. Any pipe damaged during joining and joint tightening shall be removed and replaced at no expense to the Contracting Agency.

Care shall be taken to properly align the pipe before joints are entirely forced home. During insertion of the tongue or spigot, the pipe shall be partially supported by hand, sling or crane to minimize unequal lateral pressure on the gasket and to maintain concentricity until the gasket is properly positioned. Since most gasketed joints tend to creep apart when the end of the pipe is deflected and straightened, such movement shall be held to a minimum once the joint is home.

Sufficient restraint shall be applied to the line to ensure that joints once home are held so by compacting backfill material under and alongside the pipe or by other acceptable means. At the end of the work day, the last pipe shall be blocked in such a manner as may be required to prevent creep.

7-08.3(2)F Plugs and Connections

Plugs for pipe branches, stubs, or other open ends which are not to be immediately connected shall be made of an approved material and shall be secured in a place with a joint comparable to the main line joint, or stoppers may be of an integrally cast breakout design.

7-08.3(2)G Jointing of Dissimilar Pipe

Dissimilar pipe shall be jointed by use of a factory-fabricated adapter coupling or a pipe collar as detailed in the *Standard Plans*.

7-08.3(2)H Sewer Line Connections

Storm and sanitary sewer line connections to trunks, mains, laterals, or side sewers shall be left uncovered until after the Engineer has inspected and approved the Work. After approval of the connection, the trench shall be backfilled as specified.

7-08.3(2)I Side Sewer Connections

Where a storm or sanitary side sewer is larger than the trunk, main, or lateral to which it is to be connected, the connection shall be made only at a standard manhole unless otherwise provided in the Plans or in the Special Provisions, or unless otherwise authorized by the Engineer.

7-08.3(3) Backfilling

Placement of pipe zone backfill shall be performed in accordance with these requirements and the *Standard Plans*. Trenches shall be backfilled as soon after the pipe laying as possible.

Pipe zone backfill material shall be clean earth or sand, free from clay, frozen lumps, roots, or moisture in excess of that permitting required compaction. Rocks or lumps larger than 3 inches maximum shall not be used for pipe zone backfill.

Pipe zone backfill shall be placed in loose layers and compacted to 90 percent maximum density. Backfill shall be brought up simultaneously on each side of the pipe to the top of the pipe zone. The pipe shall then be covered to the top of the pipe zone and the materials compacted in a manner to avoid damaging or disturbing the completed pipe.

Backfill above the pipe zone shall be accomplished in such a manner that the pipe will not be shifted out of position nor damaged by impact or overloading. If pipe is being placed in a new embankment, backfill above the pipe zone shall be placed in accordance with Section 2-03.3(14)C. If pipe is being placed under existing paved areas, or Roadways, backfill above the pipe zone shall be placed in horizontal layers no more than 6 inches thick and compacted to 95 percent maximum density. If pipe is being placed in non-traffic areas, backfill above the pipe zone shall be placed in horizontal layers no more than 6 inches thick and shall be compacted to 85 percent maximum density. All compaction shall be in accordance with the Compaction Control Test of Section 2-03.3(14)D, except in the case that 100% Recycled Concrete Aggregate is used. When 100% Recycled

Concrete Aggregate is used, the Contractor may submit a written request to use a test point evaluation for compaction acceptance. Test Point evaluation shall be performed in accordance with SOP 738. Material excavated from the trench shall be used for backfill above the pipe zone, except that organic material, frozen lumps, wood, rocks, or pavement chunks larger than 6 inches in maximum dimension shall not be used. Materials determined by the Engineer to be unsuitable for backfill at the time of excavation shall be removed and replaced with imported backfill material.

Backfilling of trenches in the vicinity of catch basins, manholes, or other appurtenances will not be permitted until the cement in the masonry has become thoroughly hardened.

When it is required that a blanket of select material or bank run gravel is to be placed on top of the native backfill, the backfill shall be placed to the elevations shown in the Plans, or to the elevations specified by the Engineer. Compaction of the native material shall be as required by the Contracting Agency and shall be performed prior to placing the select material. Surface material shall be loosened to whatever depth is required to prevent bridging of the top layer, but shall in no case be less than 18 inches.

The Contractor shall not operate tractors or other heavy equipment over the top of the pipe until the backfill has reached a height of 2 feet above the top of the pipe.

7-08.3(4) Plugging Existing Pipe

Where shown in the Plans or where designated by the Engineer, existing pipes shall be plugged on the inlet end for a distance of 2 diameters with commercial concrete. Care shall be used in placing the concrete in the pipe to see that the opening of the pipe is completely filled and thoroughly plugged.

7-08.4 Measurement

Gravel backfill for foundations, or gravel backfill for pipe zone bedding when used for foundations, shall be measured by the cubic yard, including haul, as specified in Section 2-09.

Plugging pipes will be measured per each, for each plug installed, for pipe diameters up to and including 36 inches. The concrete for plugging pipes in excess of 36 inches in diameter will be measured by the cubic yard. Computations for corrugated metal pipes will be based on the nominal diameter.

Excavation of the trench will be measured as Structure excavation Class B or Structure excavation Class B including haul, by the cubic yard as specified in Section 2-09. When excavation below grade is necessary, excavation will be measured to the limits ordered by the Engineer.

Embankment construction before pipe placement under the applicable provisions of Section 7-08.3(1)A will be measured in accordance with Section 2-03.

Shoring or extra excavation class B will be measured as specified in Section 2-09.4.

7-08.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Gravel Backfill for Foundations Class ____", per cubic yard.

"Gravel Backfill for Pipe Zone Bedding", per cubic yard.

All costs associated with furnishing and installing bedding and backfill material within the pipe zone in the installation of culvert, storm sewer, and sanitary sewer pipes shall be included in the unit Contract price for the type and size of pipe installed.

"Plugging Existing Pipe", per each.

"Commercial Concrete", per cubic yard.

"Structure Excavation Class B", per cubic yard.

"Structure Excavation Class B Incl. Haul", per cubic yard.

"Shoring or Extra Excavation Class B", per square foot.

All costs in jointing dissimilar pipe with a coupling or concrete collar shall be included in the unit Contract price per foot for the size and type of pipe being jointed.

7-09 Water Mains

7-09.1 Description

This Work consists of constructing water mains 16 inches in diameter and smaller in accordance with the Plans, these *Standard Specifications*, the Special Provisions and the *Standard Plans*, at the location shown on the Plans.

7-09.1(1) Definitions

7-09.1(1)A Trench Widths

Trench width is from trench wall to trench wall, outside of shoring.

7-09.1(1)B Unsuitable Material

Material removed because it is unsatisfactory for foundations is defined as unsuitable foundation material.

Material removed in trenching which is unsuitable for replacement in the backfill is defined as unsuitable backfill material.

7-09.1(1)C Gravel Backfill for Pipe Zone Bedding

Gravel backfill for pipe zone bedding is the method or material used to transmit load from the pipe into the foundation or into the sidewall support.

7-09.1(1)D Pipe Zone Backfill

Pipe zone backfill includes material placed above the gravel backfill for pipe zone bedding up to the depths shown on the *Standard Plans*.

7-09.1(1)E Trench Backfill

Trench backfill includes materials placed above the pipe zone backfill. Trench backfill within the Roadway prism shall extend up to the underside of the pavement or surfacing materials. Trench backfill outside the Roadway prism shall extend up to original ground or finished grade.

7-09.2 Materials

Materials shall meet the requirements of the following sections:

Pipe for main line:	9-30.1
Ductile Iron Pipe	9-30.1(1)
Steel Pipe (6 inches and over)	9-30.1(4)A
Polyvinyl Chloride (PVC) Pressure Pipe (4 inches and over)	9-30.1(5)A
Polyvinyl Chloride (PVC) Pressure Pipe (under 4 inches)	9-30.1(5)B
Polyethylene (PE) Pressure Pipe (4 inches and over)	9-30.1(6)
Fittings for Main Lines:	9-30.2
Ductile Iron Pipe	9-30.2(1)
Steel Pipe (6 inches and over)	9-30.2(4)A
Polyvinyl Chloride (PVC) Pipe (4 inches and over)	9-30.2(5)A
Polyvinyl Chloride (PVC) Pipe (under 4 inches)	9-30.2(5)B
Restrained Joints	9-30.2(6)
Bolted, Sleeve-Type Couplings for Plain End Pipe	9-30.2(7)
Restrained Flexible Couplings	9-30.2(8)
Grooved and Shouldered Joints	9-30.2(9)
Polyethylene (PE) Pipe (4 inches and over)	9-30.2(10)
Fabricated Steel Mechanical Slip-Type Expansion Joints	9-30.2(11)
Appurtenances:	
Concrete Blocking	6-02.3(2)B
Detectable Marking Tape	9-15.18
Blow Off Assemblies	9-30.1, 9-30.2, 9-30.3, 9-30.6
Polyethylene Encasement	9-30.1(2)
Steel Pipe (4 inches and under)	9-30.1(4)B
Fittings for Steel Pipe (4 inches and under)	9-30.2(4)B
Aggregates:	
Foundation Material	9-03.17, 9-03.18
Gravel Backfill for Pipe Zone Bedding	9-03.12(3)
Pipe Zone Backfill	9-03.19
Trench Backfill	9-03.15 or 9-03.19

It is not intended that materials listed herein are to be necessarily considered equal or generally interchangeable for all applications. Those suitable for the project shall be specified in the Special Provisions or shown on the Plans.

The pipe manufacturer shall test all pipe and fittings as required by these *Standard Specifications* and the standards referenced. The Contractor shall submit Type 1 Working Drawings consisting of all test results from the pipe manufacturer including a written certification that material to be delivered is represented by the samples tested and that such delivered materials meet or exceed the specified requirements. No pipe shall be delivered until test results and certifications are in the hands of the Engineer.

The Engineer shall have free access to all testing and records pertaining to material to be delivered to the job site. The Engineer may elect to be present at any or all material testing operations.

The basis of acceptance shall be a certificate of compliance as described in Section 1-06.3, accompanied by two copies of pressure test results of the pipe or fittings involved.

7-09.3 Construction Requirements

7-09.3(1) General

Trench excavation required for the installation of water mains and appurtenances shall be unclassified. Material excavated from trenches and piled adjacent to the trench or in a Roadway or public thoroughfare shall be piled and maintained so that the toe of the slope of the spoil material is at least 2 feet from the edge of the trench. It shall be piled in a manner to prevent surface water from flowing into the excavation and in a manner that will cause a minimum of inconvenience to public travel. Free access shall be provided to all fire hydrants, water valves, and meters; and clearance shall be left to enable the free flow of storm water in gutters, conduits, and natural watercourses.

7-09.3(2) Ungraded Streets

On ungraded streets, when grading is not called for in the Contract, the depth of trench excavation shall be as shown on the Plans and as staked.

Where the Plans show the pipe is to be laid above the existing ground surface, an embankment fill shall be made and compacted to conform with the section shown on the Plans, and the water main trench shall be excavated therein. That portion of the embankment below the bottom of the pipe shall be compacted with rollers or mechanical compactors under controlled moisture conditions as required under Method B of Section 2-03.3(14)C.

7-09.3(3) Clearing and Grubbing in Ungraded Streets

On ungraded streets, where clearing and grubbing is not called for in the Contract, the area to be excavated or filled shall be cleared and grubbed by the Contractor. This Work shall consist of the removal and disposal of logs, stumps, roots, brush, and other refuse within 5 feet of the centerline of the pipe. Such material shall be disposed of in accordance with the Special Provisions.

7-09.3(4) Removal of Existing Street Improvements

Removal of existing street improvements and pavement from driveways and sidewalks shall be performed as specified in Section 2-02. Stockpiling of waste materials along the trench shall not be allowed.

7-09.3(5) Grade and Alignment

The location of blow off assemblies and combination air release/air vacuum valves are shown on the Plans.

The Contractor shall verify the locations and establish the depth of the existing water mains at the points where connections are to be made prior to trenching for the pipelines. The profile shall be adjusted so no new high spots or low spots are created between the connection points to the existing water mains.

The depth of trenching for water mains shall be such as to give a minimum cover of 36 inches over the top of the pipe unless otherwise specified in the Special Provisions. Deeper excavation may be required due to localized breaks in grade, or to install the new main under existing culverts or other utilities where necessary. Where the profile of the pipeline and the ground surface is shown on the Plans, the pipeline shall be laid to the elevation shown regardless of depth. The excavation shall be to such depth that the minimum cover over valve operating nuts shall be 1 foot.

7-09.3(6) Existing Utilities

Existing utilities of record, except services, are shown on the Plans. These are shown for convenience only, and the Engineer assumes no responsibility for improper locations or failure to show utility locations on the Plans.

When utility services occupy the same space as the new water main, the Contractor shall complete necessary excavation to fully expose such services. The Contractor shall protect said services, and work around them during excavating and pipe laying operations. Any damages to services resulting from the Contractor's operation shall be reported to the appropriate utility. Such damage shall be repaired at the Contractor's expense.

7-09.3(7) Trench Excavation

The Contractor shall perform excavation of every description and in whatever materials encountered to the depth indicated on the Plans or specified in the Special Provisions. Excavations shall be made by open cut unless otherwise provided for. Trenches shall be excavated to true and smooth bottom grades and in accordance with the lines given by the Engineer or shown on the Plans. The trench bottom shall provide uniform bearing and support for each length of pipe.

Bell holes shall be excavated to the extent necessary to permit accurate Work in making and inspecting the joints. The banks of the trenches shall be kept as nearly vertical as soil conditions will permit, and where required to control trench width or to protect adjacent Structures, the trench shall be sheeted and braced. Trench widths to 1 foot above the top of the pipe shall not exceed 30 inches maximum or 1½ times the outside diameter of the pipe plus 18 inches whichever is greater. Standard excavating equipment shall be adjusted so as to excavate the narrowest trench possible.

The length of trench excavation in advance of pipe laying shall be kept to a minimum. Excavations shall be either closed up at the end of the day or protected per Section 1-07.23(1).

The Contractor shall exercise sound engineering and construction practices in excavating the trench and maintaining the trench so that no damage will occur to any foundation, Structure, pole line, pipe line, or other facility because of slough or slopes, or from any other cause. If, as a result of the excavation, there is disturbance of the ground, which may endanger other property, the Contractor shall immediately take remedial action at no additional expense to the Contracting Agency. No act, representation, or instruction of the Engineer shall in any way relieve the Contractor from liability for damages or costs that result from trench excavation.

Care shall be taken not to excavate below the depth specified. Excavation below that depth shall be backfilled with foundation material and compacted as specified herein.

If workers have to enter any trench or other excavation 4 feet or more in depth that does not meet the open pit requirements of Section 2-09.3(3)B, it shall be shored. The Contractor alone shall be responsible for worker safety, and the Contracting Agency assumes no responsibility.

Upon completing the Work, the Contractor shall remove all shoring unless the Plans or the Engineer direct otherwise.

7-09.3(7)A Dewatering of Trench

Where water is encountered in the trench, it shall be removed during pipe-laying operations and the trench so maintained until the ends of the pipe are sealed and provisions are made to prevent floating of the pipe. Trench water or other deleterious materials shall not be allowed to enter the pipe at any time.

7-09.3(7)B Rock Excavation

Rock excavation shall cover the removal and disposal of rock that requires systematic drilling and blasting for its removal, and also boulders exceeding ½ cubic yard. Ledge rock, boulders, or stones shall be removed to provide a minimum clearance of 4 inches under the pipe.

Hardpan, hard clay, glacial till, sandstone, siltstone, shale, or other sedimentary rocks, which are soft, weathered, or extensively fissured will not be classified as rock excavation. Rock is defined as one that has a modulus of elasticity of more than 200,000 psi or unconfined compressive strength at field moisture content of more than 2,000 psi.

Materials removed shall be replaced with gravel backfill for pipe zone bedding, pipe zone backfill or trench backfill as designated by the Engineer.

7-09.3(7)C Extra Trench Excavation

Changes in grades of the water main from those shown on the Plans, or as provided in the Special Provisions, may be necessary because of unexpected utilities, or for other reasons. If, in the opinion of the Engineer, it is necessary to adjust, correct, relocate, or in any way change the line and grade, such changes shall be made by the Contractor under the terms of these *Standard Specifications*.

When pipeline grade is lowered in excess of 1 foot below the grade indicated on the Plans, the Contractor shall make such extra excavation as necessary.

When the pipeline horizontal alignment is changed by more than 1 foot from the line indicated on the Plans, after the trench has been excavated, the Contractor shall excavate the trench at the changed location and backfill and compact the previous trench.

Additional excavation so required will be classified as extra trench excavation.

7-09.3(8) Removal and Replacement of Unsuitable Materials

Whenever in excavating the trench for water mains, the bottom of the trench exposes peat, soft clay, quicksand, or other unsuitable foundation material, such material shall be removed to the depth directed by the Engineer and backfilled with foundation material. When determined by the Engineer that silty soils or fine sandy soils are encountered, Class C foundation material shall be required. Silty soils or fine sandy soils usually flow in the presence of a stream of water. When determined by the Engineer that clay, peat, or other soft materials are encountered that become saturated with water, but do not break down into fine particles and flow, Class A or Class B foundation material shall be required.

Material removed from the trench that is unsuitable for trench backfill shall be removed and hauled to a waste site. If material is not available within the limits of the project for backfilling the trench, the Contractor shall furnish trench backfill meeting the requirements of Section 9-03.12(3) or 9-03.19 as required.

Unsuitable material shall be loaded directly into trucks and hauled to a waste site obtained by the Contractor. Stockpiling of unsuitable material at the project site shall not be allowed.

7-09.3(9) Bedding the Pipe

Gravel backfill for pipe zone bedding shall be select granular material free from wood waste, organic material, and other extraneous or objectionable materials and shall have a maximum dimension of 1½ inches. Gravel backfill for pipe zone bedding shall be placed to the depths shown in the *Standard Plans*. Gravel backfill for pipe zone bedding shall be rammed and tamped around the pipe to 95 percent of maximum density by approved hand-held tools, so as to provide firm and uniform support for the full length of the pipe, valves, and fittings. Care shall be taken to prevent any damage to the pipe or its protective coating.

7-09.3(10) Backfilling Trenches

Prior to backfilling, form lumber and debris shall be removed from the trench. Sheeting used by the Contractor shall be removed just ahead of the backfilling.

Backfill up to 12 inches over the top of the pipe shall be evenly and carefully placed. Materials capable of damaging the pipe or its coating shall be removed from the backfill material. The remainder of the material shall be placed by dumping into the trench by any method at the option of the Contractor, and shall be compacted as specified hereinafter.

A minimum 3 inch sand cushion shall be placed between the water main and existing pipelines or other conduits when encountered during construction.

7-09.3(11) Compaction of Backfill

Backfill shall be compacted to at least 95 percent of maximum density as specified in Section 2-03.3(14)D.

At locations where paved streets, Roadway Shoulders, driveways, or sidewalks will be constructed or reconstructed over the trench, the backfill shall be spread in layers and be compacted by mechanical tampers. In such cases, the backfill material shall be placed in successive layers not exceeding 6 inches in loose thickness, and each layer shall be compacted with mechanical tampers to the density specified herein. Mechanical tampers shall be of the impact type as approved by the Engineer.

7-09.3(12) General Pipe Installation

Pipe shall be installed in accordance with the manufacturer's printed Specifications and instructions, and to the standards of the AWWA for installing the type of pipe used. The Contractor shall provide tools and equipment, including any special tools required for installing each particular type of pipe used.

Short lengths of pipe supplied by the manufacturer shall be used whenever possible to provide the proper spacing of valves, tees, or special fittings.

7-09.3(13) Handling of Pipe

Pipe shall be handled in a manner that will prevent damage to the pipe, pipe lining, or coating. Pipe and fittings shall be loaded and unloaded using hoists and slings in a manner to avoid shock or damage, and under no circumstances shall they be dropped, skidded, or rolled against other pipe. If any part of the coating or lining is damaged, repair thereof shall be made by the Contractor at no additional expense to the Contracting Agency and in a manner satisfactory to the Engineer. Damaged pipe shall be rejected, and the Contractor shall immediately place damaged pipe apart from the undamaged and shall remove the damaged pipe from the site within 24 hours.

Threaded pipe ends shall be protected by couplings or other means until laid.

Pipe and fittings shall be inspected for defects.

Dirt or other foreign material shall be prevented from entering the pipe or pipe joint during handling or laying operations, and any pipe or fitting that has been installed with dirt or foreign material in it shall be removed, cleaned, and re-laid. At times when pipe laying is not in progress, the open ends of the pipe shall be closed by a watertight plug or by other means approved by the Engineer to ensure cleanliness inside the pipe.

7-09.3(14) Cutting Pipe

Whenever it becomes necessary to cut a length of pipe, the cut shall be made by abrasive saw or by a special pipe cutter. Pipe ends shall be square with the longitudinal axis of the pipe and shall be reamed and otherwise smoothed so that good connections can be made. Threads shall be cleanly cut. Oxyacetylene torch cutting of ductile iron pipe shall not be allowed.

7-09.3(15) Laying of Pipe on Curves

7-09.3(15)A Ductile Iron Pipe

Long radius curves, either horizontal or vertical, may be laid with standard pipe lengths by deflecting the joints. If the pipe is shown curved on the Plans and no special fittings are shown, the Contractor can assume that the curves can be made by deflecting the joints with standard lengths of pipe. If shorter lengths are required, the Plans will indicate maximum lengths that can be used. The amount of deflection at each pipe joint when pipe is laid on a horizontal or vertical curve shall not exceed the manufacturer's printed recommended deflections.

Where field conditions require deflection or curves not anticipated by the Plans, the Engineer will determine the methods to be used. No additional payment will be made for laying pipe on curves as shown on the Plans, or for field changes involving standard lengths of pipe deflected at the joints. When special fittings not shown on the Plans are required to meet field conditions, additional payment will be made for special fittings as provided in Section 1-09.6.

When rubber gasketed pipe is laid on a curve, the pipe shall be jointed in a straight alignment and then deflected to the curved alignment. Trenches shall be made wider on curves for this purpose.

7-09.3(15)B Polyvinyl Chloride (PVC) Pipe (4 inches and Over)

PVC pipe may be bent to allow for slight changes in direction. The minimum bending radius shall be as follows:

Size	Minimum Bending Radius
4 inch	125 feet
6 inch	175 feet
8 inch	225 feet
10 inch	275 feet
12 inch	325 feet
14 inch	400 feet

Axial deflection at the pipe joints shall not be allowed.

For 16-inch diameter pipe, changes in direction may be accomplished by axial deflection of the pipe joint. The maximum axial deflection allowed at each joint is 1 degree. For changes in direction greater than 1 degree per pipe joint, fittings shall be used.

7-09.3(16) Cleaning and Assembling Joint

The pipe ends, couplings, fittings, and appurtenances shall be cleaned to remove oil, grit, or other foreign matter from the joint. Care shall be taken to keep the joint from contacting the ground.

Pipe not furnished with a depth mark shall be marked before assembly to ensure visual observation of the Work.

7-09.3(17) Laying Ductile Iron Pipe With Polyethylene Encasement

Where shown on the Plans, the Contractor shall lay ductile iron pipe with a polyethylene encasement. Pipe and polyethylene encasement shall be installed in accordance with AWWA C105.

7-09.3(18) Coupled Pipe 4 inches in Diameter and Larger

Joints for steel pipe shall be bell and spigot or welded as specified in the Special Provisions.

Component parts of couplings, rings, and bells shall receive a protective coating in the same manner as specified for the steel pipe. Bolts and nuts, exposed edges, and flanges shall, after installation, be covered with coal-tar protective coating conforming to AWWA C203 or other coating approved by the Engineer.

Steel pipe 4 inches and larger for aboveground service shall be coupled with flanges, compression type or grooved type couplings.

Pipe for outdoor service above ground shall be protected with a coal-tar protective coating conforming to AWWA C203 or other coating approved by the Engineer.

7-09.3(19) Connections

7-09.3(19)A Connections to Existing Mains

Connections to the existing water main shall not be made without first making the necessary scheduling arrangements with the Engineer in advance. Work shall not be started until all the materials, equipment, and labor necessary to properly complete the Work are assembled on the site.

Existing water mains shall be cut by the Contractor unless otherwise specified in the Special Provisions. The Contractor shall remove the portions of pipe to provide for the installation of the required fittings at the points of connection. Damage caused by the Contractor's operations to existing joints in piping to remain in-service shall be repaired by the Contractor at no additional expense to the Contracting Agency. The Contractor shall determine the exact length of the existing water main that must be removed. The pipe ends shall be beveled to prevent damage to the transition coupling gasket during installation of the coupling. The exterior of the existing pipe end shall be cleaned to a sound, smooth finish before installation of the coupling.

Transition couplings shall be installed by the Contractor and shall be provided with a plastic film wrap. The plastic film wrap shall be wrapped loosely around the pipe, fittings, and couplings, and secured with 2-inch-wide polyethylene adhesive tape. Pipelines in which the couplings are installed shall be wrapped a minimum of 3 feet on each side of the coupling. Joints or seams in the plastic film wrap shall be made using the 2-inch-wide polyethylene adhesive tape. The plastic film wrap need not be watertight, but no part of the pipe or coupling shall be exposed to the backfill. Care shall be exercised during backfilling to prevent the plastic film wrap from being punctured or otherwise damaged. Plastic film wrap and its installation shall conform to AWWA C105 except as modified herein.

Once Work is started on a connection, it shall proceed continuously without interruption and as rapidly as possible until completed. No shutoff of mains will be permitted overnight, over weekends, or on holidays.

If the connection to the existing system involves turning off the water, the Contractor shall be responsible for notifying the residents affected by the shutoff. The Engineer will advise which property owners are to be notified.

The Contractor may be required to perform the connection during times other than normal working hours. The Contractor shall not operate any valves on the existing system without specific permission of the Engineer.

The types of connections are varied and suggested piping arrangements have been shown on the Plans. For the installation of these connections, the surfaced portion of the Roadway shall not be penetrated unless the connecting point is directly under it. For connection by any other method, the Contractor shall furnish a detailed sketch for approval not less than 2 weeks prior to the expected construction.

7-09.3(19)B Maintaining Service

Where existing services are to be transferred from old to new mains, the Contractor shall plan and coordinate its Work with that of the Utility so that service will be resumed with the least possible inconvenience to customers.

To supply customers with water during the construction of a water main project where any section of the pipe has passed satisfactory hydrostatic and bacteriological tests, the Utility reserves the right to tap corporation stops into the section of new pipe and install service connections at such locations as the Utility may elect. The installation of any such service connections by the Utility shall not be construed by the Contractor as an acceptance by the Contracting Agency of any part of the Work required under the Contract.

7-09.3(20) Detectable Marking Tape

Detectable marking tape shall be installed over nonmetallic water lines including services lines. The tape shall be placed approximately 1 foot above the top of the line and shall extend its full length. Detectable marking tape shall meet the requirements of Section 9-15.18.

7-09.3(21) Concrete Thrust Blocking

Concrete thrust blocking, as detailed on the Plans, shall be placed at bends, tees, dead ends, and crosses. Blocking shall be commercial concrete meeting the requirement of Section 6-02.3(2)B poured in place.

Concrete blocking shall bear against solid undisturbed earth at the sides and bottom of the trench excavation and shall be shaped so as not to obstruct access to the joints of the pipe or fittings.

7-09.3(22) Blowoff Assemblies

Blowoff Assemblies shall be constructed at the locations shown on the Plans and in accordance with the *Standard Plans*.

7-09.3(23) Hydrostatic Pressure Test

Water main appurtenances and service connections to the meter setter shall be tested in sections of convenient length under a hydrostatic pressure equal to 150 psi in excess of that under which they will operate or in no case shall the test pressure be less than 225 psi. Pumps, gauges, plugs, saddles, corporation stops, miscellaneous hose and piping, and measuring equipment necessary for performing the test shall be furnished and operated by the Contractor.

Sections to be tested shall normally be limited to 1,500 feet. The Engineer may require that the first section of pipe, not less than 1,000 feet in length, installed by each of the Contractor's crews, be tested in order to qualify the crew and the materials. Pipe laying shall not be continued more than an additional 1,000 feet until the first section has been tested successfully.

The pipeline shall be backfilled sufficiently to prevent movement of the pipe under pressure. Thrust blocks shall be in place and time allowed for the concrete to cure before testing. Where permanent blocking is not required, the Contractor shall furnish and install temporary blocking and remove it after testing.

The mains shall be filled with water and allowed to stand under pressure a sufficient length of time to allow the escape of air and allow the lining of the pipe to absorb water. The Contracting Agency will furnish the water necessary to fill the pipelines for testing purposes at a time of day when sufficient quantities of water are available for normal system operation.

The test shall be accomplished by pumping the main up to the required pressure, stopping the pump for 15 minutes, and then pumping the main up to the test pressure again. During the test, the section being tested shall be observed to detect any visible leakage.

A clean container shall be used for holding water for pumping up pressure on the main being tested. This makeup water shall be sterilized by the addition of chlorine to a concentration of 50 mg/l.

The quantity of water required to restore the pressure shall be accurately determined by pumping through a positive displacement water meter. The meter shall be approved by the Engineer. Acceptability of the test will be determined as follows:

$$L = \frac{SD\sqrt{P}}{266{,}400}$$

The quantity of water lost from the main shall not exceed the number of gallons per hour as determined by the formula:

Where:

L	=	allowable leakage, gallons/hour
D	=	nominal diameter of the pipe in inches
P	=	test pressure during the leakage test (psi)
S	=	gross length of pipe tested, feet

There shall not be an appreciable or abrupt loss in pressure during the 15-minute test period.

Pressure gauges used in the test shall be accompanied with certifications of accuracy from a testing Laboratory approved by the Engineer.

Any visible leakage detected shall be corrected by the Contractor regardless of the allowable leakage specified above. Should the tested section fail to meet the pressure test successfully as specified, the Contractor shall, at no additional expense to the Contracting Agency, locate and repair the defects and then retest the pipeline.

Tests shall be made with the hydrant auxiliary gate valves open and pressure against the hydrant valve. Each valve shall be tested by closing each in turn and relieving the pressure beyond. This test of the valve will be acceptable if there is no immediate loss of pressure on the gauge when the pressure comes against the valve being checked. The Contractor

shall verify that the pressure differential across the valve does not exceed the rated working pressure of the valve.

Prior to calling out the Engineer to witness the pressure test, the Contractor shall have all equipment set up completely ready for operation and shall have successfully performed the test to ensure that the pipe is in satisfactory condition.

Defective materials or workmanship, discovered as a result of hydrostatic field test, shall be replaced by the Contractor at no additional expense to the Contracting Agency. Whenever it is necessary to replace defective material or correct the workmanship, the hydrostatic test shall be re-run at the Contractor's expense until a satisfactory test is obtained.

7-09.3(23)A Testing Extensions From Existing Mains

When an existing water main is extended with new pipe to a new valve and the distance from the existing pipe to the new valve is 18 feet or less, the section of new pipe installed between the new valve and the end of the existing main shall be made with pretested, prechlorinated pipe, and no hydrostatic test will be required. When the required hydrostatic tests are conducted in the new main section beyond the installed new valve in the closed position, the normal pressure of the existing main may be present against the other side of the new valve.

Where the distance between the end of an existing water main pipe extension to the new valve is more than 18 feet, the connection of the new pipe to existing pipe shall not be made until after hydrostatic tests have been made to the required pressure in both directions against the new valve. This shall be accomplished by a temporary cap or plug installed on the end of the new pipe, beyond the new valve, as close as possible to the existing pipe for testing purposes.

The short length of pipe between the temporary cap or plug end with the new valve in the closed position, with no hydrostatic pressure active on the opposite side of the valve, shall be subjected to the required test pressure. The same test shall be made against the other side of the new valve when that section of pipe is tested with no hydrostatic pressure active in the short section of pipe toward the existing main. The final connection to the existing main shall be made with pretested prechlorinated pipe.

7-09.3(23)B Testing Section With Hydrants Installed

When hydrants are included with the section of main pipe to be tested, the testing shall be conducted in three separate tests as follows:

Test No. 1 – Water main gate valves and hydrant auxiliary gate valves closed, with the hydrant operating stem valves and hose ports wide open.

Test No. 2 – Water main gate valves and the hydrant operating the stem valves tightly closed but the hydrant auxiliary gate valves and hose ports wide open.

Test No. 3 – Each hydrant shall be tested to the pressure indicated in Section 7-09.3(23) with the hydrant auxiliary gate valve and hose ports closed and the hydrant operating stem valve wide open.

7-09.3(23)C Testing Hydrants Installed on Existing Mains

For hydrants installed and connected to an existing main, the hydrant connection including hydrant tee, connection pipe, and auxiliary gate valves, shall be installed with pretested materials.

Before the hydrant connection is made to the existing main, the hydrant installation shall be subjected to the hydrostatic Test No. 3 as specified in Section 7-09.3(23)B. Hydrants installed and connected to an existing main shall have a satisfactory bacteriological sample obtained following the hydrostatic test.

7-09.3(24) Disinfection of Water Mains

Before being placed into service, new water mains and repaired portions of, or extensions to, existing mains shall be chlorinated and a satisfactory bacteriological report obtained. In the event two unsatisfactory bacteriological reports are obtained on a section of pipe, the Contractor shall revise his method of disinfection and the form of applied chlorine.

7-09.3(24)A Flushing

Sections of pipe to be disinfected shall first be flushed to remove any solids or contaminated material that may have become lodged in the pipe. If a hydrant is not installed at the end of the main, then a tap shall be provided large enough to develop a flow velocity of at least 2.5 fps in the water main.

Taps required by the Contractor for temporary or permanent release of air, chlorination or flushing purposes shall be provided by the Contractor as part of the construction of water mains.

Where dry calcium hypochlorite is used for disinfection of the pipe, flushing shall be done after disinfection.

The Contractor shall be responsible for disposal of treated water flushed from mains and shall neutralize the wastewater for protection of aquatic life in the receiving water before disposal into any natural drainage channel, i.e., receiving water, waters of the State, including wetlands. The Contractor shall be responsible for disposing of disinfecting solution to the satisfaction of the Contracting Agency and local authorities. At a minimum, chlorinated water shall be dechlorinated to a concentration of 0.1 parts per million (ppm) or less, and pH adjustment to within 6.5 – 8.5 standard units before discharging to surface waters of the State or to a storm sewer system that drains to surface waters of the State.

If approved by the Engineer and by the local authority responsible for the sanitary sewer system, disposal of treated water from mains may be made to an available sanitary sewer, provided the rate of disposal will not overload the sewer.

7-09.3(24)B Requirement of Chlorine

Before being placed into service, new mains and repaired portions of, or extensions to, existing mains shall be chlorinated so that a chlorine residual of not less than 25 mg/l remains in the water after standing 24 hours in the pipe. The initial chlorine content of the water shall be not less than 50 mg/l.

7-09.3(24)C Form of Applied Chlorine

Chlorine shall be applied by one of the methods which follow, to give a dosage of not less than 50 mg/l of available chlorine.

7-09.3(24)D Dry Calcium Hypochlorite

As each length of pipe is laid, sufficient high-test calcium hypochlorite (65 to 70 percent chlorine) shall be placed inside the pipe to yield a dosage of not less than 50 mg/l available chlorine, calculated on the volume of the water that the pipe and appurtenances will contain.

The number of grams of 70 percent test calcium hypochlorite required for a 20-foot length of pipe equals

$0.238 \times d^2$, in which “d” is the diameter in inches.

7-09.3(24)E Liquid Chlorine

A chlorine gas-water mixture shall be applied by means of a solution-feed chlorinating device, or the dry gas may be fed directly through proper devices for regulating the rate of flow and providing effective diffusion of the gas into the water within the pipe being treated. Chlorinating devices for feeding solutions of the chlorine gas, or the gas itself, must provide means for preventing the backflow of water into the chlorine.

7-09.3(24)F Chlorine-Bearing Compounds in Water

A mixture of water and high-test calcium hypochlorite (65 to 70 percent Cl) may be substituted for the chlorine gas-water mixture. The dry powder shall first be mixed as a paste and then thinned to a 1 percent chlorine solution by adding water to give a total quantity of 7.5 gallons of water per pound of dry powder. This solution shall be injected in one end of the section of main to be disinfected while filling the main with water.

7-09.3(24)G Sodium Hypochlorite

Sodium hypochlorite, commercial grade (12.5 percent Cl) or in the form of liquid household bleach (5 to 6 percent Cl), may be substituted for the chlorine gas-water mixture. This liquid chlorine compound may be used full strength or diluted with water and injected into the main in correct proportion to the fill water so that dosage applied to the water will be at least 50 mg/l.

7-09.3(24)H Point of Application

The point of application of the chlorinating agent shall be at the beginning of the pipeline extension or any valved section of it, and through a corporation stop inserted in the horizontal axis of the pipe. The water injector for delivering the chlorine-bearing water into the pipe should be supplied from a tap on the pressure side of the gate valve controlling the flow into the pipeline extension. Alternate points of applications may be used when approved by the Engineer.

7-09.3(24)I Rate of Application

Water from the existing distribution system, or other source of supply, shall be controlled to flow very slowly into the newly-laid pipeline during application of the chlorine. The rate of chlorine gas-water mixture or dry gas feed shall be in such proportion to the rate of water entering the newly-laid pipe that the dosage applied to the water will be at least 50 mg/l.

7-09.3(24)J Preventing Reverse Flow

No connections shall be made between the existing distribution system and pipelines not disinfected that are constructed under this Contract without a State Department of Health approved backflow preventer installed in the connecting line.

7-09.3(24)K Retention Period

Treated water shall be retained in the pipe at least 24 hours. After this period, the chlorine residual at pipe extremities and at other representative points shall be at least 25 mg/l.

7-09.3(24)L Chlorinating Valves, Hydrants, and Appurtenances

In the process of chlorinating newly laid pipe, valves, hydrants, and other appurtenances shall be operated while the pipeline is filled with the chlorinating agent and under normal operating pressure.

7-09.3(24)M Chlorinating Connections to Existing Water Mains and Water Service Connections

The chlorinating procedure to be followed shall be as specified in AWWA Standard C651. All closure fittings shall be swabbed with a very strong chlorine solution at least as strong as liquid household bleach (5 to 6 percent Cl).

7-09.3(24)N Final Flushing and Testing

Following chlorination, treated water shall be flushed from the newly-laid pipe until the replacement water throughout its length shows, upon test, the absence of chlorine. In the event chlorine is normally used in the source of supply, then the tests shall show a residual not in excess of that carried in the water supply system.

A sample tap shall be located ahead of the flushing hose for convenience and for sanitary sampling.

Before placing the lines into service, a satisfactory report shall be received from the local or State Health Department on samples collected from representative points in the new system. Samples will be collected and bacteriological tests obtained by the Engineer.

At a minimum, chlorinated water shall be dechlorinated to a concentration of 0.1 parts per million (ppm) or less, and pH adjustment to within 6.5 to 8.5 standard units, if necessary, before discharging to surface waters of the State or to a storm sewer system that drains to surface waters of the State.

7-09.3(24)O Repetition of Flushing and Testing

Should the initial treatment result in an unsatisfactory bacteriological test, the original chlorination procedure shall be repeated by the Contractor until satisfactory results are obtained. Failure to get a satisfactory test shall be considered as failure of the Contractor to keep the pipe clean during construction, or to properly chlorinate the main.

7-09.4 Measurement

Measurement for payment of pipe for water mains will be by the linear foot of pipe laid and tested and shall be measured along the pipe through fittings, valves, and couplings.

Measurement for payment of blowoff assembly will be per each.

When listed as a pay item, rock excavation will be measured in its original position by volume in cubic yards. The quantity measured for payment will include only the material excavated from within the limits hereinafter defined. Any additional excavation outside of these limits will be considered as having been made for the Contractor's benefit, and all costs in connection with such excavation shall be included in the unit Contract prices for the various items of Work.

The horizontal limits for measuring rock excavation will be the sides of the trench, except no payment will be made for material removed outside of vertical planes extended beyond the maximum trench widths, as specified in Section 7-09.3(7). Vertical distances shall be measured from the upper surface of the rock to an elevation 6 inches below the underside of the pipe barrel, or to the lower surface of the rock, whichever is less. Boulders exceeding 1 cubic yard in volume shall be paid for according to their measured volume.

Removal of the extra trench excavation as defined in Section 7-09.3(7)C will be measured by the cubic yard. The depth shall be the actual depth removed for the changed line or grade in accordance with Section 7-09.3(5) or as ordered by the Engineer in accordance with Section 1-04.4. The width shall be the actual width removed for the changed line or grade, but in no case shall the measured width exceed the allowable widths specified in Section 7-09.3(7).

Removal and replacement of unsuitable material will be measured by the cubic yard. The depth shall be the actual depth removed below the depth specified in Section 7-09.3(5). The width shall be the actual width removed, but in no case shall the measured width exceed the allowable widths specified in Section 7-09.3(7).

Measurement of bank run gravel for trench backfill will be by the cubic yard measured in trucks at the point of delivery.

Shoring or extra trench excavation will be measured as specified in Section 2-09.4 for shoring or extra excavation Class B.

7-09.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"_____Pipe for Water Main_____ In. Diam.", per linear foot.

The unit Contract price per linear foot for each size and kind of "_____ Pipe for Water Main _____ In. Diam." shall be full pay for all Work to complete the installation of the water main, including but not limited to, trench excavation, bedding, laying and jointing pipe and fittings, backfilling, concrete thrust blocking, testing, disinfecting the pipeline, flushing, dechlorination of water used for flushing, and cleanup.

Payment for restoration will be made under the applicable items shown in the Proposal. If no pay items for restoration are included in the Proposal, restoration shall be considered incidental to the Work of constructing the water main, and all costs thereof shall be included in the unit Contract price Bid for "_____ Pipe for Water Main ____ In. Diam."

"Rock Excavation", per cubic yard.

If no pay item is listed, rock excavation shall be considered incidental to the Work to construct the water main and all costs shall be included in other items of Work specified in Section 7-09.5.

"Extra Trench Excavation", per cubic yard.

"Removal and Replacement of Unsuitable Material", per cubic yard.

"Bank Run Gravel for Trench Backfill", per cubic yard.

No separate payment will be made for clearing and grubbing, removal of existing street improvements, furnishing and installing sand cushion, protection of existing utilities and services, trench excavation and backfill, bedding the pipe, and compacting the backfill. These items shall all be considered as incidental to the Work of constructing the water main, and all costs thereof shall be included in the payment as specified in Section 7-09.5.

"Shoring or Extra Excavation Trench", per square foot.

"Blowoff Assembly", per each.

The unit Contract price Bid per each for "Blowoff Assembly" shall be full pay for all Work to install the blowoff assembly, including but not limited to excavating, backfilling, laying and jointing pipe, tapping the main, corporation stop, pipe and fittings, gate valve, meter box, and cover and cleanup.

7-10 Vacant

7-11 Vacant

7-12 Valves for Water Mains

7-12.1 Description

Valves for water mains shall be suitable for ordinary waterworks service, intended to be installed in a normal position on buried pipelines for water distribution systems.

Valves shall open counterclockwise and shall be equipped with a 2-inch-square AWWA standard operating nut. Unless otherwise specified, all valves shall be the nonrising stem type.

7-12.2 Materials

Materials shall meet the requirements of the following sections:

Gate Valves (3 to 16 inches)	9-30.3(1)
Butterfly Valves	9-30.3(3)
Valve Boxes	9-30.3(4)
Valve Marker Posts	9-30.3(5)
Combination Air Release/Air Vacuum Valves	9-30.3(7)
End Connections	9-30.5(1)
Tapping Sleeve and Valve Assembly	9-30.3(8)

The valves shall be standard pattern of a manufacturer whose products are approved by the Engineer and shall have the name or mark of the manufacturer, year valve casting was made, size and working pressure plainly cast in raised letters on the valve body.

The valve bodies shall be cast iron, ductile iron, or other approved material mounted with approved noncorrosive metals. All wearing surfaces shall be bronze or other approved noncorrosive material, and there shall be no moving bearing or contact surfaces of iron in contact with iron. Contact surfaces shall be machined and finished in the best workmanlike manner, and all wearing surfaces shall be easily renewable.

7-12.3 Construction Requirements

All valves shall be inspected upon delivery in the field to ensure proper working order before installation. They shall be set and jointed to the pipe in the manner as set forth in the AWWA Standards for the type of connecting ends furnished. The valves shall also be carefully inspected for injury to the outer protective coatings. At all places where the coating has been ruptured or scraped off, the damaged area shall be cleaned to expose the iron base installation, and the cleaned area shall then be recoated with two or more field coats of approved protective coating.

Upon delivery at the work site, all valves shall be opened to prevent the collection of water in the valve. Valves shall have the interiors cleaned of all foreign matter and shall be inspected both in open and closed position prior to installation. Valves and valve boxes shall be set plumb and valve boxes shall be placed over the valve or valve operator in a manner that the valve box does not transmit shock or stress to the valve. The lower casting of the unit is installed first, in a manner as to be supported by a minimum backfill

or by a Styrofoam collar not less than 2 inches in thickness. The casting shall not rest directly upon the body of the valve or upon the water main. Backfill shall be carefully tamped around the valve box to a distance of 3 feet on all sides or to the undisturbed face of the trench if it is closer. The cast iron valve box cover shall be set flush with the Roadbed or finished paved surface.

The combination air release/air vacuum valves shall be installed as shown in the Plans. All piping shall be sloped to permit escape of any entrapped air. Backfilling and compaction shall be as specified in Section 7-09.

After installation, all valves shall be subjected to field testing and disinfected as outlined in Section 7-09. Should any defects in design, materials, or workmanship appear during these tests, the Contractor shall correct such defects with the least possible delay and to the satisfaction of the Engineer.

7-12.3(1) Installation of Valve Marker Post

Where required, a valve marker post shall be furnished and installed with each valve. Valve marker posts shall be placed at the edge of the Right of Way opposite the valve and be set with 18 inches of the post exposed above grade. The exposed portion of the valve marker posts shall be painted with two coats of concrete paint in a color selected by the Engineer, and then the size of the valve and the distance in feet and inches to the valve shall be stenciled with black paint on the face of the post, using a stencil which will produce letters 2 inches high.

7-12.4 Measurement

Measurement of valves shall be per each for each type and size actually installed.

7-12.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Gate Valve ____ In.", per each.

"Butterfly Valve ____ In.", per each.

"Comb. Air Release/Air Vacuum Valve Assembly ____ In.", per each.

"Tapping Sleeve and Valve Assembly ____ In.", per each.

The unit Contract price per each for the valve specified shall be full pay for all Work to furnish and install the valve complete in place on the water main, including trenching, jointing, blocking of valve, painting, disinfecting, hydrostatic testing, valve box, and marker post.

7-13 Vacant

7-14 Hydrants

7-14.1 Description

This Section covers the installation of dry barrel fire hydrants intended for ordinary water works service.

7-14.2 Materials

Materials shall meet the requirements of the following sections:

Hydrants	9-30.5
End Connections	9-30.5(1)
Hydrant Dimensions	9-30.5(2)
Hydrant Extensions	9-30.5(3)
Hydrant Restraint	9-30.5(4)
Traffic Flange	9-30.5(5)
Guard Posts	9-30.5(6)

7-14.3 Construction Requirements

7-14.3(1) Setting Hydrants

Where shown in the Plans, hydrants shall be installed in accordance with the *Standard Plans*. In addition, a minimum 3-foot radius unobstructed working area shall be provided around all hydrants. The sidewalk flange shall be set 2 inches above finished grade.

All hydrants shall be set on concrete blocks as shown in the *Standard Plans*. The hydrant barrel drain shall waste into a pit of porous gravel material situated at the base of the hydrant as shown in the *Standard Plans*.

All hydrants shall be inspected upon delivery in the field to ensure proper working order. After installation, fire hydrants, auxiliary gate valves, and other appurtenances thereto shall be subjected to a hydrostatic test and disinfection procedures as specified in Section 7-09.

After all installation and testing is complete, the exposed portion of the hydrant shall be painted with one field coat. The type and color of paint will be designated by the Engineer.

Any hydrant not in service shall be identified by covering with a burlap or plastic bag properly secured.

7-14.3(2) Hydrant Connections

Hydrant laterals shall consist of one continuous section of 6-inch ductile iron pipe from the main to the hydrant and shall include an auxiliary gate valve set vertically and placed in accordance with the *Standard Plans*.

7-14.3(2)A Hydrant Restraints

The thrust created in the hydrant lateral shall be restrained as shown in the *Standard Plans*. If applicable, shackle rods, after installation, shall be cleaned and painted with two coats of asphalt varnish, or with such other bituminous coating as may be approved by the Engineer.

7-14.3(2)B Auxiliary Gate Valves and Valve Boxes

Auxiliary gate valves and valve boxes shall be installed in accordance with Section 7-12 except that the end connections shall be provided with lugs for shackling, or the bells shall provide sufficient clearance between the body of the valve and the hub to permit the installation of shackles.

7-14.3(2)C Hydrant Guard Posts

Hydrant guard posts shall be constructed at the locations shown in the Plans. The exposed portion of each guard post shall be painted with one coating of the type and color designated by the Engineer.

7-14.3(3) Resetting Existing Hydrants

Where existing hydrants are shown in the Plans for adjustments to conform to a new street alignment or grade or both, the hydrant shall be relocated without disturbing the location of the hydrant lateral tee at the main.

The method for thrust restraint for the hydrant lateral shall be determined by the conditions found in the field and shall be constructed as ordered by the Engineer at no additional cost to the Contracting Agency.

This Work shall conform to Section 7-14.3(1).

7-14.3(4) Moving Existing Hydrants

Existing hydrants shall be moved where shown in the Plans. When the existing hydrant lateral tee does not accommodate a new hydrant location, a new hydrant lateral tee shall be installed in the main. The existing hydrant lateral tee shall be removed from the main (if said main is to remain active), and a new section of pipe inserted into the water main in place of the existing hydrant lateral tee. Where the existing main to which the existing hydrant lateral tee is connected, and is to be abandoned or temporarily activated after the existing hydrant is moved, the open end of the hydrant lateral pipeline shall be plugged (and temporary thrust restrain provided if temporarily reactivated). All Work shall meet the requirements of Section 7-14.3(1).

7-14.3(5) Reconnecting Existing Hydrants

Existing hydrants shall be reconnected where shown in the Plans. The location and elevation of the existing hydrant shall remain unchanged, but the existing hydrant connection is changed to connect with a new hydrant tee provided in a new main.

Where existing hydrants were not shackled to the old main, the new connection shall be shackled with steel rods as shown in the *Standard Plans*, or by such other shackling method as approved by the Engineer.

Hydrant reconnections shall meet the requirements of Sections 7-14.3(1) and 7-14.3(2).

7-14.3(6) Hydrant Extensions

The Contractor shall furnish and install hydrant extensions where required. The hydrant extensions, operating stems for the hydrant main valves, and sidewalk flanges shall conform to AWWA C502. After installation, the extended fire hydrant shall be subjected to a hydrostatic pressure test and disinfection procedure as specified in Section 7-09.

7-14.4 Measurement

Measurement of hydrant assembly, resetting existing hydrants, moving existing hydrants, and reconnecting existing hydrants will be made per each. Measurement of hydrant extension will be made per linear foot.

7-14.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Hydrant Assembly", per each.

The unit Contract price per each for "Hydrant Assembly" shall be full pay for all Work to furnish and install fire hydrant assemblies, including all costs for auxiliary gate valve, shackles, tie rods, concrete blocks, gravel, and painting required for the complete installation of the hydrant assembly as specified, except the pipe connecting the hydrant to the main and the hydrant lateral tee will be paid for as specified in Section 7-09.5.

"Resetting Existing Hydrant", per each.

The unit Contract price per each for "Resetting Existing Hydrant" shall be full pay for all Work to reset the existing hydrant, including shackling, painting, and reconnecting to the main. New pipe required from the main to the hydrant will be paid as specified in Section 7-09.5.

"Moving Existing Hydrant", per each.

The unit Contract price per each for "Moving Existing Hydrant" shall be full pay for all Work to move the existing hydrant, including new hydrant lateral tee, shackling, painting, and reconnecting to the main. New pipe for hydrant connections will be paid for as specified in Section 7-09.5.

"Reconnecting Existing Hydrant", per each.

The unit Contract price per each for "Reconnecting Existing Hydrant" shall be full pay for all Work to reconnect the existing hydrant, excepting however, that new pipe used for the connection will be paid as specified in Section 7-09.5.

"Hydrant Extension", per linear foot.

The unit Contract price per linear foot for "Hydrant Extension" shall be full pay for all Work to extend the hydrant vertically.

7-15 Service Connections

7-15.1 Description

This Work consists of installing 2 inch and smaller service connections from the main to and including the meter setter for the premises served. Service connections larger than 2 inches shall be installed as detailed on the Plans or as described in the Special Provisions.

7-15.2 Materials

Materials shall meet the requirements of the following sections:

Saddles	9-30.6(1)
Corporation Stops	9-30.6(2)
Service Pipe	9-30.6(3)
Service Fittings	9-30.6(4)
Meter Setters	9-30.6(5)
Bronze Nipples and Fittings	9-30.6(6)
Meter Boxes	9-30.6(7)

7-15.3 Construction Requirements

All service connections to water mains, except to ductile iron pipe Class 52 or stronger, shall be made using saddles as specified and be of the size and type suitable for use with the pipe being installed. Ductile iron pipe Class 52 or stronger may be direct tapped for corporation stops in accordance with the recommendations of DIPRA; unless direct taps are prohibited by the Special Provisions. Service pipelines shall be installed perpendicular to the main, unless shown otherwise in the Plans.

The depth of trenching for service connection piping shall provide a minimum of 3 feet of cover over the top of the pipe. Particular care shall be exercised to ensure that the main is not damaged by the Work undertaken to install the service. Excavating and backfilling for service connections shall be as specified in Section 7-09, except that the service pipeline shall be installed under pavement, curbs, and sidewalks by boring methods approved by the governmental agency having jurisdiction over the Roadway.

Service pipes shall be cut using a tool or tools specifically designed to leave a smooth, even, and square end on the piping material to be cut. Cut ends shall be reamed to the full inside diameter of the pipe. Pipe ends to be connected using couplings which seal to the outside surface of the pipe shall be cleaned to a sound, smooth finish before the couplings are installed. The meter box shall be adjusted to the finished grade after the surface has been acceptably restored.

Where shown in the Plans, existing service connections shall be reconnected to the new mains. The location of existing service connections shall be verified in the field by the Contractor. The Contractor shall notify affected customers of the service interruption at least 24 hours prior to service interruption.

Pipe materials used to extend or replace existing service connections beyond the meter box shall be copper or polyethylene pipe. Insulating couplings shall be used at any connection between galvanized steel or iron pipe and copper pipe. All fittings, appurtenances, and other miscellaneous materials on the sections of existing pipe that have been removed shall become the property of the Contractor.

7-15.3(1) Flushing and Disinfection

All service pipe and appurtenances shall be prechlorinated prior to installation. After installation, the service connection shall be flushed prior to connecting the meter.

7-15.4 Measurement

Service connections will be measured per each for each size of service connection installed.

7-15.5 Payment

Payment will be made for the following Bid item when it is included in the Proposal:

"Service Connection ____ In. Diam.", per each.

The unit Contract price per each for "Service Connection ____ In. Diam." shall be full pay for all Work to install the service connection, including but not limited to, excavating, tapping the main, laying and jointing the pipe and fittings and appurtenances, backfilling, testing, flushing, and disinfection of the service connection.

7-16 Vacant

7-17 Sanitary Sewers

7-17.1 Description

This Work consists of constructing sanitary sewer lines in accordance with the Plans, these Specifications, and the *Standard Plans*, as staked.

7-17.2 Materials

Pipe used for sanitary sewers may be:

Rigid	Thermoplastic
Concrete	ABS Composite
Vitrified Clay	PVC (Polyvinyl Chloride)
Ductile Iron	Polypropylene

All sanitary sewer pipe shall have flexible gasketed joints unless otherwise specified.

It is not intended that materials listed are to be considered equal or generally interchangeable for all applications. The Engineer shall determine from the materials listed those suitable for the project, and shall so specify in the Specifications or the Plans.

Materials shall meet the requirements of the following sections.

Plain Concrete Storm Sewer Pipe	9-05.7(1)
Reinforced Concrete Storm Sewer Pipe	9-05.7(2)
Vitrified Clay Sewer Pipe	9-05.8
Solid Wall PVC Sanitary Sewer Pipe	9-05.12(1)
Profile Wall PVC Sanitary Sewer Pipe	9-05.12(2)
Ductile Iron Sewer Pipe	9-05.13
ABS Composite Sewer Pipe	9-05.14
Polypropylene Sewer Pipe	9-05.24

All pipe shall be clearly marked with type, class, and thickness. Lettering shall be legible and permanent under normal conditions of handling and storage.

7-17.3 Construction Requirements

Sanitary sewers shall be constructed in accordance with Section 7-08.3.

7-17.3(1) Protection of Existing Sewerage Facilities

All existing live sewers including septic tanks and drain fields shall be kept in service at all times. Provision shall be made for disposal of sewage flow if any existing sewers are damaged. Damage to existing sewers shall be repaired by the Contractor, at no expense to the Contracting Agency, to a condition equal to or better than their condition prior to the damage.

Water accumulating during construction shall be removed from the new sewers but shall not be permitted to enter the existing system. The Contractor shall be responsible for flushing out and cleaning any existing sewers into which gravel, rocks, or other debris

has entered as a result of their operations, and shall repair lift stations or other facilities damaged by the Contractor's operations.

The physical connection to an existing manhole or sewer shall not be made until authorized by the Engineer. Such authorization will not be given until all upstream lines have been completely cleaned, all debris removed, and where applicable, a pipe temporarily placed in the existing channel and sealed.

7-17.3(2) Cleaning and Testing

7-17.3(2)A General

Sewers and appurtenances, where required in the Plans, shall be cleaned and tested after backfilling by either the exfiltration or low pressure air method at the option of the Contractor, except where the ground water table is such that the Engineer may require the infiltration test.

All Work involved in cleaning and testing sewer lines between manholes or rodding inlets as required shall be completed within 15 working days after backfilling of sewer lines and Structures. Any further delay will require the written consent of the Engineer. The Contractor shall furnish all labor, materials, tools, and equipment necessary to make the test, clean the lines, and perform all incidental Work. The Contractor shall perform the tests under the direction and in the presence of the Engineer. Precautions shall be taken to prevent joints from drawing during tests, and any damage resulting from these tests shall be repaired by the Contractor at no expense to the Contracting Agency. The manner and time of testing shall be subject to approval by the Engineer.

All wyes, tees, and stubs shall be plugged with flexible jointed caps, or acceptable alternate, securely fastened to withstand the internal test pressure. Such plugs or caps shall be readily removable, and their removal shall provide a socket suitable for making a flexible jointed lateral connection or extension.

Testing side sanitary sewers shall be for their entire length from the public sewer in the street to the connection with the building's plumbing. Their testing shall be as required by the local sanitary agency but in no case shall it be less thorough than that of filling the pipe with water before backfilling and visually inspecting the exterior for leakage. The decision of the Engineer as to acceptance of the side sanitary sewer shall be final.

If any sewer installation fails to meet the requirements of the test method used, the Contractor shall determine, at no expense to the Contracting Agency, the source or sources of leakage and shall repair or replace all defective materials or workmanship at no expense to the Contracting Agency. The complete pipe installation shall meet the requirements of the test method used before being considered acceptable.

7-17.3(2)B Exfiltration Test

Prior to making exfiltration leakage tests, the Contractor may fill the pipe with clear water to permit normal absorption into the pipe walls provided, however, that after so filling the pipe, the Contractor shall complete the leakage test within 24 hours after filling. When under test, the allowable leakage shall be limited according to the provisions that follow. Specified allowances assume pre-wetted pipe.

Leakage shall be no more than 0.28 gph per inch diameter per 100 feet of sewer, with a hydrostatic head of 6 feet above the crown at the upper end of the test section, or above the natural ground water table at the time of test, whichever is higher. The length of pipe tested shall be limited so that the pressure at the lower end of the Section tested does not exceed 16 feet of head above the invert, and in no case shall be greater than 700 feet or the distance between manholes when greater than 700 feet.

Where the test head is other than 6 feet, the maximum leakage shall not exceed the amount determined from the following equation:

Maximum leakage (in gallons per hour) $= 0.28 \times (\sqrt{H}/\sqrt{6}) \times D \times (L/100)$

Where:

D = diameter (in.)
L = length of pipe (ft.)
H = test head (ft.)

When the test is to be made one joint at a time, the leakage per joint shall not exceed the computed allowable leakage per length of pipe.

7-17.3(2)C Infiltration Test

Where the natural ground water head over the pipe is 2 feet or less above the crown of pipe at the upper end of the test section, the infiltration test leakage shall not exceed 0.16 gallons per hour per inch of diameter per 100 feet of pipe length. The length of pipe tested shall not exceed 700 feet or the distance between manholes when greater than 700 feet.

Where the natural ground water head is greater than 2 feet, the maximum leakage shall not exceed the amount determined from the following equation:

Maximum leakage (in gallons per hour) $= 0.16 \times (\sqrt{H}/\sqrt{2}) \times D \times (L/100)$

Where:

D = diameter (in.)
L = length of pipe (ft.)
H = natural ground water head (ft.)

When a suitable head of ground water exists above the crown of the pipe and when the pipe is large enough to work inside, acceptance may be based on the repair of visible leakage by means satisfactory to the Engineer.

7-17.3(2)D Other Test Allowances

For either the infiltration or exfiltration test, all lateral or side sewer branches included in the test section shall be taken into account in computing allowable leakage. An allowance of 0.2 gallons per hour per foot of head above invert shall be made for each manhole included in a test section.

Upon final acceptance of the Work all sewers, side sewers and fittings shall be open, clean, and free draining.

7-17.3(2)E Low Pressure Air Test for Sanitary Sewers Constructed of Air Permeable Materials

Air permeable materials include concrete and vitrified clay. Low pressure air testing may be used for air permeable pipes 30 inches in diameter and smaller.

The test equipment to be used shall be furnished by the Contractor and shall be inspected and approved by the Engineer prior to use. The Engineer may at any time require a calibration test of gauges or other instrumentation that is incorporated into the test equipment. Calibration tests shall be certified by an independent testing Laboratory.

Plugs used to close the pipe for the air test must be securely braced to prevent the unintentional release of a plug, which can become a high velocity projectile. Gauges, air piping manifold, and valves shall be located at the top of the ground. No one shall be permitted to enter a manhole or catch basin where a plugged pipe is under pressure. Air testing apparatus shall be equipped with a pressure release device, such as a rupture disk or a pressure relief valve, designed to activate when the pressure in the pipe exceeds 2 psig above the required test pressure.

If the pipe to be tested is submerged by groundwater, the backpressure on the pipe created by the groundwater submergence must be determined. All gauge pressures described in the test shall be increased by that amount.

The first section of pipe installed by each crew shall be tested in order to qualify the crew and material. A successful test for the section shall be a prerequisite to further installation by that crew. Following the initial test, pipes shall be tested from manhole to manhole, catch basin to catch basin, or such shorter lengths as determined by the Contractor.

Air shall be slowly supplied to the plugged pipe section until the internal air pressure reaches 4 psig. Wait at least 2 minutes to allow for pressure and temperature stabilization to occur within the pipe.

When the pressure decreases to 3.5 psig, the air pressure test shall begin. The test shall consist of measuring the time in seconds for the pressure in the pipe to drop from 3.5 psig to 2.5 psig. The pipe shall be considered acceptable if the time in seconds for the pressure drop is equal to or greater than the required time as calculated below:

$K = 0.0111d^2L$

$C = 0.0003918dL$

If $C_T < 1$, then time = K_T

If $1 < C_T < 1.75$, then time = K_T/C_T

If $C_T > 1.75$, then time = $K_T/1.75$

Where:

d	=	Pipe diameter (inches)
L	=	Pipe length (feet)
K	=	value for each length of pipe of a specific diameter
C	=	value for each length of pipe of a specific diameter
K_T	=	sum of all K values
C_T	=	sum of all C values

This method was developed based on an allowable air loss rate of 0.003 cubic feet per minute (cfm) per square foot of internal pipe surface, with the total air loss rate not less than 2 cfm nor greater than 3.5 cfm. At the Contractor's option, the pipe may be tested without pre-wetting; however, the allowable air loss rate assumes pre-wetted pipe.

Pipe over 30 inches in diameter shall be tested one joint at a time in accordance with ASTM C1103.

7-17.3(2)F Low Pressure Air Test for Sanitary Sewers Constructed of Non Air Permeable Materials

Non air permeable materials include ductile iron, ABS composite, polyvinyl chloride (PVC), and polyethylene (PE). When non air permeable pipe is subjected to a low-pressure air test, all of the provisions of Section 7-17.3(2)E shall apply, except that the time in seconds for the pressure drop shall be equal to or greater than four times the required time calculated in Section 7-17.3(2)E.

Pipe over 30 inches in diameter shall be tested one joint at a time in accordance with ASTM C1103.

Reaches of thermoplastic pipe containing no joints shall be exempt from testing requirements.

7-17.3(2)G Deflection Test for Thermoplastic Pipe

Sanitary sewers constructed of thermoplastic pipe shall be tested for deflection not less than 30 days after the trench backfill and compaction has been completed. The test shall be conducted by pulling a properly sized "go-nogo" mandrel through the completed pipeline. Testing shall be conducted on a manhole-to-manhole basis and shall be done after the line has been completely flushed out with water.

The mandrel shall be a rigid, nonadjustable mandrel having an effective length of not less than its normal diameter and an odd-number of legs (9 legs minimum). Minimum diameter at any point along the full length of the mandrel shall be 95 percent of the base inside diameter of the pipe being tested.

Base inside diameter is derived by subtracting a statistical tolerance package from the average inside diameter. The tolerance package is defined as the square root of the sum of squared manufacturing tolerances. The tolerance package for controlled outside diameter pipe consists of (1) outside diameter tolerance specified in applicable ASTM Standard, (2) 12 percent of one wall thickness specified in applicable ASTM Standard, and (3) out of roundness tolerance listed in appendix of applicable ASTM Standard. The items in the tolerance package for controlled inside diameter pipe consists of (1) inside diameter tolerance listed in appendix of applicable ASTM Standard and (2) out of roundness tolerance listed in appendix of applicable ASTM Standard. When out of roundness tolerance is not listed, use 3 percent of average inside diameter.

The average inside diameter for pipe with controlled outside diameter shall be equal to the average outside diameter as specified in applicable ASTM Standard minus 2 minimum wall thicknesses as specified in applicable ASTM Standard and minus 2 times excess wall tolerance of 6 percent. The average inside diameter for pipes with controlled inside diameter shall be the average inside diameter as specified in applicable ASTM Standard.

The Contractor shall be required, at no expense to the Contracting Agency, to locate and uncover any sections failing to pass the test and, if not damaged, reinstall the pipe. The use of a vibratory re-rounding device or any process other than removal or reinstallation shall not be acceptable. The Contractor shall retest the section after replacement of the pipe.

Pipe large enough to work inside of may be accepted on the basis of direct measurement.

7-17.3(2)H Television Inspection

The Engineer may require any or all sanitary sewer lines be inspected by the use of a television camera before final acceptance. The costs incurred in making the initial inspection shall be borne by the owner of the sanitary sewer.

The Contractor shall bear all costs incurred in correcting any deficiencies found during television inspection including the cost of any additional television inspection that may be required by the Engineer to verify the correction of said deficiency.

The Contractor shall be responsible for all costs incurred in any television inspection performed solely for the benefit of the Contractor.

7-17.4 Measurement

The length of sewer pipe will be the number of linear feet of completed installation measured along the invert and will include the length through elbows, tees and fittings. The number of linear feet will be measured from the center of manhole to center of manhole or to the inside face of catch basins and similar type Structures.

The length of testing sewer pipe in conformance with Section 7-17.3(2) will be the number of linear feet of completed installation actually tested.

7-17.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Plain Conc. or V.C. Sewer Pipe ____ In. Diam.", per linear foot.

"Cl. ____ Reinf. Conc. Sewer Pipe ____ In. Diam.", per linear foot.

"PVC Sanitary Sewer Pipe ____ In. Diam.", per linear foot.

"Ductile Iron Sewer Pipe ____ In. Diam.", per linear foot.

"ABS Composite Sewer Pipe ____ In. Diam.", per linear foot.

"Polypropylene Sewer Pipe ____ In. Diam.", per linear foot.

The unit Contract price per linear foot for sewer pipe of the kind and size specified shall be full pay for furnishing, hauling, and assembling in place the completed installation including all wyes, tees, special fittings, joint materials, bedding and backfill material, and adjustment of inverts to manholes for the completion of the installation to the required lines and grades.

"Testing Sewer Pipe", per linear foot.

The unit Contract price per linear foot for "Testing Sewer Pipe" shall be full pay for all labor, material and equipment required to conduct the leakage tests required in Section 7-17.3(2).

"Removal and Replacement of Unsuitable Material", per cubic yard.

The unit Contract price per cubic yard for "Removal and Replacement of Unsuitable Material" shall be full pay for all Work to remove unsuitable material and replace and compact suitable material as specified in Section 7-08.3(1)A.

7-18 Side Sewers

7-18.1 Description

This Work shall consist of constructing side sewers in accordance with the Plans, these Specifications, and the *Standard Plans*, at locations staked, on both the right of way and private property between the main sanitary sewer line and the stubout from a residence or other building.

7-18.2 Materials

Materials shall be the same as required for sanitary sewers in Section 7-17.

7-18.3 Construction Requirements

7-18.3(1) General

The construction requirements for sanitary sewers in Section 7-17 shall apply to the construction of side sewers.

Side sewers shall not be backfilled prior to inspection.

Side sewers shall be constructed with a maximum joint deflection not to exceed the manufacturer's printed recommendations and in no case shall exceed 2 inches per foot in any joint. Larger changes in direction shall be made by use of standard ⅛ bends.

7-18.3(2) Fittings

Side sewers shall be connected to the tee, wye, or riser provided in the public sewer, where such is available, utilizing approved fittings or adapters. Where no tee, wye, or riser is provided or available, connection shall be made by machine made tap and approved saddle.

7-18.3(3) Testing

All side sewers shall be tested after backfilling.

All side sewers constructed in conjunction with the main sewer shall, for purposes of testing as specified in Section 7-17, have a 6-inch tee fitting pipe placed at the point where the side sewer crosses the street or other public Right of Way margin. The tee opening shall be positioned perpendicular to the side sewer slope, unless otherwise directed by the Engineer.

When side sewers are not tested simultaneously with the testing of the main sewer, the Contractor, at no expense to the Contracting Agency, shall furnish and place an additional tee in the first pipe out of the main sewer tee or wye branch, so that an inflatable rubber ball can be inserted for sealing off the side sewer and thus permit separate tests.

7-18.3(4) Extending Side Sewers Into Private Property

Side sewers shall not be constructed on private property prior to completion and acceptance of the main line and side sewer on public Right of Way or easement unless approved in writing by the Engineer.

7-18.3(5) End Pipe Marker

The location of side sewers at the property line shall be marked by the Contractor with a 2 by 4-inch wooden stake 4 feet long buried in the ground a depth of 3 feet. The low end shall have a 2 by 4-inch cleat nailed to it to prevent withdrawal of the stake. The exposed end shall be painted traffic white and the depth to the side sewer or tee shall be indicated in black paint on the 2 by 4. In addition, a length of 12-gage galvanized wire shall be provided to extend from the plugged end of the side sewer or tee. The upper end shall emerge at the 4-foot stake, but shall not be fastened to it.

7-18.4 Measurement

Measurement shall be as specified in Section 7-17.4.

7-18.5 Payment

Payment shall be made for each of the Bid items shown in Section 7-17.5 that are included in the Proposal.

The unit Contract price per linear foot for sewer pipe of the various kind and size specified shall be full pay for all Work required for the completion of the installation including fittings and end pipe marker.

7-19 Sewer Cleanouts

7-19.1 Description

This Work consists of constructing sanitary sewer cleanouts in accordance with the Plans, these Specifications, and the *Standard Plans* as staked.

7-19.2 Materials

All materials incorporated into the total cleanout Structure shall meet the requirements of the various applicable sections of these Specifications.

7-19.3 Construction Requirements

A cleanout shall be provided for each total change of 90 degrees of grade or alignment and in no case shall the spacing of cleanouts exceed 100 feet. No cleanout will be required at the connection of the side sewer to a riser on the public sewer. A suitably located cleanout in the house piping or plumbing may be considered as a cleanout for the side sewer. Cleanouts shall consist of a wye branch in the side sewer.

All cleanouts located in public rights of way shall be extended to grade.

The extension of cleanouts to grade on private property will be optional with the property owner. When extended to grade, cleanouts shall be full side sewer diameter and shall be extended to a point not less than 6 inches nor more than 12 inches below the finished ground surface and shall be plugged with a removable stopper which will prevent passage of dirt or water. When specified, the Contractor shall install an approved casting to provide ready access to the cleanout stopper. A ⅛ bend shall be used to deflect the side sewer upward as a cleanout where the terminal end of the side sewer lies upstream from the last point of connection.

7-19.4 Measurement

Sewer cleanouts will be measured per each.

7-19.5 Payment

Payment will be made for the following Bid item when listed in the Proposal:

> "Sewer Cleanout", per each.
>
> The unit Contract price per each for cleanouts shall be full pay for furnishing and placing the wye, pipe, pipe bends, pipe plug, castings, and collar as specified herein and as shown on the *Standard Plans*.

8-01 Erosion Control and Water Pollution Control

8-01.1 Description

This Work consists of furnishing, installing, maintaining, removing and disposing of best management practices (BMPs), as defined in the Washington Administrative Code (WAC) 173-201A, to manage erosion and water quality in accordance with these Specifications and as shown in the Plans or as designated by the Engineer.

The Contracting Agency may have a National Pollution Discharge Elimination System Construction Stormwater General Permit (CSWGP) as identified in the Contract Special Provisions. The Contracting Agency may or may not transfer coverage of the CSWGP to the Contractor when a CSWGP has been obtained. The Contracting Agency may not have a CSWGP for the project but may have another water quality related permit as identified in the Contract Special Provisions or the Contracting Agency may not have water quality related permits but the project is subject to applicable laws for the Work. Section 8-01 covers all of these conditions.

8-01.1(1) Definitions

1. pH Affected Stormwater
    a. Stormwater contacting green concrete (concrete that has set/stiffen but is still curing), recycled concrete, or engineered soils (as defined in the Construction Stormwater General Permit (CSWGP)) as a natural process
    b. pH monitoring shall be performed in accordance with the CSWGP, or Water Quality Standards (WQS in accordance with WAC 173-201A (surface) or 173-200C (ground)) when the CSWGP does not apply
    c. May be neutralized and discharged to surface waters or infiltrated
2. pH Affected Non-Stormwater
    a. Conditionally authorized in accordance with CSWGP Special Condition S.1.C., uncontaminated water contacting green concrete, recycled concrete, or engineered soils (as defined in the CSWGP)
    b. Shall not be categorized as cementitious wastewater/concrete wastewater, as defined below
    c. Shall be managed and treated in accordance with the CSWGP, or WQS when the CSWGP does not apply
    d. pH adjustment and dechlorination may be necessary, as specified in the CSWGP or in accordance with WQS when the CSWGP does not apply

e. May be neutralized, treated, and discharged to surface waters in accordance with the CSWGP, with the exception of water-only shaft drilling slurry. Water-only shaft drilling slurry may be treated, neutralized, and infiltrated but not discharged to surface waters (Refer to Special Conditions S1.C. Authorized Discharges and S1.d Prohibited Discharges of the CSWGP)

3. Cementitious Wastewater/Concrete Wastewater

a. Any water that comes into contact with fine cementitious particles or slurry; any water used in the production, placement and/or clean-up of cementitious products; any water used to cut, grind, wash, or otherwise modify cementitious products

b. When any water, including stormwater, commingles with cementitious wastewater/concrete wastewater, the resulting water is considered cementitious wastewater/concrete wastewater and shall be managed to prevent discharge to waters of the State, including ground water

c. CSWGP Examples include: water used for or resulting from concrete truck/mixer/pumper/tool/chute rinsing or washing, concrete saw cutting and surfacing (sawing, coring, grinding, roughening, hydro-demolition, bridge and road surfacing)

d. Cannot be neutralized and discharged or infiltrated

8-01.2 Materials

Materials shall meet the requirements of the following sections:

Corrugated Polyethylene Drain Pipe	9-05.1(6)
Quarry Spalls and Permeable Ballast	9-13
Seed	9-14.3
Fertilizer	9-14.3
Mulch and Amendments	9-14.5
Tackifier	9-14.5(7)
Erosion Control Devices	9-14.6
Plant Materials	9-14.7
Construction Geotextile	9-33

Recycled concrete, in any form, shall not be used for any Work defined in Section 8-01.

8-01.3 Construction Requirements

8-01.3(1) General

Adaptive management shall be employed throughout the duration of the project for the implementation of erosion and water pollution control permit requirements for the current condition of the project site. The adaptive management includes the selection and utilization of BMPs, scheduling of activities, prohibiting unacceptable practices, implementing maintenance procedures, and other managerial practices that when used singularly or in combination, prevent or reduce the release of pollutants to waters of

the State. The adaptive management shall use the means and methods identified in this section and means and methods identified in the Washington State Department of Transportation's *Temporary Erosion and Sediment Control Manual* or the Washington State Department of Ecology's *Stormwater Management Manuals* for construction stormwater.

The Contractor shall install a high visibility fence along the lines shown in the Plans or as instructed by the Engineer.

Throughout the life of the project, the Contractor shall preserve and protect the delineated preservation area, acting immediately to repair or restore any high visibility fencing damaged or removed.

All discharges to surface waters shall comply with surface water quality standards as defined in Washington Administrative Code (WAC) Chapter 173-201A. All discharges to groundwater shall comply with groundwater quality standards WAC Chapter 173-200. The Contractor shall comply with the CSWGP when the project is covered by the CSWGP.

Work, at a minimum, shall include the implementation of:

1. Sediment control measures prior to ground disturbing activities to ensure all discharges from construction areas receive treatment prior to discharging from the site.
2. Flow control measures to prevent erosive flows from developing.
3. Water management strategies and pollution prevention measures to prevent contamination of waters that will be discharged to surface waters or the ground.
4. Erosion control measures to stabilize erodible earth not being worked.
5. Maintenance of BMPs to ensure continued compliant performance.
6. Immediate corrective action if evidence suggests construction activity is not in compliance. Evidence includes sampling data, olfactory or visual evidence such as the presence of suspended sediment, turbidity, discoloration, or oil sheen in discharges.

To the degree possible, the Contractor shall coordinate this Work with permanent drainage and roadside restoration Work the Contract requires.

Clearing, grubbing, excavation, borrow, or fill within the Right of Way shall never expose more erodible earth than as listed below:

Western Washington (West of the Cascade Mountain Crest)	
May 1 through September 30	17 Acres
October 1 through April 30	5 Acres

Eastern Washington (East of the Cascade Mountain Crest)	
April 1 through October 31	17 Acres
November 1 through March 31	5 Acres

The Engineer may increase or decrease the limits based on project conditions.

Erodible earth is defined as any surface where soils, grindings, or other materials may be capable of being displaced and transported by rain, wind, or surface water runoff.

Erodible earth not being worked, whether at final grade or not, shall be covered within the specified time period (see the table below) BMPs for erosion control.

Western Washington (West of the Cascade Mountain Crest)	
October 1 through April 30	2 days maximum
May 1 to September 30	7 days maximum

Eastern Washington (East of the Cascade Mountain Crest)	
October 1 through June 30	5 days maximum
July 1 through September 30	10 days maximum

When applicable, the Contractor shall be responsible for all Work required for compliance with CSWGP including annual permit fees.

If the Engineer, under Section 1-08.6, orders the Work suspended, the Contractor shall continue to comply with this division during the suspension.

8-01.3(1)A Submittals

8-01.3(1)A1 Temporary Erosion and Sediment Control Plan

Temporary Erosion and Sediment Control (TESC) Plans consist of a narrative section and plan sheets that meets Ecology's Stormwater Pollution Prevention Plan (SWPPP) requirement in the CSWGP. For projects that do not require a CSWGP but have the potential to discharge to surface waters of the state, an abbreviated TESC plan shall be used, which may consist of a narrative and/or plan sheets and shall demonstrate compliance with applicable codes, ordinances and regulations, including the water quality standards for surface waters, Chapter 173-201A of the Washington Administrative Code (WAC) and water quality standards for groundwaters in accordance with Chapter 173-200 WAC.

The Contractor shall either adopt the TESC Plan in the Contract or develop a new TESC Plan. If the Contractor adopts the TESC Plan in scenarios in which the CSWGP is transferred to the Contractor, the Contractor shall modify the TESC Plan to match the Contractor's schedule, method of construction, and to include all areas that will be used to directly support construction activity such as equipment staging yards, material storage areas, or borrow areas. TESC Plans shall include all high visibility fence shown in the Plans. All TESC Plans shall meet the requirements of the current edition of the WSDOT *Temporary Erosion and Sediment Control Manual* M 3109 and be adaptively managed throughout construction based on site inspections and required sampling to maintain compliance with the CSWGP, or WQS when no CSWGP applies. The Contractor shall develop a schedule for implementation of the TESC work and incorporate it into the Contractor's progress schedule.

The Contractor shall submit their TESC Plan (either the adopted plan or new plan) as Type 2 Working Drawings. At the request of the Engineer updated TESC Plans shall be submitted as Type 1 Working Drawings.

8-01.3(1)B Erosion and Sediment Control (ESC) Lead

The Contractor shall identify the ESC Lead at the preconstruction discussions and in the TESC Plan. For projects with a CSWGP, the ESC Lead shall have, for the life of the Contract, a current Certificate of Training in Construction Site Erosion and Sediment Control from a course approved by the Washington State Department of Ecology. The ESC Lead must be onsite or on call at all times throughout construction. The ESC Lead shall be listed on the Emergency Contact List required under Section 1-05.13(1).

The ESC Lead shall implement the TESC Plan. For projects with a CSWGP, implementation shall include, but is not limited to:

1. Installing, adaptively managing, and maintaining temporary erosion and sediment control BMPs to assure continued performance of their intended function. Damaged or inadequate BMPs shall be corrected immediately.
2. Updating the TESC Plan to reflect current field conditions.
3. Discharge sampling and submitting Discharge Monitoring Reports (DMRs) to Ecology in accordance with the CSWGP.
4. Develop and maintain the Site Log Book as defined in the CSWGP. When the Site Log Book or portion thereof is electronically developed, the electronic documentation must be accessible onsite. As a part of the Site Log Book, the Contractor shall develop and maintain a tracking table to show that identified TESC compliance issues are fully resolved within 10 calendar days. The table shall include the date an issue was identified, a description of how it was resolved, and the date the issue was fully resolved.

The ESC Lead shall also inspect all areas disturbed by construction activities, all on-site erosion and sediment control BMP's, and all stormwater discharge points at least once every calendar week and within 24-hours of runoff events in which stormwater discharges from the site. Inspections of temporarily stabilized, inactive sites may be reduced to once every calendar month. For projects with a CSWGP, the Washington State Department of Ecology's Erosion and Sediment Control Site Inspection Form, located at https://ecology.wa.gov/Regulations-Permits/Permits-certifications/Stormwater-general-permits/Construction-stormwater-permit shall be completed for each inspection and a copy shall be submitted to the Engineer no later than the end of the next working day following the inspection.

8-01.3(1)C Water Management

Unless site water is to be managed in accordance with the conditions of a waste discharge permit from a local permitting authority, site water shall be managed as follows:

8-01.3(1)C1 Disposal of Dewatering Water

When uncontaminated groundwater is encountered in an excavation on a project, it may be infiltrated within vegetated areas of the right of way not designated as Sensitive Areas or incorporated into an existing stormwater conveyance system at a rate that will not cause erosion or flooding in any receiving surface water.

Alternatively, the Contractor may pursue independent disposal and treatment alternatives that do not use the stormwater conveyance system provided it is in compliance with the applicable WACs and permits.

8-01.3(1)C2 Process Wastewater

Wastewater generated on-site as a byproduct of a construction process shall not be discharged to surface waters of the State. Some sources of process wastewater may be infiltrated in accordance with the CSWGP. Some sources of process wastewater may be disposed via independent disposal and treatment alternatives in compliance with the applicable WACs and permits.

8-01.3(1)C3 Shaft Drilling Slurry Wastewater

Wastewater generated on-site during shaft drilling activity shall be managed and disposed of in accordance with the requirements below. No shaft drilling slurry wastewater shall be discharged to surface waters of the State. Neither the sediment nor liquid portions of the shaft drilling slurry wastewater shall be contaminated, as detectable by visible or olfactory indication (e.g., chemical sheen or smell).

1. Water-only shaft drilling slurry or water slurry with accepted flocculants may be infiltrated on-site. Flocculants used shall meet the requirements of Section 9-14.6(1) or shall be chitosan products listed as General Use Level Designation (GULD) on the Department of Ecology's stormwater treatment technologies webpage for construction treatment. Infiltration is permitted if the following requirements are met:

    a. Wastewater shall have a pH of 6.5 – 8.5 prior to discharge.

    b. The amount of flocculant added to the slurry shall be kept to the minimum needed to adequately settle out solids. The flocculant shall be thoroughly mixed into the slurry.

    c. The slurry removed from the shaft shall be contained in a leak proof cell or tank for a minimum of 3 hours.

    d. The infiltration rate shall be reduced if needed to prevent wastewater from leaving the infiltration location. The infiltration site shall be monitored regularly during infiltration activity. All wastewater discharged to the ground shall fully infiltrate and discharges shall stop before the end of each work day.

    e. Drilling spoils and settled sediments remaining in the containment cell or tank shall be disposed of in accordance with Section 6-19.3(4)F.

    f. Infiltration locations shall be in upland areas at least 150 feet away from surface waters, wells, on-site sewage systems, aquifer sensitive recharge areas, sole source aquifers, well head protection areas, and shall be marked on the plan sheets before the infiltration activity begins.

g. Prior to infiltration, the Contractor shall submit a Shaft Drilling Slurry Wastewater Management and Infiltration Plan as a Type 2 Working Drawing. This Plan shall be kept on-site, adapted if needed to meet the construction requirements, and updated to reflect what is being done in the field. The Working Drawing shall include, at a minimum, the following information:

i. Plan sheet showing the proposed infiltration location and all surface waters, wells, on-site sewage systems, aquifer-sensitive recharge areas, sole source aquifers, and well-head protection areas within 150 feet.

ii. The proposed elevation of soil surface receiving the wastewater for infiltration and the anticipated phreatic surface (i.e., saturated soil).

iii. The source of the water used to produce the slurry.

iv. The estimated total volume of wastewater to be infiltrated.

v. The accepted flocculant to be used (if any).

vi. The controls or methods used to prevent surface wastewater runoff from leaving the infiltration location.

vii. The strategy for removing slurry wastewater from the shaft and containing the slurry wastewater once it has been removed from the shaft.

viii. The strategy for monitoring infiltration activity and adapting methods to ensure compliance.

ix. A contingency plan that can be implemented immediately if it becomes evident that the controls in place or methods being used are not adequate.

x. The strategy for cleaning up the infiltration location after the infiltration activity is done. Cleanup shall include stabilizing any loose sediment on the surface within the infiltration area generated as a byproduct of suspended solids in the infiltrated wastewater or soil disturbance associated with BMP placement and removal.

2. Shaft drilling mineral slurry, synthetic slurry, or slurry with polymer additives not allowed for infiltration shall be contained and disposed of by the Contractor at an accepted disposal facility in accordance with Section 2-03.3(7)C. Spoils that have come into contact with mineral slurry shall be disposed of in accordance with Section 6-19.3(4)F.

8-01.3(1)C4 Management of Off-Site Water

Prior to clearing and grubbing, the Contractor shall intercept all sources of off-site surface water and overland flow that will run-on to the project. Off-site surface water run-on shall be diverted through or around the project in a way that does not introduce construction related pollution. It shall be diverted to its preconstruction discharge location in a manner that does not increase preconstruction flow rate and velocity and protects contiguous properties and waterways from erosion. The Contractor shall submit a Type 2 Working Drawing consisting of the method for performing this Work.

8-01.3(1)C5 Water Management for In-Water Work Below Ordinary High Water Mark (OHWM)

Work over surface waters of the state (defined in WAC 173-201A-010) or below the OHWM (defined in RCW 90.58.030) shall comply with water quality standards for surface waters of the state of Washington.

8-01.3(1)C6 Environmentally Acceptable Hydraulic Fluid

All equipment containing hydraulic fluid that extends from a bridge deck over surface waters of the state or below the OHWM, shall be equipped with a biodegradable hydraulic fluid. The fluid shall achieve either a Pw1 Environmental Persistence Classification stated in ASTM D6046 (≥60% biodegradation in 28 days) or equivalent standard. Alternatively, hydraulic fluid that meets International Organization for Standardization (ISO 15380), the European Union Ecolabel, or equivalent certification will also be accepted.

The Contractor shall submit a Type 1 Working Drawing consisting of a manufacturer catalog cut of the hydraulic fluid used.

The designation of biodegradable hydraulic fluid does not mean fluid spills are acceptable. The Contractor shall respond to spills to land or water in accordance with the Contract, the associated SPCC Plan, and all applicable local, state, and federal regulations.

8-01.3(1)C7 Turbidity Curtain

All Work for the turbidity curtain shall be in accordance with the manufacturer's recommendations for the site conditions. Removal procedures shall be developed and used to minimize silt release and disturbance of silt. The Contractor shall submit a Type 2 Working Drawing, detailing product information, installation and removal procedures, equipment and workforce needs, maintenance plans, and emergency repair/replacement plans.

Turbidity curtain materials, installation, and maintenance shall be sufficient to comply with water quality standards.

The Contractor shall notify the Engineer 10 days in advance of removing the turbidity curtain. All components of the turbidity curtain shall be removed from the project.

8-01.3(1)D Dispersion/Infiltration

Water shall be conveyed only to dispersion or infiltration areas designated in the TESC Plan or to sites approved by the Engineer. Water shall be conveyed to designated dispersion areas at a rate such that, when runoff leaves the area and enters waters of the State, turbidity standards are achieved. Water shall be conveyed to designated infiltration areas at a rate that does not produce surface runoff.

8-01.3(1)E Detention/Retention Pond Construction

Permanent or temporary, ponds shall be constructed before beginning other grading and excavation Work in the area that drains into that pond. Detention/retention ponds may be constructed concurrently with grading and excavation when allowed by the Engineer. Temporary conveyances shall be installed concurrently with grading in accordance with the TESC Plan so that newly graded areas drain to the pond as they are exposed.

8-01.3(2) Temporary Seeding and Mulching

8-01.3(2)A Preparation for Application

A cleated roller, crawler tractor, or similar equipment, which forms longitudinal depressions at least 2 inches deep shall be used for compaction and preparation of the surface to be seeded. The entire area shall be uniformly covered with longitudinal depressions formed perpendicular to the natural flow of water on the slope. The soil shall be conditioned with sufficient water so the longitudinal depressions remain in the soil surface until completion of the seeding.

8-01.3(2)B Temporary Seeding

Temporary grass seed shall be a commercially prepared mix, made up of low growing grass species that will grow without irrigation at the project location, and accepted by the Engineer. The application rate shall be two pounds per 1000 square feet.

The Contractor shall notify the Engineer not less than 24 hours in advance of any seeding operation and shall not begin the Work until areas prepared or designated for seeding have been accepted. Following the Engineer's acceptance, seeding of the accepted slopes shall begin immediately.

Temporary seeding may be sown at any time allowed by the Engineer. Temporary seeding shall be sown by one of the following methods:

1. A hydro seeder that utilizes water as the carrying agent, and maintains continuous agitation through paddle blades. It shall have an operating capacity sufficient to agitate, suspend, and mix into a homogeneous slurry the specified amount of seed and water or other material. Distribution and discharge lines shall be large enough to prevent stoppage and shall be equipped with a set of hydraulic discharge spray nozzles that will provide a uniform distribution of the slurry.
2. Blower equipment with an adjustable disseminating device capable of maintaining a constant, measured rate of material discharge that will ensure an even distribution of seed at the rates specified.
3. Power-drawn drills or seeders.
4. Areas in which the above methods are impractical may be seeded by hand methods.

When seeding by hand, the seed shall be incorporated into the top ¼ inch of soil by hand raking or other method that is allowed by the Engineer.

Seed applied using a hydroseeder shall have a tracer added to visibly aid uniform application. This tracer shall not be harmful to plant, aquatic, or animal life. If Short-Term Mulch is used as a tracer, the application rate shall not exceed 250 pounds per acre.

Seed and fertilizer may be applied in one application provided that the fertilizer is placed in the hydroseeder tank no more than 1 hour prior to application.

8-01.3(2)C Vacant

8-01.3(2)D Temporary Mulching

Temporary mulch shall be straw, wood strand, or HECP mulch and shall be used for the purpose of erosion control by protecting bare soil surface from particle displacement. Mulch shall not be applied below the anticipated water level of ditch slopes, pond bottoms, and stream banks. HECP mulch shall not be used within the Ordinary High Water Mark. Non-HECP mulches applied below the anticipated water level shall be removed or anchored down so that it cannot move or float, at no additional expense to the Contracting Agency.

Straw or wood strand mulch shall be applied at a rate to achieve at least 95 percent visual blockage of the soil surface. Straw mulch shall be suitable for spreading with mulch blower equipment.

Short Term Mulch shall be hydraulically applied at the rate of 2500 pounds per acre and may be applied in one lift. Short-Term Mulch shall not be used in conjunction with permanent seeding.

Moderate Term Mulch and Long Term Mulch shall be hydraulically applied at the rate of 3500 pounds per acre with no more than 2000 pounds applied in any single lift. Moderate-Term Mulch shall not be used in conjunction with permanent seeding.

Mulch sprayed on signs or sign Structures shall be removed the same day.

Areas not accessible by mulching equipment shall be mulched by accepted hand methods.

8-01.3(2)E Tackifiers

Tackifiers applied using a hydroseeder shall have a mulch tracer added to visibly aid uniform application. This tracer shall not be harmful to plant, aquatic, or animal life. A minimum of 125 pounds per acre and a maximum of 250 pounds per acre of Short-Term Mulch shall be used as a tracer. Tackifier shall be mixed and applied in accordance with the manufacturer's recommendations.

Soil Binding Using Polyacrylamide (PAM) – The PAM shall be applied on bare soil completely dissolved and mixed in water or applied as a dry powder. Dissolved PAM shall be applied at a rate of not more than ⅔ pound per 1,000 gallons of water per acre. A minimum of 200 pounds per acre of Short-Term Mulch shall be applied with the dissolved PAM. Dry powder applications may be at a rate of 5 pounds per acre using a hand-held fertilizer spreader or a tractor-mounted spreader.

PAM shall be applied only to areas that drain to completed sedimentation control BMPs in accordance with the TESC Plan. PAM may be reapplied on actively worked areas after a 48-hour period.

PAM shall not be applied during rainfall or to saturated soils.

8-01.3(3) Placing Erosion Control Blanket

Erosion Control Blankets are used as an erosion prevention device and to enhance the establishment of vegetation. Erosion control blankets shall be installed according to the manufacturer's recommendations.

When used to enhance the establishment of seeded areas, seeding and fertilizing shall be done prior to blanket installation.

Select erosion control blanket material for an area based on the intended function: slope or ditch stabilization, and site specific factors including soil, slope gradient, rainfall, and flow exposure. Erosion Control Blankets shall not be used on slopes or in ditches that exceed the manufacturer's recommendations.

8-01.3(4) Placing Compost Blanket

Compost blankets are used for erosion control. Compost blanket shall only be placed on ground surfaces that are steeper than 3-foot horizontal and 1-foot vertical though steeper slopes shall be broken by wattles or compost socks placed according to the Standard Plans. Compost shall be placed to a depth of 3 inches over bare soil. An organic tackifier shall be placed over the entire composted area when dry or windy conditions are present or expected. The tackifier shall be applied immediately after the application of compost to prevent compost from leaving the composted area.

Medium compost shall be used for the compost blanket. Compost may serve the purpose of soil amendment as specified in Section 8-02.3(6).

8-01.3(5) Plastic Covering

Erosion Control – Plastic coverings used to temporarily cover stockpiled materials, slopes or bare soils shall be installed and maintained in a way that prevents water from intruding under the plastic and prevents the plastic cover from being damaged by wind. Plastic coverings shall be placed with at least a 12-inch overlap of all seams and be a minimum of 6 mils thick. Soil stabilization and energy dissipation BMPs shall be used to minimize the erosive energy flows coming off sloped areas of plastic (e.g., toe of slope). When feasible, the Contractor shall prevent clean runoff from plastic from hitting bare soil. Flows from plastic shall be directed to stabilized outlet areas.

Containment – Plastic coverings used to line concrete washout areas, contain wastewaters, or used in secondary containment to prevent spills, shall be seamless to prevent infiltration and be a minimum of 10 mils thick.

Vegetation Management – Plastic covering shall be clear when placed over areas that have been seeded, and shall be black when placed over areas where vegetation growth is to be inhibited. Plastic covering for vegetation management shall be a minimum of 4 mils thick.

8-01.3(6) Check Dams

Check dams are used as an erosion and sediment control device in channels or conveyance areas. Check dams shall be installed as soon as construction will allow, or when directed by the Engineer. The Contractor may substitute a different check dam material, in lieu of what is specified in the contract, with approval of the Engineer. Straw bales shall not be used as check dams. The check dam is a temporary or permanent structure, built across a minor channel placed perpendicular to the flow of water. Water shall not flow freely through the check dam structure. Check dams shall be constructed in a manner that creates a ponding area upstream of the dam to allow pollutants to settle, with water from increased flows channeled over a spillway in the check dam. The check dam shall be constructed to prevent erosion in the area below the spillway. The outer edges shall extend up the sides of the conveyance to prevent water from going around the check dam. Check dams shall be of sufficient height to maximize detention, without causing water to leave the ditch.

Wattles, coir logs and compost sock used as check dams shall not be trenched in and shall be installed as shown in the *Standard Plans*.

When wattles, coir logs, and compost socks are used as check dams they shall be measured and paid as check dam in accordance with Section 8-01.4 and 8-01.5.

8-01.3(6)A Coir Log

Coir logs are used as erosion and sediment control or bank stabilizing device. Coir logs shall be laid out, spaced, staked, and installed in accordance with the *Standard Plans*.

Live stakes can be used in addition to, but not as a replacement for, wooden stakes.

8-01.3(7) Stabilized Construction Entrance

Temporary stabilized construction entrance shall be constructed in accordance with the *Standard Plans*, prior to construction vehicles entering the roadway from locations that generate sediment track out on the roadway. Material used for stabilized construction entrance shall be free of extraneous materials that may cause or contribute to track out.

When the stabilized entrance no longer prevents track out of sediment or debris, the Contractor shall either rehabilitate the existing entrance to original condition, or construct a new entrance.

When the Contract requires a tire wash in conjunction with the stabilized entrance, the Contractor shall include details for the tire wash and the method for containing and treating the sediment-laden runoff as part of the TESC Plan. All vehicles leaving the site shall stop and wash sediment from their tires.

8-01.3(8) Street Cleaning

Self-propelled pickup street sweepers shall be used to remove and collect sediment and other debris from the Roadway. The street sweeper shall effectively collect these materials and prevent them from being washed or blown off the Roadway or into waters of the State. Street sweepers shall not generate fugitive dust and shall be designed and operated in compliance with applicable air quality standards.

Material collected by the street sweeper shall be disposed of in accordance with Section 2-03.3(7)C.

When allowed by the Engineer, power broom sweepers may be used in non-sensitive areas. The broom sweeper shall sweep dirt and other debris from the roadway into the work area. The swept material shall be prevented from entering or washing into waters of the State.

Street washing with water will require the concurrence of the Engineer.

8-01.3(9) Sediment Control Barriers

Sediment control barriers shall be installed in accordance with TESC Plan or manufacturer's recommendations in the areas of clearing, grubbing, earthwork or drainage prior to starting those activities.

The sediment control barriers shall be maintained until the soils are stabilized.

8-01.3(9)A Fencing

8-01.3(9)A1 High Visibility Fencing

High visibility fencing (HVF) shall be orange in color and installed along the site preservation lines shown in the Plans or as specified by the Engineer. Post spacing and attachment of the fencing material to the posts shall be as shown in the *Standard Plans*. The HVF shall not be fastened to trees.

8-01.3(9)A2 Silt Fence

Silt fence shall be black in color and used as a sediment control device to prevent sediment laden water from leaving project boundaries, to manage stormwater within the site, or to create small detention areas. Silt fence shall be installed at locations shown in the Plans. The geotextile shall be securely attached to the posts and support system. Post spacing and attachments shall be as shown in the *Standard Plans*.

Geotextile material shall be sewn together at the point of manufacture, or at a location approved by the Engineer, to form geotextile lengths as required. All sewn seams and overlaps shall be located at a support post.

Posts shall be either wood or steel. Wood posts shall have minimum dimensions of 1¼ by 1¼ inches by the minimum length shown in the Plans.

When sediment deposits reach approximately ⅓ the height of the silt fence, the deposits shall be removed and stabilized in accordance with Section 8-01.3(15).

If trenching is not feasible due to rocky soils or not advisable due to proximity to a downslope sensitive area, a different sediment control device that does not require trenching shall be used in place of silt fence.

Backup support is needed for silt fence in areas where extra strength may be required, such as the toe of steep cut or fill slopes or areas where equipment may push excessive soils toward the fence. When backup support is used, wire shall have a maximum mesh spacing of 2 inches, and the plastic mesh shall be as resistant to ultraviolet radiation as the geotextile it supports. The strength of the wire or plastic mesh shall be equivalent to or greater than as required in Section 9-33.2(1), Table 6, for unsupported geotextile (i.e., 180 lbs. grab tensile strength in the machine direction). Post spacing and attachments shall be as shown in the *Standard Plans*.

8-01.3(9)A3 High Visibility Silt Fence

High visibility silt fence (HVSF) shall be orange in color and only be used for the dual purpose of demarcating site preservation lines and a sediment control device in a location where high visibility mesh fence and black silt fence would otherwise be used together at same location. If use of HVSF is allowed the geotextile material shall meet the material requirements of Section 9-33.2(1), Table 6. Post spacing and attachments shall be as shown in the *Standard Plans*.

Backup support is needed for high visibility silt fence (HVSF) in areas where extra strength may be required, such as the toe of steep cut or fill slopes or areas where equipment may push excessive soils toward the sensitive or protected areas. When backup support is used, wire shall have a maximum mesh spacing of 2 inches, and the plastic mesh shall be as resistant to ultraviolet radiation as the geotextile it supports. The strength of the wire or plastic mesh shall be equivalent to or greater than as required in Section 9-33.2(1), Table 6, for unsupported geotextile (i.e., 180 lbs. grab tensile strength in the machine direction). Post spacing shall be as shown in the *Standard Plans*.

When sediment deposits reach approximately ⅓ the height of the silt fence, or 8 inches whichever is lower the deposits shall be removed and stabilized in accordance with Section 8-01.3(15).

8-01.3(9)B Gravel Filter, Wood Chip, or Compost Berm

Filter berms shall retain sediment and direct flows. The gravel filter berm shall be a minimum of 1 foot in height and shall be maintained at this height for the entire time they are in use. Rock material used for filter berms shall meet the grading requirements in Section 9-03.9(2), but shall not include any recycled materials as outlined in Section 9-03.21.

The wood chip berm shall be a minimum of 2 feet in height and shall be maintained at this height for the entire time they are in use.

The Compost Berm shall be constructed in accordance with the detail in the Plans. Compost shall be Medium Compost.

8-01.3(9)C Vacant

8-01.3(9)D Inlet Protection

Inlet protection shall be installed below or above, or as a prefabricated cover at each inlet grate, as shown in the Plans. Inlet protection devices shall be installed prior to beginning clearing, grubbing, or earthwork activities.

Geotextile fabric in all prefabricated inlet protection devices shall meet or exceed the requirements of Section 9-33.2, Table 1, for Moderate Survivability, and the minimum filtration properties of Table 2.

When the depth of accumulated sediment and debris reaches approximately ½ the height of an internal device or ⅓ the height of the external device (or less when so specified by the manufacturers), or as designated by the Engineer, the deposits shall be removed and stabilized on-site in accordance with Section 8-01.3(16).

Below Inlet Grate

Below Inlet Grate devices shall be prefabricated units specifically designed for inlet protection and shall remain securely attached to the drainage Structure when fully loaded with sediment and debris, or at the maximum level of sediment and debris specified by the manufacturer.

Above Inlet Grate

Above Inlet Grate devices may be silt fence, sandbags, or prefabricated units specifically designed for inlet protection.

The device shall remain securely in place around the drainage Structure under all conditions.

Inlet Grate Cover

Inlet Grate Cover devices shall be prefabricated units specifically designed for inlet protection and have the following features:

1. Be a sewn geotextile fabric unit fitted to the individual grate and completely enclosing the grate.
2. Have built-in lifting devices to allow manual access of the stormwater system.
3. Utilize an orange monofilament geotextile fabric.

Check dams or functionally equivalent devices may be used as inlet protection devices with the approval of the Engineer.

8-01.3(10) Wattles

Wattles are used as a flow control and sediment control device. Wattles shall be installed as soon as construction will allow or when designated by the Engineer. Wattle installation and trenching shall begin from the base of the slope and work uphill prior to any topsoil or compost placement. Excavated material from trenching shall be spread evenly along the uphill slope and be compacted using hand tamping or other method approved by the Engineer. On gradually sloped or clay-type soils trenches shall be 2 to 3 inches deep. On loose soils, in high rainfall areas, or on steep slopes, trenches shall be 3 to 5 inches deep, or half the thickness of the wattle, whichever is greater.

Wattles shall be laid out, spaced, and staked in accordance with the *Standard Plans*. Live stakes can be used in addition to, but not as a replacement for, wooden stakes. If trenching and staking is not possible due to rocky soils, compost socks shall be used instead of wattles.

The Contractor shall exercise care when installing wattles to ensure the method of installation minimizes the disturbance of waterways and prevents sediment or pollutant discharge into water bodies.

8-01.3(11) Outlet Protection

Outlet protection shall prevent scour at the outlets of ponds, pipes, ditches or other conveyances. All quarry spall material used for outlet protection shall be free of extraneous material and meet the gradation requirements in Section 9-13.1(5).

8-01.3(12) Compost Sock

Compost socks are used to disperse flow and sediment. Compost socks shall be installed as soon as construction will allow but before flow conditions create erosive flows or discharges from the site. Compost socks shall be installed prior to any mulching or compost placement. Compost socks shall be laced together end-to-end with coir rope or ends shall be securely overlapped to create a continuous length. Terminal ends of the continuous length shall be curved 2 to 4 feet upward into the slope to prevent concentrated flows from going around the terminal ends. Finished grades shall be of a natural appearance with smooth transitions. Compost for compost socks shall be Medium Compost.

Compost socks shall be laid out, spaced and staked in accordance with the *Standard Plans*. Live stakes can be used in addition to, but not as a replacement for, wooden stakes. If staking is not possible or if the compost sock is being used on concrete, heavy blocks or an equivalent item shall be used to weigh down and secure the sock.

The Contractor shall exercise care when installing compost socks to ensure that the method of installation minimizes disturbance of waterways and prevents sediment or pollutant discharge into water bodies. Stakes shall be removed to minimize soil disturbance.

8-01.3(13) Temporary Curb

Temporary curbs shall divert or redirect water around erodible soils.

Temporary curbs shall be installed along pavement edges to prevent runoff from flowing onto erodible slopes. Water shall be directed to areas where erosion can be controlled. Temporary curbs shall be a minimum of 4 inches in height. Temporary curb shall be installed so that ponding does not occur in the adjacent roadway.

8-01.3(14) Temporary Pipe Slope Drain

Temporary pipe slope drain shall be Corrugated Polyethylene Drain Pipe and shall be constructed in accordance with the Plans.

Water interceptor dikes or temporary curbs shall be used to direct water into pipe slope drain. The entrance to the drain may consist of a prefabricated funnel device specifically designed for application, rock, sand bags, or as approved by the Engineer.

The pipe fittings shall be water tight and the pipe secured to the slope with metal posts, wood stakes, or sand bags.

The water shall be discharged to a stabilized conveyance, sediment trap, stormwater pond, rock splash pad, or vegetated strip, in a manner to prevent erosion and maintain water quality compliance.

8-01.3(15) Maintenance

Erosion and sediment control BMPs shall be maintained or adaptively managed as required by the CSWGP until the Engineer determines they are no longer needed. When deficiencies in functional performance are identified, the deficiencies shall be rectified immediately.

The BMPs shall be inspected on the schedule outlined in Section 8-01.3(1)B for damage and sediment deposits. Damage to or undercutting of BMPs shall be repaired immediately.

In areas where the Contractor's activities have compromised the erosion control functions of the existing grasses, the Contractor shall overseed at no additional cost to the Contracting Agency.

The quarry spalls of construction entrances shall be refreshed, replaced, or screened to maintain voids between the spalls for collecting mud and dirt.

Unless otherwise specified, when the depth of accumulated sediment and debris reaches approximately ⅓ the height of the BMP the deposits shall be removed. Debris or contaminated sediment shall be disposed of in accordance with Section 2-03.3(7)C. Clean sediments may be stabilized on-site using BMPs as allowed by the Engineer.

8-01.3(16) Removal

The Contractor shall remove all temporary BMPs, all associated hardware and associated accumulated sediment deposition from the project limits prior to Physical Completion unless otherwise allowed by the Engineer. When the temporary BMP materials are made of natural plant fibers unaltered by synthetic materials the Engineer may allow leaving the BMP in place.

The Contractor shall remove BMPs and associated hardware in a way that minimizes soil disturbance. The Contractor shall permanently stabilize all bare and disturbed soil after removal of BMPs. If the installation and use of the erosion control BMPs have compacted or otherwise rendered the soil inhospitable to plant growth, such as construction entrances, the Contractor shall take measures to rehabilitate the soil to facilitate plant growth. This may include, but is not limited to, ripping the soil, incorporating soil amendments, or seeding with the specified seed.

At the request of the Contractor and at the sole discretion of the Engineer the CSWGP may be transferred back to the Contracting Agency. Approval of the Transfer of Coverage request will require the following:

1. All other Work required for Contract Completion has been completed.
2. All Work required for compliance with the CSWGP has been completed to the maximum extent possible. This includes removal of BMPs that are no longer needed and the site has undergone all Stabilization identified for meeting the requirements of Final Stabilization in the CSWGP.
3. An Equitable Adjustment change order for the cost of Work that has not been completed by the Contractor.
4. Submittal of the Washington State Department of Ecology Transfer of Coverage form (Ecology Form ECY 020-87a) to the Engineer.

If the Engineer approves the transfer of coverage back to the Contracting Agency the requirement in Section 1-07.5(3) for the Contractor's submittal of the Notice of Termination form to Ecology will not apply.

8-01.4 Measurement

8-01.4(1) Lump Sum Bid for Project (No Unit Items)

When the Bid Proposal contains the item "Erosion Control and Water Pollution Prevention" there will be no measurement of unit or force account items for Work defined in Section 8-01 except as described in Sections 8-01.4(3) and 8-01.4(4). Also, except as described in Section 8-01.4(3), all of Sections 8-01.4(2) and 8-01.5(2) are deleted.

8-01.4(2) Item Bids

When the Proposal does not contain the items "Erosion Control and Water Pollution Prevention", Sections 8-01.4(1) and 8-01.5(1) are deleted and the Bid Proposal will contain some or all of the following items measured as noted.

ESC lead will be measured per day for each day that an inspection is made and a report is filed.

Erosion control blanket and plastic covering will be measured by the square yard along the ground slope line of surface area covered and accepted.

Turbidity curtains will be measured by the linear foot along the ground line of the installed curtain.

Check dams will be measured per linear foot one time only along the ground line of the completed check dam. No additional measurement will be made for check dams that are required to be rehabilitated or replaced due to wear.

Stabilized construction entrances will be measured by the square yard by ground slope measurement for each entrance constructed.

Tire wash facilities will be measured per each for each tire wash installed.

Street cleaning will be measured by the hour for the actual time spent cleaning pavement, refilling with water, dumping and transport to and from cleaning locations within the project limits, as authorized by the Engineer. Time to mobilize the equipment to or from the project limits on which street cleaning is required will not be measured.

Inlet protections will be measured per each for each initial installation at a drainage structure.

Silt fence, gravel filter, compost berms, and wood chip berms will be measured by the linear foot along the ground line of the completed barrier.

Wattles and compost socks will be measured by the linear foot.

Temporary curbs will be measured by the linear foot along the ground line of the completed installation.

Temporary pipe slope drains will be measured by the linear foot along the flow line of the pipe.

Coir logs will be measured by the linear foot along the ground line of the completed installation.

Outlet protections will be measured per each initial installation at an outlet location.

Temporary seeding, temporary mulching, and tackifiers will be measured by the acre by ground slope measurement.

Compost blanket will be measured by the square yard by ground slope surface area covered and accepted.

8-01.4(3) Reinstating Unit Items with Lump Sum Erosion Control and Water Pollution Prevention

The Contract Provisions may establish the project as lump sum, in accordance with Section 8-01.4(1) and also include one or more of the items included above in Section 8-01.4(2). When that occurs, the corresponding measurement provision in Section 8-01.4(2) is not deleted and the Work under that item will be measured as specified.

8-01.4(4) Items not included with Lump Sum Erosion Control and Water Pollution Prevention

Compost blanket will be measured by the square yard by ground slope surface area covered and accepted.

Temporary mulch will be measured by the acre by ground slope surface area covered and accepted.

High visibility fence will be measured by the linear foot along the ground line of the completed fence.

8-01.5 Payment

8-01.5(1) Lump Sum Bid for Project (No Unit Items)

Payment will be made for the following Bid item when it is included in the Proposal:

"Erosion Control and Water Pollution Prevention", lump sum.

The lump sum Contract price for "Erosion Control and Water Pollution Prevention" shall be full pay to perform the Work as described in Section 8-01 except for costs compensated by Bid Proposal items inserted through Contract Provisions as described in Section 8-01.4(2). Progress payments for the lump sum item "Erosion Control and Water Pollution Prevention" will be made as follows:

1. The Contracting Agency will pay 15 percent of the bid amount for the initial set up for the item. Initial set up includes the following:
    a. Acceptance of the TESC Plan provided by the Contracting Agency or submittal of a new TESC Plan,
    b. Submittal of a schedule for the installation of the BMPs,
    c. Identifying water quality sampling locations, and
2. Seventy percent of the bid amount will be paid in accordance with Section 1-09.9.
3. Once the project is physically complete and copies of the all reports submitted to Ecology have been submitted to the Engineer, and, if applicable, transference of the CSWGP back to the Contracting Agency is complete, the remaining 15 percent of the bid amount shall be paid in accordance with Section 1-09.9.

8-01.5(2) Item Bids

"ESC Lead", per day.

"Turbidity Curtain", per linear foot.

"Erosion Control Blanket", per square yard.

"Plastic Covering", per square yard.

"Check Dam", per linear foot.

"Inlet Protection", per each.

"Gravel Filter Berm", per linear foot.

"Stabilized Construction Entrance", per square yard.

"Street Cleaning", per hour.

"Silt Fence", per linear foot.

"Wood Chip Berm", per linear foot.

"Compost Berm", per linear foot.

"Wattle", per linear foot.

"Compost Sock", per linear foot.

"Coir Log", per linear foot.

"Temporary Curb", per linear foot.

"Temporary Pipe Slope Drain", per linear foot.

"Temporary Seeding", per acre.

"Temporary Mulching", per acre.

"Compost Blanket", per square yard.

"Outlet Protection", per each.

"Tackifier", per acre.

"Erosion/Water Pollution Control", by force account as provided in Section 1-09.6.

Maintenance and removal of erosion and water pollution control devices including removal and disposal of sediment, stabilization and rehabilitation of soil disturbed by these activities, and any additional Work deemed necessary by the Engineer to control erosion and water pollution will be paid by force account in accordance with Section 1-09.6.

To provide a common Proposal for all Bidders, the Contracting Agency has entered an amount in the Proposal to become a part of the Contractor's total Bid.

8-01.5(3) Reinstating Unit Items with Lump Sum Erosion Control and Water Pollution Prevention

The Contract may establish the project as lump sum, in accordance with Section 8-01.4(1) and also reinstate the measurement of one or more of the items described in Section 8-01.4(2), except for Erosion/Water Pollution Control, by force account. When that occurs, the corresponding payment provision in Section 8-01.5(2) is not deleted and the Work under that item will be paid as specified.

8-01.5(4) Items not included with Lump Sum Erosion Control and Water Pollution Prevention

Payment will be made for the following Bid item when it is included in the Proposal:

"High Visibility Fence", per linear foot.

8-02 Roadside Restoration

8-02.1 Description

This Work consists of preserving, maintaining, establishing and augmenting vegetation on the roadsides and within mitigation or sundry site areas. It includes vegetation preservation, weed and pest control, furnishing and placing topsoil, compost, and soil amendments, and furnishing and planting seed, sod and plants of all forms and container types. It includes performing plant establishment activities and soil bioengineering. Work shall be performed in accordance with these Specifications and as shown in the Plans or as designated by the Engineer.

Trees, whips, shrubs, ground covers, cuttings, live stakes, live poles, live branches, rhizomes, tubers, rootstock, and seedlings will hereinafter be referred to collectively as “plants” or “plant material”. Grass, wildflowers, and other plant materials installed in seed form will hereinafter be referred to collectively as “seed”.

8-02.2 Materials

Materials shall meet the requirements of the following sections:

Topsoil	9-14.2
Seed	9-14.3
Fertilizer	9-14.4
Mulch and Amendments	9-14.5
Erosion Control Devices	9-14.6
Plant Materials	9-14.7
Stakes, Guys, and Wrapping	9-14.8
Water	9-25.2

Botanical identification and nomenclature of plant materials shall be based on descriptions by Hitchcock and Cronquist in “Flora of the Pacific Northwest”. Botanical identification and nomenclature of plant material not found in "Flora" shall be based on Bailey in “Hortus Third” or superseding editions and amendments or as referenced in the Plans.

8-02.3 Construction Requirements

8-02.3(1) Responsibility During Construction

The Contractor shall prepare, install, and ensure adequate and proper care of all roadside seeded, planted, and lawn areas on the project until all plant establishment periods required by the Contract are complete or until Physical Completion of the project, whichever is last.

Adequate and proper care shall include, but is not limited to, keeping all plant material in a healthy, growing condition by watering, pruning, and other actions deemed necessary for plant health. This Work shall include keeping the project area free from insect infestation, weeds or unwanted vegetation, litter, and other debris along with retaining the finished grades and mulch in a neat uniform condition.

Existing desirable vegetation shall be saved and protected unless removal is required by the Contract or allowed by the Engineer.

The Contractor shall have sole responsibility for the maintenance and appearance of the roadside restoration.

8-02.3(2) Work Plans

Three Work Plan submittals exist under this section:

1. Roadside Work Plan: This plan is required when Work will disturb the roadside beyond 20 feet from the pavement or where trees or native vegetation will be removed, the Contractor shall submit a Type 2 Working Drawing.
2. Weed and Pest Control Plan: This plan is required when the proposal contains the item “Weed and Pest Control,” and prior to application of any chemicals or weed control activities, the Contractor shall submit a Type 2 Working Drawing.
3. Plant Establishment Plan: This plan is required when the proposal contains the item “PSIPE__”, and prior to completion of Initial Planting, the Contractor shall submit a Type 2 Working Drawing.

8-02.3(2)A Roadside Work Plan

The Roadside Work Plan shall define the expected impacts to the roadside and restoration resulting from Work necessary to meet all Contract requirements. The Contractor shall define how the roadside restoration Work included in the Contract will be phased and coordinated with project Work such as earthwork, staging, access, erosion and water pollution control, irrigation, etc. The Roadside Work Plan shall include the following:

1. Limiting impacts to roadsides:
    a. Limits of Work including locations of staging or parking.
    b. Means and methods for vegetation protection (in accordance with Section 1-07.16(2)).

c. Locations outside of clearing limits where vegetation shall be removed to provide access routes or other needs to accomplish the Work.

d. Plans for removal, preservation and stockpile of topsoil or other native materials, if outside of clearing and grubbing limits and within the project limits.

2. Roadside Restoration:

a. Plan for propagation and procurement of plants, ground preparation for planting, and installation of plants.

b. Means and methods to limit soil compaction where seeding and planting are to occur, such as steel plates, hog fuel access roads, wood mats for sensitive areas (including removal) and decompaction for unavoidable impacts.

c. Plan and timing to incorporate or remove erosion control items.

3. Lawn Installation:

a. Schedule for lawn installation work.

b. Establishment and maintenance of lawns.

8-02.3(2)B Weed and Pest Control Plan

The Weed and Pest Control Plan shall describe all weed and pest control needs for the project.

The plan shall be prepared and signed by a licensed Commercial Pest Control Operator or Consultant. The plan for control of weeds and pests on the Contract in accordance with Section 8-02.3(3) shall include the following:

1. Names of plan preparer and pesticide operators, including contact information. The Contractor shall furnish the Engineer evidence that all operators are licensed with appropriate endorsements, and that the pesticide used is registered for use by the Washington State Department of Agriculture.

2. Means and methods of weed control, including mechanical and/or chemical.

3. Schedule for weed control including re-entry times for pesticide application by pesticide type.

4. Proposed pesticide use in accordance with Section 8-02.3(3)A: name, application rate, and Safety Data Sheets of all proposed pesticides. Include a copy of the current product label for each pesticide to be used.

5. Plan to ensure worker safety until pesticide re-entry periods are met.

8-02.3(2)C Plant Establishment Plan

The Plant Establishment Plan shall describe activities necessary to ensure continued health and vigor of planted and seeded areas in accordance with the requirements of Sections 8-02.3(12) and 8-02.3(13). Should the plan become unworkable at any time during the first-year plant establishment, the Contractor shall submit a revised plan prior to proceeding with further Work. The Plant Establishment Plan shall include:

1. Proposed scheduling of joint inspection meetings, activities, materials, equipment to be utilized for the first-year plant establishment.
2. Proposed adaptive management activities to ensure successful establishment of seeded, sodded, and planted areas.
3. A contact person.
4. Management of the irrigation system, when applicable.

8-02.3(3) Weed and Pest Control

The Contractor shall control weed and pest species within the project area using integrated pest management principles consisting of mechanical, biological, and chemical controls that are outlined in the Weed and Pest Control Plan or as designated by the Engineer. Controlling weeds consists of killing and removing weeds by chemical, mechanical, and hand methods.

8-02.3(3)A Chemical Pesticides

Chemical pesticides include, but are not restricted to, any substance or mixture of substances intended for preventing, destroying, repelling or mitigating any pest, including but not limited to, insecticides, herbicides, fungicides, adjuvants, and additives, including plant regulators, defoliants and desiccants. The Contractor shall apply chemical pesticides in accordance with the label recommendations, the Washington State Department of Ecology, local sensitive area ordinances, and Washington State Department of Agriculture laws and regulations. Only those pesticides listed in the table Herbicides Approved for Use on WSDOT Rights of Way and accepted as part of the Weed and Pest Control Plan or by written authorization from the Engineer may be used (www.wsdot.wa.gov/maintenance/roadside/herbicide_use.htm).

The applicator shall be licensed by the State of Washington as a Commercial Applicator or Commercial Operator, with additional endorsements as required by the Special Provisions or the proposed weed control plan. All chemical pesticides shall be delivered to the job site in the original containers, or if pre-mixed off-site, a certification of the components and formulation from the supplier is required. The licensed applicator or operator shall complete WSDOT Form 540-509, Commercial Pesticide Application Record, each day the pesticide is applied and furnish a copy to the Engineer by the following business day.

The Contractor shall ensure confinement of the chemicals within the designated areas. The use of spray chemical pesticides shall require the use of anti-drift and activating agents and a spray pattern indicator unless otherwise allowed by the Engineer.

The Contractor shall assume all responsibility for rendering any area unsatisfactory for planting by reason of chemical application. Damage to adjacent areas, either on or off the Highway Right of Way, shall be repaired to the satisfaction of the Engineer or the property owner at no additional cost to the Contracting Agency.

8-02.3(3)B Planting and Lawn Area Weed Control

Planting and lawn area weed control consists of controlling weeds and pests in planted and lawn areas shown in the Plans. This Work is included in the bid items for planting and lawn installation.

All planting and lawn areas shall be prepared so that they are weed and debris free at the time of planting and until completion of the project. The planting areas shall include the entire ground surface, regardless of cover, areas around plants, and those areas shown in the Plans.

Within planting or lawn areas, all species that are not shown in the Plans are unwanted and shall be controlled unless specifically allowed by the Engineer to remain.

Grass growing within the mulch ring of a plant, including grass applied in accordance with Sections 8-01.3(2)A, 8-02.3(9) or 8-02.3(10), shall be considered a weed and shall be controlled on the project in accordance with the weed and pest control plan.

All applications of post-emergent herbicides shall be made while green and growing tissue is present. Residual herbicides shall not be used where rhizomatous species or perennial species are indicated.

Should unwanted vegetation reach the flowering and seed stage in violation of these Specifications, the Contractor shall physically remove and bag the seed heads prior to seed dispersion. All physically removed vegetation and seed heads shall be disposed of off-site at no cost to the Contracting Agency.

8-02.3(3)C Project Area Weed and Pest Control

The Contractor shall control weeds not otherwise covered in accordance with Section 8-02.3(3)B, in all areas within the project limits, including erosion control seeding areas and vegetation preservation areas, as designated by the Engineer.

When the Bid Item “Project Area Weed and Pest Control” is included in the Contract, the Contractor shall also control all weeds specified as noxious by the Washington State Department of Agriculture, the local Weed District, or the County Noxious Weed Control Board outside of planting areas within the project limits.

8-02.3(4) Topsoil

Topsoil shall not be worked or placed when the ground or topsoil is frozen, or excessively wet.

The Contractor shall protect topsoil stockpiled for project use to prevent erosion and weed growth. Weed growth on topsoil stockpile sites shall be immediately eliminated in accordance with the accepted Weed and Pest Control Plan and Section 8-02.3(3)C.

The subsoil where topsoil is to be placed shall be tilled to a depth of 1 foot or as specified in the Special Provisions or the Plans. Topsoil of the type specified shall be evenly spread over the specified areas to the depth shown in the Plans or as otherwise ordered by the Engineer. Topsoil depths greater than 6 inches shall be placed in lifts no more than 6 inches in depth. The first lift of topsoil shall be incorporated with sub-soil to a depth of 8 inches and subsequent lifts placed and lightly tamped between lifts. After the topsoil has been spread, all large clods, hard lumps, and rocks 2 inches in diameter and larger, and litter shall be raked up, removed, and disposed.

8-02.3(4)A Topsoil Type A

Topsoil Type A shall be as specified in the Special Provisions. The Contractor shall submit a certification by the supplier that the contents of the Topsoil meet the requirements in the Special Provisions.

8-02.3(4)B Topsoil Type B

Topsoil Type B shall be taken from within the project limits. Topsoil Type B shall be taken from areas shown in the Plans to the designated depth and stockpiled at locations that will not interfere with the construction of the project, and outside of sensitive areas, as allowed by the Engineer. The general limits of the material to be utilized for topsoil will be indicated in the Plans or in the Special Provisions. The Engineer will make the final determination of the areas where the most suitable material exists within these general limits. Material for Topsoil Type B shall not be taken from a depth greater than 1 foot from the existing ground unless otherwise designated by the Engineer. Prior to topsoil removal, the Contractor shall reduce the native vegetation to a height not exceeding 1 foot. A minimum of two weeks prior to excavation of Topsoil Type B, the Contractor shall pre-treat the vegetation on the designated Topsoil Type B areas according to the Weed and Pest Control Plan. Areas beyond the slope stakes shall be disturbed as little as possible in the above operations and under no circumstances shall Topsoil Type B be stockpiled within 10 feet of any existing tree or vegetation area designated to be saved and protected. The Contractor shall protect topsoil stockpile from weed infestation.

The Contractor shall set aside sufficient material to satisfy the needs of the project.

Upon completion of topsoil placement, the Contractor shall dispose of remaining stockpiled Topsoil Type B not required for use on the project at no additional expense to the Contracting Agency in accordance with Section 2-03.3(7)C.

Should a shortage of Topsoil Type B occur, and the Contractor has wasted or otherwise disposed of topsoil material, the Contractor shall furnish Topsoil Type A or C at no additional expense to the Contracting Agency.

8-02.3(4)C Topsoil Type C

Topsoil Type C shall be naturally occurring topsoil obtained from a source provided by the Contractor outside of the Contracting Agency-owned Right of Way. Topsoil Type C shall meet the requirements of Sections 8-02.3(4) and 8-02.3(4)B. The Contractor shall not begin removal of Topsoil Type C from the proposed source until the material has been allowed for use by the Engineer.

8-02.3(5) Roadside Seeding, Lawn and Planting Area Preparation

This Work includes preparing worked areas for the installation of all types of permanent erosion control planting. Work shall be conducted so the flow lines in drainage channels are maintained. Material displaced by the Contractor's operations that interferes with drainage shall be removed from the channel and disposed of as allowed by the Engineer.

8-02.3(5)A Seeding Area Preparation

The Contractor shall prepare roadside seeding areas as follows:

1. Remove all excess material, debris, stumps, and rocks greater than 3 inches in diameter from areas to be seeded. Dispose of removed materials offsite.
2. Prepare roadside seeding area to a weed free and bare condition.
3. Bring area to uniform grade and install topsoil, soil amendments, or compost as specified. Any slopes 3(H) to 1(V) or steeper shall not be tilled unless otherwise specified.
4. Compact to provide a reasonably firm but friable seedbed; tractor walk to uniformly cover the surface with longitudinal depressions at least 2 inches deep formed perpendicular to the natural flow of water on the slope. Condition the soil with sufficient water so the longitudinal depressions remain in the soil surface until completion of the seeding.
5. Seed and mulch within 2 days of preparation.

8-02.3(5)B Lawn Area Preparation

The Contractor shall prepare lawn areas as follows:

1. Prepare lawn area to a weed free and bare condition in accordance with Section 8-02.3(3)B.
2. Remove excess material, stumps, wood or rocks over 3 inches in diameter and remove from site.
3. Bring area to uniform grade and install topsoil or soil amendments in accordance with Section 8-02.3(4) and 8-02.3(6).

4. Till to an 8-inch depth, rake to a smooth even grade without low areas that trap water, and compact with a 50-pound roller. The finished grade of the soil shall be 1 inch below the top of all curbs, junction and valve boxes, walks, driveways, and other Structures.
5. Seed or sod the area within two days of preparation.

8-02.3(5)C Planting Area Preparation

The Contractor shall prepare planting areas as follows:

1. Prepare planting area to a weed free and bare condition in accordance with Section 8-02.3(3)B.
2. Decompact soil to a depth of 18 inches where construction activities have taken place or where native soils are compacted.
3. Return soil to uniform grade even with surrounding areas, leaving no holes or mounds over 3 inches in depth or height.
4. Remove excess material, stumps, wood or rocks over 3 inches in diameter and remove from site.
5. Apply compost or other amendments as indicated in the plans and in accordance with Section 8-02.3(6).
6. Cultivate amendments to a depth of 12 inches to provide a reasonably firm but friable planting area. Do not till any slopes 3(H) to 1(V) or steeper.
7. Return soil to a uniform finished grade, 1 inch, or the specified depth of mulch plus 1 inch, below walks, curbs, junction and valve boxes, catch basins, and driveways, unless otherwise specified.
8. Begin planting and mulching the area within two days of final preparation.

8-02.3(6) Mulch and Amendments

The Contractor shall place soil amendments of the type, quality, and quantities specified where shown in the Plans or as specified in the Special Provisions. Areas receiving soil amendments shall be bare soil or vegetation free prior to application. All soil amendments shall be installed as shown in the Plans within 30 calendar days after delivery to the project site.

8-02.3(6)A Compost

Compost used for soil amendments shall be Fine Compost unless otherwise designated in the Plans. When compost blanket is used for temporary erosion control, the compost blanket may be incorporated into the soil immediately prior to planting when used as compost soil amendment. The area shall be prepared in accordance with Section 8-02.3(5) prior to placing compost.

8-02.3(6)B Fertilizers

The Contractor shall apply fertilizer in the form, mixture, and rate specified in the Special Provisions or as directed by the Engineer. Application procedures shall be in accordance with the manufacturer's recommendations unless otherwise specified in the Special Provisions.

The Contractor shall submit a guaranteed fertilizer analysis label for the selected product a minimum of one week prior to application for acceptance. Following the Engineer's acceptance, fertilizing of the accepted ground or vegetated surfaces shall begin immediately.

In seeding and lawn areas to be fertilized, the fertilizer shall be applied concurrently with the seed. When fertilizer is hydraulically applied, the fertilizer shall be suitable for application with seeding as specified in Section 8-02.3(9)C. If hydroseeding, the fertilizer shall be placed in the hydroseeder tank no more than 1 hour prior to application.

Fertilizers for planting areas shall be applied concurrently with compost and applied prior to incorporation, unless tablet form fertilizer is specified. Where tablet form fertilizer is specified, fertilizer shall be applied concurrently with plant installation.

Fertilizer sprayed on signs or sign structures shall be removed the same day.

Areas not accessible by fertilizing equipment shall be fertilized by allowed hand methods.

Second Application: A second application of fertilizer shall be applied as specified in the Special Provisions at the locations designated in the Plans. The fertilizer shall be applied during the months of March, April, or May of the following year after the initial seeding, planting, or lawn installation. The fertilizer shall be dry granular pellets or pearls and applied in accordance with the manufacturer's recommendations or as specified in the Special Provisions.

8-02.3(7) Layout of Planting, Lawn and Seeding Areas

The Contractor shall lay out and prepare planting and lawn areas and receive the Engineer's acceptance of layout and preparation prior to any installation activities. The Contractor shall stake the location of all trees larger than 1-inch caliper and the perimeter of all planting areas for acceptance by the Engineer prior to any installation activities.

The Contractor shall locate all trees to be planted in mowable grass areas a minimum of 10 feet from the edge of planting areas, other trees, fence lines, and bottom of ditches unless otherwise specified.

Tree locations shown in the Plans shall be considered approximate unless shown with stationing and offset distance. In irrigated areas, trees shall be located so their trunk is a minimum of ⅓ of the spray radius away from the nearest sprinkler head.

Unless otherwise shown, planting areas located adjacent to Roadways shall begin 6 feet from the edge of shoulder on roadway fills and begin 5 feet up on the back slope from the bottom on roadway cut sections. Plants within planting areas shall be located such

that mature branching pattern will not block sight distance, signs, or other traffic-related devices. No trees shall be placed where the mature canopy will grow to within 10 feet of existing power lines. Where roadside ditches are present, planting areas shall begin 5 feet from the centerline of the ditch unless shown otherwise in the Plans.

8-02.3(8) Planting

8-02.3(8)A Dates and Conditions for Planting

The Contracting Agency will make an inspection of plant material at the source when requested by the Engineer. However, such preliminary approval shall not be considered as final acceptance for payment. Final inspection and approval (or rejection) will only occur when the plant material has been delivered to the Contract site. The Contractor shall notify the Engineer, not less than 48 hours in advance, of plant material delivery to the project.

No plant material shall be planted until it has been inspected and accepted for planting by the Engineer. Rejected material shall be removed from the project site immediately. All plants for the project or a sufficient quantity to plant 1-acre of the site, whichever is less, shall be received on site prior to the Engineer beginning inspection of the plants.

Plants delivered as a single unit of 25 or less of the same size, species, and variety, shall be clearly marked and tagged. Plants delivered in large quantities of more than 25 must be segregated as to variety, grade, and size; and one plant in each 25, or fraction thereof, of each variety, grade, and size shall be tagged. No substitution of plant material, species or variety, will be permitted unless evidence is submitted in writing to the Engineer that a specified plant cannot be obtained and has been unobtainable since the Award of the Contract. If substitution is permitted, it can be made only with written approval by the Engineer. The nearest variety, size, and grade, as approved by the Engineer, shall then be furnished.

Container or balled and burlapped plant material may be substituted for bare root plant material. Container grown plant material may be substituted for balled and burlapped plant materials. When substitution is allowed, use current ASNS standards to determine the correct rootball volume (container or balled and burlapped) of the substituted material that corresponds to that of the specified material. These substitutions shall be approved by the Engineer and be at no cost to the Contracting Agency.

Plants stored under temporary conditions prior to installation shall be the responsibility of the Contractor.

Plants stored on the project shall be protected at all times from extreme weather conditions by insulating the roots, root balls, or containers with sawdust, soil, compost, bark or wood chips, or other approved material and shall be kept moist at all times prior to planting.

Cuttings shall continually be shaded and protected from wind. Cuttings shall be protected from drying at all times and shall be heeled into moist soil or other insulating material or placed in water if not installed within 8 hours of cutting. Cuttings to be stored for later installation shall be bundled, laid horizontally, and completely buried under 6 inches of water, moist soil or placed in cold storage at a temperature of 34°F and 90 percent humidity. Cuttings that are not planted within 24 hours of cutting shall be soaked in water for 24 hours prior to planting. Cuttings taken when the temperature is higher than 50°F shall not be stored for later use. Cuttings that already have developed roots shall not be used.

Under no circumstances will planting be permitted during unsuitable soil or weather conditions as determined by the Engineer. Unsuitable conditions may include frozen soil, freezing weather, saturated soil, standing water, high winds, heavy rains, and high water levels. All planting shall be accomplished during the following periods:

1. Non-Irrigated Plant Material

Western Washington (West of the Cascade Mountain Crest)	Eastern Washington (East of the Cascade Mountain Crest)
October 1 through March 1	October 1 through November 15

2. Irrigated Plant Material

   In irrigated areas, plant material shall not be installed until the irrigation system is fully operational and accepted by the Engineer. Trees and shrubs may be planted in irrigated areas during the non-irrigated planting window before the irrigation system is functional with the written concurrence of the Engineer only if the irrigation system is guaranteed to be operational prior to the end of the non-irrigated planting window.

8-02.3(8)B Plant Installation

The Contractor shall handle plant material in the following manner:

1. Root systems shall be kept covered and damp at all times. Plant material shall be kept in containers until the time of planting.
2. Roots shall not be bunched, curled, twisted, or unreasonably bent when placed in the planting hole. Bare root plant material shall be dormant at the time of harvesting and planting. The root systems of all bare root plant material shall be dipped in a slurry immediately prior to planting.
3. Plant material supplied in wrapped balls shall not be removed from the wrapping until the time of planting at the planting location. The root system of balled plant material shall be moist at the time of planting. Root balls shall be loosened prior to planting. All burlap, baskets, string, wire and other such materials shall be removed from the hole when planting balled plants.
4. Plant cutting material shall be dormant at the time of cutting and planting. All cuttings shall be installed immediately if buds begin to swell.

5. Plants shall be placed with the crown at the finished grade. In their final position, plants shall have their top true root (not adventitious root) no more than 1 inch below the soil surface, no matter where that root was located in the original root ball or container. The backfill material, including container and root ball soil, shall be thoroughly watered on the same day that planting occurs regardless of season.

When installing plants, the Contractor shall dig planting holes three times the diameter of the container or root ball size. Any glazed surface of the planting hole shall be roughened prior to planting.

8-02.3(8)C Pruning, Staking, Guying, and Wrapping

Plants shall be pruned at the time of planting, only to remove minor broken or damaged twigs, branches or roots. Pruning shall be performed with a sharp tool and shall be done in such a manner as to retain or to encourage natural growth characteristics of the plants. All other pruning shall be performed only after the plants have been in the ground at least 1 year and when plants are dormant.

Trees shall only be staked when so noted in the Plans. Each tree shall be staked or guyed before completion of the backfilling in accordance with the details shown in the Plans.

Commercial plant ties may be used in lieu of hose and wire guying upon concurrence of the Engineer. Trees shall be wrapped when so noted in the Plans.

8-02.3(9) Seeding, Fertilizing, and Mulching

For all seed, the Contractor shall furnish the following documentation to the Engineer:

1. The state or provincial seed dealer license and endorsements.
2. Copies of Washington State Department of Agriculture (WSDA) test results on each lot of seed. Test results shall be within six months prior to the date of application.

8-02.3(9)A Dates for Application of Seed

Unless otherwise allowed by the Engineer, the Contractor shall apply seed for permanent erosion control during the following periods:

Western Washington[1] (West of the Cascade Mountain Crest)	Eastern Washington (East of the Cascade Mountain Crest)
March 1 through May 15 September 1 through October 1	October 1 through November 15

[1]Seeding may be allowed outside these dates when allowed by the Engineer.

All roadway excavation and embankment ground surfaces that are completed to final grades shall be prepared and seeded during the first available seeding window. When environmental conditions are not conducive to satisfactory results, the Engineer may suspend the seeding Work until such time that the desired results are likely to be obtained. If seeding is suspended, temporary erosion control methods according to Section 8-01 shall be used to protect the bare soil until seeding conditions improve.

8-02.3(9)B Seeding and Fertilizing

The Contractor shall prepare the seeding area in accordance with Section 8-02.3(5)A and apply seed at the rate and mix specified in the Special Provisions. The Contractor shall notify the Engineer within 5 days in advance of any seeding operation and shall not begin the Work until areas prepared or designated for seeding have been accepted. Following the Engineer's acceptance, seeding of the accepted ground surfaces shall begin immediately.

Seeding shall not be done during windy weather or when the ground is frozen, or excessively wet.

When seeding by hand, the seed shall be incorporated into the top ¼ inch of soil by hand raking or other method that is allowed by the Engineer.

Seed applied as a separate operation using a hydroseeder shall have a tracer added to visibly aid uniform application. The tracer shall be HECP Short-Term Mulch applied at a rate of 200 to 250 pounds per acre and the tracer shall carry the measured specified seeding rate.

8-02.3(9)C Seeding with Fertilizers and Mulches

When the Proposal includes any variation of seeding, fertilizing, and mulching, the seed and fertilizer shall be applied in one application followed by mulching. West of the Cascade Mountains, seed, fertilizer, and mulch may be completely applied in one application. East of the Cascades, seeding, fertilizing, and mulching shall not be applied as a single application unless allowed by the Engineer in writing prior to application. The fertilizing and mulching shall meet the requirements of Sections 8-02.3(6) and 8-02.3(11).

8-02.3(9)D Inspection

Seeded areas will be inspected upon completion of seeding, fertilizing, and mulching. The Work in any area will not be measured for payment until a uniform distribution of the materials is accomplished at the specified rate. Areas that have not received a uniform application of seed, fertilizer, and mulch at the specified rate, as determined by the Engineer, shall be re-seeded, re-fertilized, or re-mulched prior to payment for seeding within a designated area.

8-02.3(9)E Protection and Care of Seeded Areas

The Contractor shall install and establish a stable and weed free stand of grass as specified within all designated permanent seeding areas. A stable stand of grass shall meet the following requirements:

1. A dense and uniform canopy cover, 70% for Western Washington and 50% for Eastern Washington, of specified species covers all seeded areas after 3 months of active growth following germination during the growing season. Canopy cover is defined as the cover of living and vigorous grass blades, leaves, and shoots of specified species. Volunteer species, weeds, woody plants, or other undesirable

vegetation shall not factor into the canopy cover. Growth and establishment may require supplemental irrigation to meet cover requirements.

2. Stand health is evident by vigorously growing planted species having a uniform rich-green appearance and with no dead patches or major gaps of growth. A stand of grass that displays rusting, wilting, stunted growth, disease, yellowing or browning of leaves, or bare patches does not meet the stand health requirement.
3. The Contractor shall establish a stable stand of grass free of all weeds, non-specified grasses, and other undesirable vegetation. Weed control shall be in accordance with the Weed and Pest Control Plan and occur on a monthly basis during the establishment period and through the life of the Contract.
4. Remove all trash, rocks, construction debris, and other obstructions that may be detrimental to the continued establishment of future seeding.

In addition to the requirements of Section 1-07.13(1), restoration of eroded areas including clean up, removal, and proper disposal of eroded material, filling and raking of eroded areas with Topsoil Type A or fine compost, and re-application of the specified seed, fertilizer, and mulch shall occur at no additional cost to the Contracting Agency.

8-02.3(10) Lawn Installation

8-02.3(10)A Dates and Conditions for Lawn Installation

In irrigated areas, lawn installation shall not begin until the irrigation system is fully operational.

Unless otherwise allowed by the Engineer, seeded lawn installation shall be performed during the following time periods at the location shown:

Western Washington (West of the Cascade Mountain Crest)	Eastern Washington (East of the Cascade Mountain Crest)
March 1 through May 15 September 1 through October 1	October 1 through November 15
When irrigation system is operational March 1 through October 1	When irrigation system is operational March 1 through November 1

8-02.3(10)B Lawn Seeding and Sodding

The Contractor shall prepare the lawn area in accordance with Section 8-02.3(5) and apply seed at the mix and rate of application as specified in the Special Provisions.

The Contractor shall have the option of sodding in lieu of seeding for lawn installation at no additional expense to the Contracting Agency. The available grass mixtures on the current market shall be submitted to the Engineer for selection and acceptance. Seeding in lieu of sodding will not be allowed.

Seed placed by hand shall be raked into the soil. Following raking, the seeded soil shall be rolled with a smooth 50-pound roller. Sod strips shall be placed within 48 hours of

being cut. Placement shall be without voids and have the end joints staggered. Following placement, the sod shall be rolled with a smooth roller to establish contact with the soil.

Barriers shall be erected, with warning signs where necessary, to preclude pedestrian traffic access to the newly placed lawn during the establishment period.

8-02.3(10)C Lawn Establishment

Lawn establishment shall consist of caring for all new lawn areas within the limits of the project.

The lawn establishment period shall begin immediately after the lawn seeding or sodding has been accepted by the Engineer and shall extend to the end of four mowings or 20 working days whichever is longer. The mowings shall be done in accordance with Section 8-02.3(10)D.

During the lawn establishment period, the Contractor shall ensure the continuing healthy growth of the turf. This care shall include keeping the project in a presentable condition including, but not limited to, removal of litter, mowing, trimming, removal of grass clippings, edging, fertilization, insecticide and fungicide applications, weed control, watering, repairing the irrigation system, and repair and reseeding all damaged areas.

Temporary barriers shall be removed only when directed by the Engineer.

All Work performed under lawn establishment shall comply with established turf management practices.

Acceptance of lawn planting as specified will be based on a uniform stand of grass and a uniform grade at the time of final inspection. The Contractor shall recultivate, re-grade, reseed, and refertilize areas that are bare or have a poor stand of grass or not having a uniform grade through any cause before final inspection at no additional cost to the Contracting Agency.

8-02.3(10)D Lawn Mowing

Lawn mowing shall begin immediately after the lawn establishment period has been accepted by the Engineer and shall extend to the end of the Contract or the first-year plant establishment, whichever is last.

The Contractor shall accomplish the following minimum requirements:

1. Mow, trim, and edge as often as conditions dictate, at a minimum, once per week between April and September. Maximum height of lawn shall not exceed 3 inches. The cutting height shall be 2 inches. Cuttings, trimmings, and edgings shall be disposed of off the project site. When the Engineer allows the use of a mulching mower, trimmings may be left in place.
2. Water as often as conditions dictate depending on weather and soil conditions.
3. Provide fertilizer, weed control, water, and other measures as necessary to establish and maintain a healthy stand of grass.

8-02.3(11) Mulch

Mulches associated with seeding and planting shall be of the type specified in the Special Provisions or as indicated in the Plans. The Contractor shall evenly apply mulch at the rates indicated in the Plans. Mulches shall not be placed below the anticipated water level of ditch slopes, pond bank slopes, and stream banks, or in areas of standing or flowing water.

8-02.3(11)A Mulch for Seeding Areas

The Contractor shall furnish and evenly apply Hydraulically Applied Erosion Control Product (HECP) Long Term Mulch at the rates indicated and in accordance with the Manufacturer's specifications unless otherwise specified.

HECP Long Term Mulch shall be hydraulically applied at the rate of 3500 pounds per acre with no more than 2000 pounds applied in any single lift. HECP mulch shall not be used within the Ordinary High Water Mark.

Mulch sprayed on signs or sign Structures shall be removed the same day.

Areas not accessible by mulching equipment shall be mulched by accepted hand methods.

HECP Long Term Mulch may be applied with seed and fertilizer west of the summit of the Cascade Range. East of the summit of the Cascade Range, seed and fertilizer shall be applied in a single application followed by the application of mulch.

8-02.3(11)B Bark or Woodchip Mulch

The Contractor shall apply bark or wood chip mulch of the type and depth specified where shown in the Plans or as specified in the Special Provisions.

The Contractor shall complete final grading and placement/incorporation of soil amendments within the planting area prior to placement of mulch. Areas receiving bark mulch shall be bare soil or vegetation free before application, except where trees and other plants are specifically identified in the Plans or designated by the Engineer to be saved and protected.

Bark or wood chip mulch shall be placed to a uniform non-compacted depth of 3 inches over all planting areas unless otherwise specified. Mulch shall be feathered to the base of the plant and 1 inch below the top of junction and valve boxes, curbs, and pavement edges.

Any contamination of the mulch due to the Contractor's operations shall be corrected to its former condition at no additional cost to the Contracting Agency. Mulch placed to a thickness greater than specified shall be at no additional cost to the Contracting Agency.

The Contractor shall keep plant material crowns, runners, and branches free of mulch at all times.

8-02.3(11)C Bark or Woodchip Mulch Rings

The Contractor shall apply mulch rings around plants installed within existing vegetation areas or within seeded areas as shown in the Plans. Bark or wood chip mulch rings shall be applied to the surface of vegetation free amended soil in the isolated plant locations where shown in the Plans or as specified in the Special Provisions. Bark or wood chip mulch shall be placed to a uniform non-compacted depth of 3 inches to a radius of 2 feet around all plants within interplanted plant locations.

8-02.3(12) Completion of Initial Planting

Upon completion of the initial planting within a designated area, the Engineer will make an inspection of all planting areas. The Engineer will notify the Contractor, in writing, of any replacements or corrective action necessary to meet the plant installation requirements. The Contractor shall replace all materials rejected or missing and correct unsatisfactory conditions.

Completion of the initial planting within a designated area includes the following conditions:

1. 100 percent of each of the plant material categories are installed as shown in the Plans.
2. Planting Area is cleaned up.
3. Repairs are completed, including but not limited to, full operation of the irrigation system.
4. Mulch coverage is complete.
5. All weeds are controlled.

8-02.3(13) Plant Establishment

Plant establishment consists of caring for all plants and planting areas within the project limits. The provisions of Sections 1-07.13(2) and 1-07.13(3) do not apply to this Section.

When the Proposal includes the bid item PSIPE____ (Plant Selection Including Plant Establishment), that bid item includes one year of plant establishment Work. The first year of plant establishment shall begin immediately upon written notification from the Engineer of the completion of initial planting for the project. The first-year plant establishment period shall be a minimum of one calendar year. The one calendar year shall be extended an amount equal to any periods where the Contractor does not comply with the plant establishment requirements and plan.

During the first-year plant establishment period, the Contractor shall perform all Work necessary to ensure the resumption and continued growth of the transplanted material. This Work shall include, but is not limited to, applying water, removing foreign, dead, or rejected plant material, maintaining all planting areas in a weed-free condition, and replacing all unsatisfactory plant material planted under the Contract. If plants are stolen or damaged by the acts of others, the Contracting Agency will pay invoice cost only for

the replacement plants with no mark-up and the Contractor will be responsible for the labor to install the replacement plants. Other weed control within the project limits but outside of planting, lawn, or seeding areas shall be as specified in Section 8-02.3(3)C.

During the first year of plant establishment, the Contractor shall meet monthly or at an agreed upon schedule with the Engineer for the purpose of joint inspection of the planting material. The Contractor shall correct all unsatisfactory conditions identified by the Engineer within a 10-day period immediately following the inspection. If plant replacement is required, the Contractor shall, within the 10-day period, submit a plan and schedule for the plant procurement and replacement to occur during the planting period as designated in Section 8-02.3(8). At the end of the plant establishment period, plants that do not show normal growth shall be replaced and all staking and guying that remain on the project shall be removed unless otherwise allowed by the Engineer.

All automatic irrigation systems shall be operated fully automatic during the plant establishment period and until final acceptance of the Contract. Payment for water used to water in plants, or hand watering of plant material or lawn areas unless otherwise specified, is the responsibility of the Contractor during the first-year plant establishment period.

Subsequent year plant establishment periods shall begin immediately at the completion of the preceding year's plant establishment period. Each subsequent plant establishment period shall be one full calendar year in duration.

During the plant establishment period(s) after the first year plant establishment, the Work necessary for the continued healthy and vigorous growth of all plants material shall be performed as directed by the Engineer.

Payment for water used to water plants during the subsequent year(s) of plant establishment will be paid under the plant establishment item.

8-02.3(14) Plant Replacement

The Contractor shall be responsible for growing or arrange to provide sufficient plants for replacement of all plant material rejected through first-year plant establishment. All replacement plant material shall be inspected and accepted by the Engineer prior to installation. All rejected plant material shall be replaced with acceptable plants meeting the specifications and installed according to the requirements of this section at dates allowed by the Engineer.

All replacement plants shall be of the same species as the plants they replace and meet the requirements of Section 9-14.8 unless otherwise allowed by the Engineer. Plants may vary in size reflecting one season of growth should the Contractor elect to hold plant material under nursery conditions for an additional year to serve as replacement plants. Replacement plant material larger than specified in the Plans shall meet the applicable section requirements of the ASNS for container class, ball size, spread, and branching characteristics.

8-02.3(15) Bioengineering

Bioengineering consists of using plant materials for the purpose of streambank or earthen slope construction and surface stabilization. This Work may include installing woody plant cuttings in various forms as well as part of streambank or earthen slope construction.

8-02.3(15)A Live Fascines

Live fascines shall be constructed of live and dead cuttings bundled together with a diameter of 8 to 18 inches. Live cuttings shall be the species shown in the Plans. Dead branches may be cuttings from any woody, non-invasive plant native to the project area. Dead branches may be placed within the live fascine and on the side exposed to the air. Live branches shall be placed in contact with the soil along their entire length. Each live fascine must contain a minimum of eight live branches. Dead branches shall constitute no more than 40 percent of the total fascine content.

The total length of each live fascine shall be a minimum of 5 feet. Branches shall be bundled into log-like forms and bound with biodegradable twine spaced at 1-foot intervals along the entire length of the live fascine. Live fascines shall be installed horizontally in a trench whose depth shall be ½ the diameter of the live fascine. Secure the live fascine with live stakes 3 feet in length and ¾ inch in diameter placed at 18-inch intervals. A minimum of three live stakes shall be used per fascine. The live stakes shall be driven through the live fascine vertically into the slope. The ends of live fascines shall be woven together so that no gap remains between the two sections of the live fascine.

Prior to being covered with soil, the fascine shall be thoroughly watered. Once the fascine is covered with 6 inches of soil, the soil covering the fascine shall be thoroughly watered.

When used to remedy erosion areas, live fascines shall extend a minimum of two feet beyond the visible area of erosion and soil disturbance. The locations for live fascines and live stake rows shall be identified in the field for review and acceptance by the Engineer. The Engineer may require adjustment of fascine locations prior to installation in order to best accomplish the intended functions.

Plant replacement during plant establishment for “PSIPE Live Fascine” will be required for any section void of live shoots for a length of 3 feet or more. Replacement shall consist of installing live stakes, spaced 1 foot apart above the fascine within the area void of live shoots. Live stakes shall be of the same species as the live fascine and shall have a minimum length of 3 feet and a minimum diameter of ¾ inch. The requirements of Section 8-02.3(8) apply to PSIPE Live Fascine.

8-02.3(15)B Brush Mattress

Live brush mattress shall be constructed of live branch cuttings, live poles, jute rope and topsoil. The live cuttings and live poles shall be from the plant species designated in the Plans. Live branch cuttings shall be placed with the cut ends oriented down slope as shown in the Plans. Cuttings shall overlap from side to side and from top to bottom as each layer is constructed. The live branches in each succeeding upper layer shall overlap the adjacent lower layer by a minimum of 6 inches. A maximum of 20 percent of the

branches may be dead branches, but the live branches shall be distributed evenly to provide even rooting and growth over the entire area of the brush mattress.

The Contractor shall anchor the live brush mattress to the slope using stakes and jute rope as shown in the Plans. Initially, the stakes shall be installed to protrude above the live brush mattress. The Contractor shall attach the jute rope to the stakes and tighten the rope by tamping the stakes further into the bank, pulling the live brush mattress tight against the soil surface. The Contractor shall cover the live brush mattress with sufficient stockpiled topsoil to ensure good soil contact with the live plant material.

Plant replacement during plant establishment for "PSIPE Live Brush Mattress" will be required for any section void of live shoots for an area of 25 square feet or more. Replacement shall consist of installing live stakes, spaced 3 feet apart in a triangular pattern within the area void of live shoots. Live stakes shall be of the same species as the live brush mattress and shall have a minimum length of 3 feet and a minimum diameter of ¾ inch. The requirements of Section 8-02.3(8) apply to PSIPE Brush Mattress.

8-02.3(15)C Brush Layer

Brush layers shall be constructed of live branch cuttings, randomly mixed, from the plant species listed under the brush layer heading in the Plans. The number of branches required will vary depending on the average branch diameter and layer thickness.

Brush layers shall be placed in a trench dug at a 45 degree incline into the slope or stream bank. Two-thirds to three-fourths of the length of the live branches shall be buried. Soil shall be firmly tamped in place. Succeeding layers shall be spaced as detailed in the Plans. Brush layer placed in stream banks shall be angled downstream.

Brush layers may include plant establishment when designated as PSIPE Brush Layer. Plant replacement for PSIPE Brush Layer will be required for each section void of live shoots for a continuous distance of 3 feet or more. The requirements of Section 8-02.3(8) apply to PSIPE Brush Layer.

8-02.3(16) Roadside Maintenance Under Construction

When the Contract includes the item, Roadside Maintenance Under Construction, this Work includes roadside mowing and ditch maintenance, and noxious weed control outside of planting areas according to Section 8-02.3(3)C.

8-02.3(16)A Roadside Mowing

The Contractor shall mow designated roadside grass areas to the limits designated by the Engineer. Roadside mowing is limited to slopes not steeper than 3(H) to 1(V).

The Contractor shall mow according to the following requirements:

1. Trim around traffic equipment, structures, planting areas, or other features extending above ground preceding or simultaneously with each mowing.
2. Maintain grass between 4 and 12 inches in height.

3. Operate mowing equipment with suitable guards to prevent throwing rocks or debris onto the traveled way or off of the Contracting Agency property. Power driven equipment shall not cause ruts, deformation, and compaction of the vegetated soil.
4. Removing clippings is required on the traveled way, shoulders, walkways, or Structures.
5. Restore soil rutting to a smooth and even grade at the direction of the Engineer.

8-02.3(16)B Ditch Maintenance

The Contractor shall maintain drainage for the duration of the Contract according to the following requirements:

1. Maintain flow lines in drainage channels and roadside ditches.
2. Cutting or trimming vegetation within drainage channels to maintain positive flow.
3. Remove dirt and debris from inside of culverts or any drainage area where runoff has allowed accumulations and re-seed for erosion control.
4. Restore channels to previous operational condition.

8-02.4 Measurement

Topsoil, bark or woodchip mulch and soil amendments will be measured by the acre along the grade and slope of the area covered immediately after placement. Weed control pre-treatment of topsoil areas, excavation, and stockpiling are included in the bid item "Topsoil Type ___.

Bark or woodchip mulch rings will be measured per each.

Compost will be measured by the acre or the square yard along the grade and slope of the area covered immediately after application.

Seeding, fertilizing, and mulching will be measured by the acre or the square yard by ground slope measurement or through the use of design data.

Seeding and fertilizing by hand will be measured by the square yard. No adjustment in area size will be made for the vegetation free zone around each plant.

Seeded lawn, sod installation, and lawn mowing will be measured along the ground slope and computed in square yards of actual lawn completed, established, and accepted.

Plant selection will be measured per each.

PSIPE __ (Plant Selection Including Plant Establishment) will be measured per each.

Live Pole will be measured per each.

Live Stake Row will be measured by the linear foot along the ground slope line.

The pay quantities for plant materials will be determined by count of the number of satisfactory plants in each category accepted by the Engineer.

Fascine and PSIPE live fascine will be measured by the linear foot along the ground slope line.

Brush mattress and PSIPE live brush mattress will be measured by the surface square yard along the ground slope line.

Brush layer and PSIPE brush layer will be measured by the linear foot along the ground slope line.

Water will be measured in accordance with Section 2-07.4. Measurement will be made of only that water hauled in tank trucks or similar equipment.

8-02.5 Payment

Payment will be made for each of the following listed Bid items that are included in the Proposal:

"Project Area Weed and Pest Control" will be paid in accordance with Section 1-09.6.

For the purpose of providing a common Proposal for all Bidders, the Contracting Agency entered an amount for "Project Area Weed and Pest Control" in the Proposal to become a part of the total Bid by the Contractor. Payment under this item will be made only when the Work is not already covered by other items.

"Topsoil Type ____", per acre.

The unit Contract price per acre for "Topsoil Type ____" shall be full payment for all costs for the specified Work.

"Fine Compost ", per acre or per square yard.

"Medium Compost", per acre or per square yard.

"Coarse Compost", per acre or per square yard.

The unit Contract price per acre for "Fine Compost", "Medium Compost" or "Coarse Compost" shall be full pay for furnishing and spreading the compost onto the existing soil.

"Soil Amendment", per acre.

The unit Contract price per acre for "Soil Amendment" shall be full pay for furnishing and incorporating the soil amendment into the existing soil.

"Plant Selection ___", per each.

The unit Contract price for "Plant Selection ___", per each shall be full pay for all Work to perform the work as specified within the planting area prior to planting for weed control, planting area preparation and installation of plants with initial watering.

As the plants that do not include plant establishment are obtained, propagated, and grown, partial payments will be made as follows:

Payment of 15 percent of the unit Contract price per each when the plant materials have been contracted, propagated, and are growing under nursery conditions. The

Contractor shall provide the Engineer with certification that the plant material has been procured or contracted for delivery to the project for planting within the time limits of the project. The certification shall state the location, quantity, and size of all material.

Payment will be increased to 100 percent of the unit Contract price per each for contracted plant material at the completion of the initial planting.

All partial payments shall be limited to the actual number of healthy vigorous plants that meet the stage requirements, limited to plan quantity. Previous partial payments made for materials rejected or missing will be deducted from future payments due the Contractor.

"PSIPE ___", per each.

The unit Contract price for "PSIPE ___", per each, shall be full pay for all Work to perform as specified within the planting area for weed control and planting area preparation, planting, cleanup, and water necessary to complete planting operations as specified to the end of first year plant establishment.

As the plants that include plant establishment are obtained, propagated, and grown, partial payments will be made as follows after inspection by the Engineer:

Payment of 5 percent of the unit Contract price, per each, when the plant materials have been contracted, propagated, and are growing under nursery conditions. The Contractor shall provide the Engineer with certification that the plant material has been procured or contracted for delivery to the project for planting within the time limits of the project. The certification shall state the location, quantity, and size of all material.

Payment will be increased to 15 percent of the unit Contract price, per each, upon completion of the initial weed control and planting area preparation Work.

Payment will be increased to 60 percent of the unit Contract price per each for the contracted plant material in a designated unit area when planted.

Payment will be increased to 70 percent of the unit Contract price per each for contracted plant material at the completion of the initial planting.

Payment will be increased to the appropriate percentage upon reaching the following plant establishment milestones:

June 30th	80 percent
September 30th	90 percent
Completion of first-year plant establishment or after all replacement plants have been installed, whichever is later	100 percent

Plant establishment milestones are achieved when planting areas meet conditions described in Section 8-02.3(13).

"Seeding, Fertilizing and Mulching", per acre.

"Seeding and Fertilizing", per acre or per square yard.

"Seeding and Fertilizing by Hand", per square yard.

"Second Application of Fertilizer", per acre.

"Seeding and Mulching", per acre.

"Seeded Lawn Installation", per square yard.

"Sod Installation", per square yard.

"Lawn Mowing", per square yard.

The unit Contract price per square yard for "Seeded Lawn Installation" or "Sod Installation" shall be full pay for all costs necessary to prepare the area, plant or sod the lawn, erect barriers, control weeds, and establish lawn areas and for furnishing all labor, tools, equipment, and materials necessary to complete the Work as specified and shall be paid in the following sequence for healthy, vigorous lawn:

Completion of Lawn Planting	60 percent of individual areas
Mid Lawn Establishment (after two mowings)	85 percent of individual areas
Completion of Lawn Establishment (after four mowings)	100 percent of individual areas

"Plant Establishment Year ____" will be paid in accordance with Section 1-09.6.

For the purpose of providing a common Proposal for all Bidders, the Contracting Agency entered an amount for "Plant Establishment - ___ Year" in the Proposal to become a part of the total Bid by the Contractor.

"Live Pole", per each.

"Live Stake Row", per linear foot.

"Bark or Wood Chip Mulch", per acre or per square yard.

"Bark or Wood Chip Mulch Rings", per each.

The unit Contract price per acre for "Bark or Wood Chip Mulch" shall be full pay for furnishing and spreading the mulch onto the existing soil.

"Fascine" and "PSIPE Live Fascine", per linear foot.

"Brush Mattress" and "PSIPE Live Brush Mattress", per square yard.

"Brush Layer" and "PSIPE Brush Layer", per linear foot.

When PSIPE is included with Fascine, Brush Mattress, or Brush Layer, the payment schedule for PSIPE ____ will apply.

"Roadside Maintenance under Construction" will be paid in accordance with Section 1-09.6.

For the purpose of providing a common Proposal for all Bidders, the Contracting Agency has entered an amount for "Roadside Maintenance Under Construction" in the Proposal to become a part of the total Bid by the Contractor.

"Water", per M Gal.

8-03 Irrigation Systems

8-03.1 Description

This Work consists of installing an irrigation system in accordance with these Specifications and the details shown in the Plans or as approved by the Engineer.

8-03.2 Materials

Materials shall meet the requirements of Sections 9-15 and 9-29.

8-03.3 Construction Requirements

Location of pipe, tubing, sprinkler heads, emitters, valves, and other equipment shall be as shown in the Plans and shall be of the size and type indicated. No changes shall be made except as approved by the Engineer.

Potable water supplies shall be protected against cross connections in accordance with applicable Washington State Department of Health rules and regulations and approval by the local health authority.

Construction of electrical systems shall conform to applicable portions of Sections 8-20 and 9-29.

8-03.3(1) Layout of Irrigation System

The Contractor shall stake the irrigation system following the schematic design shown in the Plans. Approval must be obtained from the Engineer. Alterations and changes in the layout may be expected in order to conform to ground conditions and to obtain full and adequate coverage of plant material with water. However, no changes in the system as planned shall be made without prior authorization by the Engineer.

8-03.3(1)A Locating Irrigation Sleeves

Existing underground irrigation sleeve ends shall be located by potholing. Irrigation sleeves placed during general construction prior to installation of the irrigation system shall be marked at both ends with a 2 by 4 by 24 inch wood stake extending 6 inches out of the soil and painted blue on the exposed end.

8-03.3(2) Excavation

Pipe trenches shall be no wider at any point than is necessary to lay the pipe or install equipment. The top 6 inches of topsoil, when such exists, shall be kept separate from subsoil and shall be replaced as the top layer when backfill is made. Trench bottoms shall be relatively smooth and consist of sand or other suitable material free from rocks, stones, or any material that might damage the pipe. Trenches through rock or other material unsuitable for trench bottoms and sides shall be excavated 6 inches below the required depth and shall be backfilled to the top of the pipe with sand or other suitable material free from rocks or stones. Backfill material shall not contain rocks 2 inches or greater in diameter or other materials that can damage pipe.

The Contractor shall exercise care when excavating pipe trenches near existing trees to minimize damage to tree roots. Where roots are 1½ inches or greater in diameter, the trench shall be hand excavated and tunneled under the roots. When large roots are exposed, they shall be wrapped with heavy, moist material, such as burlap or canvas, for protection and to prevent excessive drying. The material must be kept moist until the trench is backfilled. Trenches dug by machines adjacent to trees with roots less than 1½ inches in diameter shall have severed roots cleanly cut. Trenches with exposed tree roots shall be backfilled within 24 hours unless adequately protected by moist material as approved by the Engineer. All material and fastenings used to cover the roots shall be removed before backfilling.

Detectable marking tape shall be placed in all trenches 6 inches directly above, parallel to, and along the entire length of all nonmetallic water pipes and all nonmetallic and aluminum sleeves, conduits, and casing pipes. The width of the tape and installation depth shall be as recommended by the manufacturer for the depth of installation or as shown in the Plans.

8-03.3(3) Piping

All water lines shall be a minimum of 18 inches below finished grade measured from the top of the pipe or as shown in the Plans. All live water mains to be constructed under existing pavement shall be placed in steel casing jacked under pavement as shown in the Plans. All PVC or polyethylene pipe installed under areas to be paved shall be placed in irrigation sleeves. Irrigation sleeves shall extend a minimum of 2 feet beyond the limits of pavement. All jacking operations shall be performed in accordance with an approved jacking plan. Where possible, mains and laterals or section piping shall be placed in the same trench. All lines shall be placed a minimum of 3 feet from the edge of concrete sidewalks, curbs, guardrails, walls, fences, and traffic barriers. Pipe pulling will not be allowed for installation and placement of irrigation pipe.

Main lines and lateral lines shall be defined as follows:

Main Lines – All supply pipe and fittings between the water meter and the irrigation control valves.

Lateral Lines – All supply pipe and fittings between the irrigation control valves and the connections to the irrigation heads. Swing joints, thick-walled PVC or polyethylene pipe, flexible risers, rigid pipe risers, and associated fittings are not considered part of the lateral line but incidental components of the irrigation heads.

8-03.3(4) Jointing

During construction, pipe ends shall be plugged or capped to prevent entry of dirt, rocks, or other debris.

All galvanized steel pipe shall have sound, clean cut, standard pipe threads well fitted. All pipes shall be reamed to the full diameter and burrs removed before assembly. Threaded galvanized steel joints shall be constructed using either a nonhardening, nonseizing multipurpose sealant or Teflon® tape or paste as recommended by the pipe manufacturer or as shown in the Plans. Threaded galvanized steel joints shall be constructed using either a nonhardening, nonseizing multipurpose sealant or Teflon tape or paste as recommended by the pipe manufacturer. All threaded joints shall be made tight with wrenches without the use of handle extensions. Joints that leak shall be cleaned and remade with new material. Caulking or thread cement to make joints tight shall not be permitted.

PVC pipe, couplings, and fittings shall be handled and installed in accordance with the manufacturer's recommendation. The outside of the PVC pipe shall be chamfered to a minimum of 1⁄16 inch at approximately 22 degrees. Pipe and fittings shall be joined by solvent welding. Solvents used must penetrate the surface at both pipe and fitting, which shall result in complete fusion at the joint. Use solvent and cement only as recommended by the pipe manufacturer.

Threaded PVC joints shall be assembled using Teflon tape as recommended by the pipe manufacturer.

On PVC or polyethylene-to-metal connections, work the metal connection first. Use a nonhardening compound on threaded connections. Connections between metal and PVC or polyethylene are to be threaded using female threaded PVC adapters with threaded Schedule 80 PVC nipples only.

Polyethylene pipe and fittings shall be installed in accordance with the manufacturer's recommendations. The ends of the polyethylene pipe shall be cut square, reamed smooth inside and out, and inserted to the full depth of the fitting. Clamps for insert fittings shall be stainless steel.

8-03.3(5) Installation

Galvanized pipe shall be used from the water meter or service connection through the cross connection control device.

Final position of turf heads shall be between ½ and 1 inch above finished grade measured from the top of the sprinkler. All sprinklers adjacent to walks, curbs, and pavement shall be placed as shown in the Plans.

Shrub heads, unless otherwise specified, shall be placed on risers approximately 12 inches above finished grade.

All automatic control valves, flow control valves, and pressure reducing valves shall be installed in appropriately sized valve boxes. Manual control valves shall be installed in an appropriately sized valve box and, where appropriate, upstream of the automatic control valves. Manual and automatic valves installed together shall be in an appropriately sized box with 3 inches of clearance on all sides.

Final position of valve boxes, capped sleeves, and quick coupler valves shall be between ½ and 1 inch above finished grade or mulch, or as shown in the Plans.

Quick coupler valves and hose bibs shall be installed in valve boxes, either separately or within a control valve assembly box upstream of the control valves. Valves, quick couplers, and hose bibs shall have 3 inches of clearance on all sides within the valve box.

Drip irrigation emitters shall be installed in accordance with the manufacturer's recommendations. Install drain valves at the lowest point of each zone in a minimum 8-inch diameter round valve box over 3 cubic feet of washed gravel.

Automatic controller pedestals or container cabinets shall be installed on a concrete base as shown in the Plans or in accordance with the manufacturer's recommendations. Provide three 1-inch diameter galvanized metal or PVC electrical wire conduits through the base and 3 inches minimum beyond the edge or side of the base, both inside and outside of the pedestal.

8-03.3(6) Electrical Wire Installation

All electrical work shall conform to the National Electric Code, NEMA Specifications, and in accordance with Section 8-20. Electrical wiring between the automatic controller and automatic valves shall be direct burial and may share a common neutral. Separate control conductors shall be run from the automatic controller to each valve. When more than one automatic controller is required, a separate common neutral shall be provided for each controller and the automatic valves it controls. Electrical wire shall be installed in the trench adjacent to or above the irrigation pipe, but no less than 12 inches deep. Plastic tape or nylon tie wraps shall be used to bundle wires together at 10-foot intervals. If it is necessary to run electrical wire in a separate trench from the irrigation pipe, the wire shall be placed at a minimum depth of 18 inches and "snaked" from side to side in the trench. Each circuit shall be identified at both ends and at all splices with a permanent marker identifying zone and/or station.

Wiring placed under pavement and walls, or through walls, shall be placed in an electrical conduit or within an irrigation sleeve. Electrical conduit shall not be less than 1 inch in diameter and shall meet conduit specifications for PVC conduit as required in Section 9-29.1.

Splices will be permitted only in approved electrical junction boxes, valve boxes, pole bases, or within control equipment boxes or pedestals. A minimum of 18 inches of excess conductor shall be left at all splices, terminals, and control valves to facilitate inspection and future splicing. The excess wire shall be neatly coiled to fit easily into the boxes.

All 120-volt electrical conductors and conduit shall be installed by a certified electrician, including all wire splices and wire terminations.

All wiring shall be tested in accordance with Section 8-20.3(11).

Continuity ground and functionality testing shall be performed for all 24-volt direct burial circuits. The Megger test, confirming insulation resistance of not less than 2 megohms to ground in accordance with Section 8-20.3(11), is required.

8-03.3(7) Flushing and Testing

All gauges used in the testing of water pressures shall be certified as accurate by an independent testing laboratory immediately prior to use on the project. Gauges shall be retested when required by the Engineer.

Automatic controllers shall be tested by actual operation for a period of 2 weeks under normal operating conditions. Should adjustments be required, the Contractor shall do so according to the manufacturer's direction and test until operation is satisfactory.

Main Line Flushing – All main supply lines shall receive two fully open flushings to remove debris that may have entered the line during construction: the first before placement of valves and the second after placement of valves and prior to testing.

Main Line Testing – All main supply lines shall be purged of air and tested with a minimum static water pressure of 150 psi for 60 minutes without the introduction of additional service or pumping pressure. Testing shall be done with one pressure gauge installed on the line, in the location required by the Engineer. For systems using a pump, an additional pressure gauge shall be installed at the pump when required by the Engineer. Lines that show loss of pressure exceeding 5 psi at the ends of specified test periods will be rejected.

Lateral Line Flushing – All lateral lines shall receive one fully open flushing prior to placement of sprinkler heads, emitters, and drain valves. The flushing shall be of sufficient duration to remove all dirt or debris that has entered the lateral lines during construction.

Lateral Line Testing – All lateral lines shall be purged of air and tested in place at operating line pressure with a pressure gauge and with all fittings capped or plugged. The operating line pressure shall be maintained for 30 minutes with valves closed and without the introduction of additional service or pumping pressure. Lines that show leaks or loss of pressure exceeding 5 psi at the end of specified test periods will be rejected.

The Contractor shall correct and retest lateral line installations that have been rejected. Throughout the life of the Contract, the Contractor shall repair, flush, and test, all main and lateral lines that have sustained a break or disruption of service. Upon restoration of the water service, the affected lines shall be brought up to operating pressure. The Contractor shall then conduct a thorough inspection of all sprinkler heads, emitters,etc., located downstream of the break or disruption of service, and make all needed repairs to ensure the entire irrigation system is operating properly.

8-03.3(8) Adjusting System

Before final inspection, the Contractor shall adjust and balance all sprinklers to provide adequate and uniform coverage. Spray patterns shall be balanced by adjusting individual sprinkler heads with the adjustment screws or replacing nozzles to produce a uniform pattern. Unless otherwise specified, sprinkler spray patterns will not be permitted to apply water to pavement, walks, or Structures.

8-03.3(9) Backfill

Backfill shall not be started until all piping has been inspected, tested, and approved by the Engineer, after which backfilling shall be completed as soon as possible. All backfill material placed within 6 inches of the pipe shall be sand or other suitable material free of rocks, roots, or other objectionable material that might cut or otherwise damage the pipe. Backfill from the bottom of the trench to approximately 6 inches above the pipe shall be by continuous compacting in a manner that will not damage pipe or wiring and shall proceed evenly on both sides of the pipe. The remainder of the backfill shall be thoroughly compacted, except that heavy equipment shall not be used within 18 inches of any pipe. The top 6 inches of the backfill shall be of topsoil material or the first 6 inches of material removed in the excavation.

8-03.3(10) As Built Plans

Upon Physical Completion of the Work, the Contractor shall submit As Built Plans consisting of corrected shop drawings, schematic circuit diagrams, or other details necessary to show the Work as constructed including the actual installed locations of the irrigation system(s) equipment including, but not limited to, water meters, cross connection control devices, electrical services, pipe and wire runs, splice boxes, controllers,valves,heads, and other equipment. These drawings shall be on sheets conforming in size to the provisions of Section 1-05.3. All drawings must be complete and legible.

Any corrections and additions ordered by the Engineer shall be made by the Contractor prior to acceptance. The Contractor shall provide the Engineer with 3 copies of parts lists, catalog cuts, and service manuals for all equipment installed on the project.

8-03.3(11) System Operation

The irrigation system shall be completely installed, tested, and automatically operable prior to planting in a unit area except where otherwise specified in the Plans or approved by the Engineer. The Contractor shall be fully responsible for all maintenance, repair, testing, inspecting, and automatic operation of the entire system until all Work is considered complete as determined by the final inspection specified in Section 1-05.11. The final inspection of the irrigation system will coincide with the end of the Contract or the end of first-year plant establishment, whichever is later.

This responsibility shall include, but not be limited to, draining the system prior to winter and reactivating the system in the spring and at other times as required by the Engineer.

For the life of the Contract, the Contractor shall be responsible for having annual inspections and tests performed on all cross connection control devices as required and specified by the Washington State Department of Health. Inspections and tests shall be conducted at the time of initial activation and each spring prior to reactivating the irrigation system. Potable water shall not flow through the cross-connection control device to any downstream component until tested and approved for use by the local health authority in accordance with Section 8-03.3(12).

In the spring, when the drip irrigation system is in full operation, the Contractor shall make a full inspection of all emitters and irrigation heads. This shall involve visual inspection of each emitter and irrigation head under operating conditions. All adjustments, flushing, or replacements to the system shall be made at this time to ensure the proper operation of all emitters and irrigation heads.

8-03.3(12) Cross Connection Control Device Installation

Cross connection control devices shall be installed, inspected, and tested by the local health authority or designee in accordance with applicable portions of WAC 246-290-490 and other applicable regulations as set forth by the Washington State Department of Health and WSDOT.

During the life of the Contract, these devices shall be inspected and tested annually, or more often if successive inspections indicate repeated failures. Inspections and tests shall be conducted at the time of initial installation, after repairs, and each spring prior to reactivation of the irrigation system. These inspections and tests shall be completed and the results recorded by a licensed Backflow Assembly Device Tester (BADT) Operator or by a Contracting Agency Certified Water Works Operator with a CCS 1 or CCS 2 Classification and shall document that the devices are in good operating condition prior to flushing and testing of any downstream water lines. Devices that are defective shall be repaired or replaced.

Inspection and test results shall be recorded on WSDOT Form 540-020 and other forms as may be required by the serving utility. The completed forms shall be submitted to the appropriate health authority and to the serving utility when applicable.

8-03.3(13) Irrigation Water Service

All water meter(s) shall be installed by the serving utility. The Contracting Agency shall arrange for water meter installation(s) for the irrigation system at the locations and sizes as shown in the Plans at no cost to the Contractor. It shall be the Contractor's responsibility to contact the Engineer to schedule the water meter installation. The Contractor shall provide a minimum of 60 calendar days notice to the Engineer prior to the desired water meter installation date.

Construction activities for irrigation water service connections shall be in accordance with the serving utility's Service Agreement. A copy of the Service Agreement maybe obtained from the Engineer.

8-03.3(14) Irrigation Electrical Service

The Contracting Agency shall arrange for electrical service connection(s) for operation of the automatic electrical controller(s) at the locations shown in the Plans. The Contractor shall splice and run conduit and wire from the electrical service connection(s) or service cabinet to the automatic electrical controller, and connect the conductors to the circuit(s) per the controller manufacturer's diagrams or recommendations.

The installation of conduits and wire for the electrical power service shall be in accordance with the serving utility's Service Agreement and these Specifications. A copy of the Service Agreement may be obtained from the Engineer.

8-03.4 Vacant

8-03.5 Payment

Payment will be made for the following Bid items when included in the Proposal:

"Irrigation System", lump sum.

All costs for furnishing and installing irrigation system equipment and components where indicated and as detailed in the Plans, all costs of initial and annual inspections and tests performed on cross connection control devices and electrical wire testing during the life of the Contract and As Built Plans shall be included in the lump sum price for the complete irrigation system as shown in the Plans or as otherwise approved by the Engineer.

The Contracting Agency will, at no cost to the Contractor, provide water and electrical services needed for installation and operation of the irrigation system for the life of the Contract.

As the irrigation system is installed, the payment schedule will be as follows:

Payment will be made in proportion to the amount of Work performed up to 90 percent of the unit Contract price for irrigation system when the irrigation system is completed, tested, inspected, and fully operational.

Payment shall be increased to 95 percent of the unit Contract price for irrigation system upon completion and acceptance of initial planting and submittal of As Built Plans.

Payment shall be increased to 100 percent of the unit Contract price for irrigation system upon completion and acceptance of the first-year plant establishment.

When there is no first-year plant establishment or when the Contract is completed, payment will be increased to 100 percent of the unit Contract price for irrigation system upon completion of As Built Plans.

8-04 Curbs, Gutters, and Spillways

8-04.1 Description

This Work consists of the construction of cement concrete curbs, curbs and gutters, gutters, spillways, hot mix asphalt curbs, gutters, spillways, and metal spillways, of the kind and design specified, at the locations shown in the Plans or where designated by the Engineer in accordance with these Specifications and in conformity to the lines and grades as staked.

8-04.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates	9-03
Premolded Joint Filler	9-04.1
Drain Pipe	9-05.1
Steel Culvert Pipe and Pipe Arch	9-05.4
Aluminum Culvert Pipe	9-05.5
Structural Steel and Related Materials	9-06
Reinforcing Steel	9-07
Hand Placed Riprap	9-13.1(4)

Hot Mix Asphalt (HMA) curbs, gutters, and spillways shall be constructed of an HMA mix that will have a dense, uniform surface and will fully retain its shape, grade, and line after placement. The mix components shall meet applicable requirements for asphalt concrete specified in Section 5-04 and shall be approved by the Engineer.

8-04.3 Construction Requirements

8-04.3(1) Cement Concrete Curbs, Gutters, and Spillways

Cement concrete curb, curb and gutter, gutter, and spillway shall be constructed with air entrained concrete Class 3000 conforming to the requirement of Section 6-02 except at driveway entrances. Cement concrete curb or curb and gutter along the full width of a driveway entrance shall be constructed with air entrained concrete Class 4000 conforming to the requirements of Section 6-02. Roundabout truck apron cement concrete curb and gutter shall be constructed with air entrained concrete Class 4000 conforming to the requirements of Section 6-02.

The foundation for curbs, gutters, and spillways shall be thoroughly compacted and required side forms shall rest throughout their length on firm ground. Side forms for straight sections shall be full depth of the curb. They shall be either metal of suitable gage for the Work or surfaced “construction” grade lumber not less than 2 inches (commercial) in thickness. Forms used more than one time shall be thoroughly cleaned and any forms that have become worn, splintered, or warped shall not be used again.

The foundation shall be watered thoroughly before the concrete is placed, and the concrete shall be well tamped and spaded or vibrated in the forms. The exposed surfaces shall be finished full width with a trowel and edger. Within 24 hours after the concrete is placed, the forms of the Roadway face of curbs shall be removed, and the concrete treated with a float finish. The top and face of the curb shall receive a light brush finish, and the top of the gutter shall receive a broom finish.

Expansion joints in the curb or curb and gutter shall be spaced as shown in the Plans, and placed at the beginning and ends of curb returns, drainage Structures, bridges, and cold joints with existing curbs and gutters. The expansion joint shall be filled to full cross-section with ⅜-inch premolded joint filler. When curb or curb and gutter is placed adjacent to portland cement concrete pavement, a ⅜-inch thick, 6 inch deep premolded joint filler shall be installed between the two vertical surfaces to prevent cracking. When noted in the Plans, the Contractor shall install the catch basin gutter pan at drainage Structures abutting the curb and gutter.

The concrete shall be cured for 72 hours by one of the methods specified for cement concrete pavement in Section 5-05.

At the option of the Contractor, the curb and gutter may be constructed using approved slip-form equipment. The curb and gutter shall be constructed to the same requirements as the cast-in-place curb and gutter.

A water-reducing admixture conforming to the requirements of Section 9-26 may be used provided the finished curb and gutter shall retain its line and shape.

8-04.3(1)A Extruded Cement Concrete Curb

Extruded cement concrete curb shall be placed, shaped, and compacted true to line and grade with an approved extrusion machine. The extrusion machine shall be capable of shaping and thoroughly compacting the concrete to the required cross section.

The pavement shall be dry and cleaned of loose and deleterious material prior to curb placement. Cement concrete curbs shall be anchored to the existing pavement by placing steel reinforcing bars 1 foot on each side of every joint.

Steel reinforcing bars shall meet the dimensions shown in the *Standard Plans*.

Joints in the curb shall be spaced at 10-foot intervals. Joints shall be cut vertically and to the depth shown in the *Standard Plans*.

All other requirements for cement curb and cement concrete curb and gutter shall apply to extruded cement concrete curb.

The Contractor may substitute extruded cement concrete curb for extruded HMA concrete curb upon receiving written permission from the Engineer. There will be no change in unit Contract price if this substitution is allowed.

8-04.3(1)B Roundabout Cement Concrete Curb and Gutter

Roundabout cement concrete curb and gutter and roundabout splitter island nosing curb shall be shaped and finished to match the shape of the adjoining curb as shown in the Plans. All other requirements for cement concrete curb and cement concrete curb and gutter shall apply to roundabout cement concrete curb and gutter.

8-04.3(2) Extruded Asphalt Concrete Curbs and Gutters

Asphalt concrete curbs, gutters, and spillways shall be constructed of Commercial HMA as specified in Section 5-04. The HMA will have a dense, uniform surface and will fully retain its shape, grade, and line after placement. Just prior to placing the curb, a tack coat of asphalt shall be applied to the existing pavement surface at the rate ordered by the Engineer.

Set forms will not be required for forming gutter if slip-form equipment of a type approved by the Engineer is used. Gutter shall be shaped and compacted to the required line, grade, and cross section. Connections to any type of outlet shall be constructed so as to form a watertight joint.

8-04.3(3) Vacant

8-04.3(4) Metal Spillways

Round metal spillways shall be plain metal drain pipe 8-inch diameter and when specified in the Contract, the joints shall be sealed with rubber gaskets conforming to the requirements of Section 9-04.4(4). Half round metal spillways shall be half round metal culvert pipe of the size, kind, and thickness shown in the Plans.

In the construction of metal spillways, sufficient bands, elbows, and joints shall be furnished and placed by the Contractor to permit the construction and connection of the spillways as indicated in the Plans so as to carry the drainage from gutters to the inlets and spillways without percolation of the water under and around the Structure.

Spillway pipe shall be laid in a trench in the embankment slope and shall not be placed until after the embankment slopes have been completed and dressed to the lines prescribed by the Engineer. The lower end of the pipe spillway shall be adequately protected and supported by hand placed riprap, concrete, or by other means as may be shown in the Plans. After the spillway pipe has been placed and connected, the trench shall be backfilled, thoroughly compacted, and the embankment slopes restored to their original condition.

8-04.3(5) Spillways at Bridge Ends

Where spillways are required to be constructed at bridge ends, they shall be constructed in the embankment slopes as described above and arranged so that they will connect to the bridge drains. The pipe shall be plain metal drain pipe 8-inch diameter and the joints shall be sealed with rubber gaskets conforming to the requirements of Section 9-04.4(4).

8-04.4 Measurement

All curbs, gutters, and spillways will be measured by the linear foot along the line and slope of the completed curbs, gutters, or spillways, including bends. Measurement of cement concrete curb and cement concrete curb and gutter, when constructed across driveways or sidewalk ramps, will include the width of the driveway or sidewalk ramp.

Roundabout splitter island nosing curb will be measured per each.

Except for metal spillways, excavation for these Structures shall be incidental to the items involved. Structure excavation required for the installation of metal spillways will be measured in accordance with the provisions of Section 2-09.

Hand placed riprap will be measured in accordance with Section 8-15.4.

8-04.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Cement Conc. Traffic Curb and Gutter", per linear foot.

"Cement Conc. Traffic Curb", per linear foot.

"Mountable Cement Conc. Traffic Curb", per linear foot.

"Dual-Faced Cement Conc. Traffic Curb and Gutter", per linear foot.

"Dual-Faced Cement Conc. Traffic Curb", per linear foot.

"Cement Conc. Pedestrian Curb", per linear foot.

"Roundabout Central Island Cement Concrete Curb", per linear foot.

"Roundabout Truck Apron Cem. Conc. Curb and Gutter", per linear foot.

"Roundabout Cement Concrete Curb and Gutter", per linear foot.

The unit Contract price per linear foot for "Roundabout Cement Concrete Curb and Gutter" shall be full payment for all costs for the specified Work including transitioning the roundabout cement concrete curb and gutter to the adjoining curb shape.

"Roundabout Splitter Island Nosing Curb", per each.

The unit Contract price per each for "Roundabout Splitter Island Nosing Curb" shall be full payment for all costs for the specified Work including transitioning the roundabout splitter island nosing curb to the adjoining curb shape.

"Extruded Curb", per linear foot.

"Cement Conc. Gutter", per linear foot.

"Cement Conc. Spillway", per linear foot.

"Asphalt Conc. Gutter", per linear foot.

"Asphalt Conc. Spillway", per linear foot.

"Drain Pipe ___ In. Diam.", per linear foot.

"Half Round Plain St. Culv. Pipe ___ In. Th. ___ In. Diam.", per linear foot.

"Half Round Tr. 1 St. Culv. Pipe ___ In. Th. ___ In. Diam.", per linear foot.

"Half Round Plain Al. Culv. Pipe ___ In. Th. ___ In. Diam.", per linear foot.

"Half Round Tr. 1 Al. Culv. Pipe ___ In. Th. ___ In. Diam.", per linear foot.

"Hand Placed Riprap", per cubic yard.

Hand placed riprap will be paid for as provided in Section 8-15.5.

When catch basin gutter pans are required in the Plans, all costs for providing the widened area of gutter pan shall be included in the curb and gutter Bid item.

8-05 Vacant

8-06 Cement Concrete Driveway Entrances

8-06.1 Description

This Work shall consist of constructing the types of cement concrete driveway entrances shown in the Plans and in accordance with these Specifications and the *Standard Plans*. The widths of the entrances shall be as noted in the Plans. When no width is noted in the Plans, the entrance shall be constructed to the minimum dimensions shown in the *Standard Plans*.

8-06.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates	9-03
Premolded Joint Filler	9-04.1

8-06.3 Construction Requirements

Cement concrete driveway approaches shall be constructed with air entrained concrete Class 4000 conforming to the requirements of Section 6-02 or Portland Cement or Blended Hydraulic Cement Concrete Pavement conforming to the requirements of Section 5-05.

Driveway entrance concrete may be placed, compacted, and finished using hand methods. The tools required for these operations shall be approved by the Engineer. After troweling and before edging, the surface of the driveway entrance shall be brushed in a transverse direction with a stiff bristled broom. Curing of the concrete shall be in accordance with Section 5-05.3(13). The driveway entrances may be opened to traffic in accordance with Section 5-05.3(17).

When noted in the Plans, the Contractor shall construct the driveway entrance in two or more segments to permit access to an existing driveway. At these locations, the Contractor shall provide a well-graded and drained temporary approach suitable for vehicular traffic from the abutting Roadway to the existing driveway and a firm surface for pedestrians crossing the approach. When the concrete in this segment of the entrance has reached the desired compressive strength, the Contractor shall route traffic over it, remove the temporary approach, and construct the remaining driveway entrance segment or segments. The joints between segments shall be filled to full cross-section with ⅜-inch premolded joint filler.

8-06.4 Measurement

Cement concrete driveway entrances will be measured by the square yard of finished surface.

8-06.5 Payment

Payment will be made for the following Bid item when it is included in the Proposal:

"Cement Conc. Driveway Entrance Type ___", per square yard.

All costs in constructing the driveway entrance in segments and installing and removing the temporary approach shall be included.

8-07 Precast Traffic Curb

8-07.1 Description

This Work consists of furnishing and installing precast traffic sloped mountable curb, or dual faced sloped mountable curb of the design and type specified in the Plans in accordance with these Specifications and the *Standard Plans* in the locations indicated in the Plans or as staked by the Engineer.

8-07.2 Materials

Materials shall meet the requirements of the following sections:

Precast Traffic Curb	9-18.1
Water Repellent Compound	9-18.4
Sodium Metasilicate	9-18.5
Mortar	9-20.4
Paint	9-34.2

8-07.3 Construction Requirements

8-07.3(1) Installing Curbs

The curb shall be firmly bedded for its entire length and breadth on a mortar bed conforming to Section 9-20.4(3) composed of one part Portland cement or blended hydraulic cement and two parts sand. The anchor grooves in the bottom of the curb shall be entirely filled with the mortar.

Before the cement mortar bed is laid, all dirt shall be cleaned from the pavement surface by washing.

All old pavements and any portion of new pavements constructed under this Contract, which are covered with oil or grease within the curb limits, shall be further cleaned as follows:

1. The pavement shall be flushed with water.
2. While the pavement is still wet, sodium metasilicate, complying with the requirements as specified elsewhere herein, shall be evenly distributed over the pavement surface at a rate of 1 to 2 pounds per 100 square feet of pavement surface.
3. The sodium metasilicate shall remain on the pavement for at least 15 minutes. Where patches of oil, tar, or grease occur, these areas shall be scrubbed with a brush or broom.
4. The pavement surface shall then be thoroughly rinsed.

All joints between adjacent pieces of curb except joints for expansion and/or drainage as designated by the Engineer shall be filled with mortar composed of one part Portland cement or blended hydraulic cement and two parts sand.

The alignment and the top surface of adjoining sections of curb shall be true and even with a maximum tolerance of 1/16 inch.

For sloped mountable curb installed in curves, the units shall be either curved blocks precast to the radii shown in the Plans or tangent blocks sawn to the dimensions shown in the *Standard Plans* to conform to the specified radii.

8-07.3(2) Painting of Curbs

Concrete curbing shall be painted with two full coats of paint conforming to Section 9-34.2, as shown in the Plans or as designated by the Engineer. The paint can be applied by brush or spray. The second coat shall have glass traffic paint beads sprinkled in the wet paint at the rate of 12 pounds per 100 linear feet of curbing. The beads shall conform to the requirements of Section 9-34.4.

8-07.4 Measurement

Sloped mountable curb will be measured by the linear foot along the front face of the curb. Dual faced sloped mountable curb will be measured by the linear foot of tapered block and nosing block installed. Only one face of dual faced curb will be measured.

8-07.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Precast Sloped Mountable Curb", per linear foot.

"Precast Dual Faced Sloped Mountable Curb", per linear foot.

8-08 Rumble Strips

8-08.1 Description

This Work consists of constructing centerline and shoulder rumble strips by grinding hot mix asphalt. The Work shall include cleanup and disposal of cuttings and other resultant debris. The *Standard Plans* show the patterns and construction details for the centerline rumble strip and the four types of shoulder rumble strips.

8-08.2 Vacant

8-08.3 Construction Requirements

The equipment shall have a rotary type cutting head or series of cutting heads capable of grinding one or more recesses in the hot mix asphalt as detailed in the *Standard Plans*. The difference in the surface texture between the high and low surfaces from the grinding shall not exceed ⅛ inch.

Rumble strips shall not be constructed on bridge decks, bridge approach slabs, or cement concrete surfaces. In areas where monuments, drainage structures, induction loop lead-ins, pavement markings or other features will not allow the rumble strips to be constructed as detailed, the rumble strips shall be eliminated or relocated as approved by the Project Engineer.

The traveled lanes shall be kept free of cuttings and other construction debris at all times. All cuttings, grinding debris, dust, and other loose materials shall become the property of the Contractor and, upon completion of rumble strip grinding, shall be immediately removed and disposed of outside the project limits. Cuttings and other debris shall not be allowed to enter any waterways.

When shown in the Plans, the rumble strips shall be fog sealed in accordance with the requirements of Section 5-02, following the completion of the shoulder rumble strip. All pavement markings, junction boxes, drainage structures, and similar objects shall not be fog sealed.

The accumulative error in the longitudinal spacing of the rumble strips and the gaps, when required, shall not exceed plus or minus 5 percent.

8-08.4 Measurement

Centerline and shoulder rumble strips will be measured to the nearest 0.01 mile along the mainline roadway for centerline or each shoulder. No deductions will be made for required gaps shown on the *Standard Plans* or for the elimination of rumble strips across bridge decks, bridge approach slabs, cement concrete areas, or other areas approved by the Engineer.

Fog sealing, when shown in the Plans, will be measured as asphalt for fog seal in accordance with Section 5-02.4.

8-08.5 Payment

“Shoulder Rumble Strip Type __”, per mile.

“Centerline Rumble Strip”, per mile.

Layout of the rumble strip pattern on the centerline or shoulders for grinding purposes is the responsibility of the Contractor. All costs involved in this Work shall be included in the appropriate Bid item.

Payment for fog sealing the shoulder, when shown in the Plans, shall be paid as asphalt for fog seal in accordance with Section 5-02.5.

8-09 Raised Pavement Markers

8-09.1 Description

This Work shall consist of furnishing and installing pavement markers of the type specified in the Plans, in accordance with these Specifications, and at the locations indicated in the Plans or where designated by the Engineer. This Work also includes cleanup and disposal of cuttings and other resultant debris. The color of pavement markers shall conform to the color of the marking for which they supplement, substitute for, or serve as a positioning guide for.

8-09.2 Materials

Raised pavement marker (RPM) shall meet the requirements of the following sections:

RPM Type 1	9-21.1
RPM Type 2	9-21.2
RPM Type 3	9-21.3
Adhesive	9-02.1(8), 9-26.2

8-09.3 Construction Requirements

8-09.3(1) Preliminary Spotting

The Engineer will provide necessary control points at intervals agreed upon with the Contractor to assist in preliminary spotting of the lines before marker placement begins. The Contractor shall be responsible for preliminary spotting of the lines to be marked. The color of the material used for spotting shall match the color of the raised pavement markers. Approval by the Engineer is required before marking begins.

Markers shall not be placed over longitudinal or transverse joints in the pavement surface.

8-09.3(2) Surface Preparation

All sand, dirt, and loose extraneous material shall be swept or blown away from the marker location and the cleaned surface prepared by one of the following procedures:

When deemed necessary by the Engineer all surface dirt within areas to receive markers shall be removed. Large areas of tar, grease, or foreign materials may require sandblasting, steam cleaning, or power brooming to accomplish complete removal.

When markers are placed on new cement concrete pavement, any curing compound shall be removed in accordance with the requirements of this Section. All liquid membrane-forming compounds shall be removed from the portland cement concrete pavement to which Raised Pavement Markers are to be bonded. Curing compound removal shall not be started until the pavement has attained sufficient flexural strength before opening to traffic. The Contractor shall submit a Type 2 Working Drawing consisting of the proposed removal method.

The pavement shall be surface dry. When applying Epoxy Adhesives in cool weather the pavement surface shall be heated by intense radiant heat (not direct flame) for

a sufficient length of time to warm the pavement areas of marker application to a minimum of 70°F.

Application of markers shall not proceed until final authorization is received from the Engineer.

8-09.3(3) Marker Preparation

Type 2 markers may be warmed prior to setting by heating to a maximum temperature of 120°F for a maximum of 10 minutes.

8-09.3(4) Adhesive Preparation

Epoxy adhesive shall be maintained at a temperature of 60°F to 85°F before use and during application.

Component A shall be added to component B just before use and mixed to a smooth uniform blend. The unused mixed adhesive shall be discarded when polymerization has caused stiffening and reduction of workability.

Flexible bituminous pavement marker adhesive shall be indirectly heated in an applicator with continuous agitation or recurring circulation. Adhesive temperature shall not exceed the maximum safe heating temperature stated by the manufacturer. The Contractor shall provide the Engineer with manufacturers written instruction for application temperature and maximum safe heating temperature.

8-09.3(5) Application Procedure

8-09.3(5)A Epoxy Adhesives

Epoxy adhesive shall conform to the requirements of Section 9-26.2.

The marker shall be affixed to the prepared pavement area with sufficient adhesive so as to squeeze out a small bead of adhesive around the entire periphery of the marker.

The sequence of operations shall be as rapid as possible. Adhesive shall be in place and the marker seated in not more than 30 seconds after the removal of the pavement preheat or warm air blast. The marker shall not have cooled more than 1 minute before seating.

The length of the pavement preheat or warming shall be adjusted so as to ensure bonding of the marker in not more than 15 minutes. Bonding will be considered satisfactory when adhesive develops a minimum bond strength in tension of not less than 800 grams per square inch or a total tensile strength of 25 pounds.

On Roadway sections which are not open to public traffic, the preheating of the markers by dry heating before setting will not be required provided the adhesive develops the required bond strength of 800 grams per square inch in less than 3 hours. If the Roadway section is carrying public traffic during the installation of the markers, the 15 minute set-to-traffic provision will be enforced, and necessary flagging and traffic control will be required.

8-09.3(5)B Flexible Bituminous Pavement Marker Adhesives

The flexible bituminous pavement marker adhesive shall conform to the requirements of Section 9-02.1(8).

The adhesive shall be applied at temperatures recommended by the manufacturer.

The marker shall be affixed to the prepared pavement area with sufficient adhesive so as to squeeze out a small bead of adhesive around the entire periphery of the marker. Markers shall be placed immediately after application of the adhesive.

8-09.3(6) Recessed Pavement Marker

The Contractor shall construct recesses for pavement markers by grinding the pavement in accordance with the dimensions shown in the *Standard Plans*. The Contractor shall ensure that grinding of the pavement does not result in any damage, (e.g. chipping, spalling or raveling) to the pavement to remain. The Contractor shall prepare the surface in accordance with Section 8-09.3(2), and install Type 2 markers in the recess in accordance with the *Standard Plans* and Section 8-09.3(4).

Recessed pavement markers shall not be constructed on bridge decks or on bridge approach slabs.

8-09.3(7) Tolerances for Pavement Markers

Markers shall be spaced and aligned as shown in the *Standard Plans* and as specified by the Engineer. A displacement of not more than ½ inch left or right of the established guideline will be permitted. The Contractor shall remove and replace all improperly placed markers at no expense to the Contracting Agency.

8-09.4 Measurement

Measurement of markers will be by units of 100 for each type of marker furnished and set in place.

8-09.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Raised Pavement Marker Type 1", per hundred.

"Raised Pavement Marker Type 2", per hundred.

"Raised Pavement Marker Type 3-_____ In.", per hundred.

"Recessed Pavement Marker", per hundred.

The unit Contract price per hundred for "Raised Pavement Marker Type 1", "Raised Pavement Marker Type 2", "Raised Pavement Marker Type 3_____ In.", and "Recessed Pavement Marker" shall be full pay for furnishing and installing the markers in accordance with these Specifications.

8-10 Guide Posts

8-10.1 Description

This Work shall consist of furnishing and placing flexible guide posts of the type specified in the Plans in accordance with these Specifications and the *Standard Plans*, at the locations indicated in the Plans or where designated by the Engineer.

8-10.2 Materials

Flexible guide posts and reflective sheeting shall be selected from approved materials listed in the Special Provisions or the Qualified Products List. Flexible guide posts shall be preapproved in accordance with Section 9-17 prior to use on a project. If a producer lacks access to a regularly conducted State Materials Laboratory test, the producer may submit for consideration, performance data gained from independent testing attested by a registered Engineer. Acceptance of independent data or repetition of selected or total tests, shall be the prerogative of the State Materials Laboratory.

Adhesives for surface mounted guide posts shall meet the requirements of Sections 9-02.1(8) or 9-26.2. Other bonding agents may be approved by the Engineer.

8-10.3 Construction Requirements

Flexible guide posts shall be installed as shown in the *Standard Plans* or as specified by the Engineer. The posts shall be installed plumb, plus or minus 1½ degrees.

Guide posts shall be of such length as to provide a height of 48 inches, plus or minus 3 inches, above the nearest edge of traveled pavement surface. Surface mounted guide posts shall be bonded to the pavement surface.

Flexible guide posts shall be installed according to the manufacturer's recommendations. The Contractor shall submit a Type 1 Working Drawing consisting of the manufacturer's recommended installation procedures. Only one type of ground mount or guardrail mount flexible guide post shall be used on each project. When a guide post is placed on new cement concrete pavement, any curing compound shall be removed. All liquid membrane-forming compounds shall be removed from the portland cement concrete pavement to which guide posts are to be bonded. Curing compound removal shall not be started until the pavement has attained sufficient flexural strength before opening to traffic. The Contractor shall submit a Type 2 Working Drawing consisting of the proposed removal method.

The final guide posts lengths will be determined or verified by the Engineer at the request of the Contractor.

If the ground adjacent to the posts is disturbed in any manner, it shall be backfilled to the level of the existing surface and thoroughly compacted. The surface of the ground adjacent to the post shall be replaced with like materials, including bituminous treatment if previously existent.

8-10.4 Measurement

Flexible guide posts will be measured by the unit for each post furnished and installed.

8-10.5 Payment

Payment will be made for the following Bid item when included in the Proposal:

"Flexible Guide Post", per each.

8-11 Guardrail

8-11.1 Description

This Work consists of constructing, modifying, removing, and resetting guardrail and anchors of the kind and type specified in accordance with the Plans, these Specifications, and the *Standard Plans* in conformity with the lines and grades as staked.

8-11.2 Materials

Materials shall meet the requirements of the following sections:

Beam Guardrail	9-16.3
Rail Element	9-16.3(1)
Posts and Blocks	9-16.3(2)
Galvanizing	9-16.3(3)
Hardware	9-16.3(4)
Anchors	9-16.3(5)

8-11.3 Construction Requirements

8-11.3(1) Beam Guardrail

8-11.3(1)A Erection of Posts

Posts shall be set to the true line and grade of the Highway after the grade is in place and compaction is completed. If the ends of a section of guardrail are curved outward or downward, the posts shall be set to accommodate the curve. The length of posts and post spacing shall be as shown in the Plans.

Posts may be placed in dug or drilled holes. Ramming or driving will be permitted only if approved by the Engineer and if no damage to the pavement, shoulders, and adjacent slopes results there from.

In broken rock embankments, the pre-punching of holes will be permitted only prior to final Shoulder or median compaction, surfacing, and paving.

In locations where posts are installed through asphalt or concrete pavement, first install openings in the pavement material called leave-outs. The leave-out opening shall either be a 15” x 15” square or a 15” diameter circle. Install the posts aligned centered in the leave-out opening except that a minimum 7” space from the back edge of the leave-out to the back of the post shall be provided. Backfill around the post in the leave-out with base course material and tamp manually to within 3” of the pavement surface. Fill the remaining 3” of the leave-out with emulsified asphalt that is level with the pavement surface. The construction of leave-outs is incidental to guardrail installation.

The posts shall be protected from traffic at all times by attaching the rail elements or by a method approved by the Engineer.

8-11.3(1)B Erection of Rail

All metal work shall be fabricated in the shop. No punching, cutting, or welding shall be done in the field, except that holes necessary when additional posts are required or for special details in exceptional cases may be drilled in the field when approved by the Engineer. The rail shall be erected so that the bolts at expansion joints will be located at the centers of the slotted holes. All holes shall be painted with two coats of paint conforming to Section 9-08.1(2)B.

Rail plates shall be assembled with the splice joints lapping in the direction of the traffic.

When nested W-beam or thrie beam is specified, two sections of guardrail, one set inside of the other shall be installed. The inside and outside rail elements shall not be staggered.

Galvanized steel rail plates shall be fastened to the posts with galvanized bolts, washers, and nuts of the size and kind shown in the Plans.

All bolts, except where otherwise required at expansion joints, shall be drawn tight. Bolts through expansion joints shall be drawn up as tight as possible without being tight enough to prevent the rail elements from sliding past one another longitudinally. Bolts shall be sufficiently long to extend at least ¼ inch beyond the nuts. Except where required for adjustments, bolts shall not extend more than ½ inch beyond the nuts.

8-11.3(1)C Terminal and Anchor Installation

All excavation and backfilling required for installation of anchors shall be performed in accordance with Section 2-09, except that the costs thereof shall be included in the unit Contract price for the anchor installed. In locations where guardrail anchors are installed on asphalt or concrete pavement, construct leave-outs around the anchor posts in accordance with Section 8-11.3(1)A. The construction of leave-outs is incidental to the anchor installation.

Bolts shall be tightened to the tension specified. The anchor cable shall be tightened sufficiently to eliminate all slack. When tightening, the anchor cable shall be restrained to prevent twisting of the cable.

When foundation tubes used with the Wood Breakaway Post are driven, they shall be driven prior to installing the wood post.

Type 2 concrete anchors may either be precast or cast-in-place at the option of the Contractor.

Assembly and installation of Beam Guardrail Non-flared Terminals for Type 31 guardrail shall be supervised at all times by a manufacturer's representative, or an installer who has been trained and certified by the manufacturer within the last 5 years and for the specific device(s) being installed. A copy of the installer's certification shall be provided to the Engineer prior to installation. Assembly and installation shall be in accordance with the manufacturer's recommendations. The manufacturer's representative or certified installer shall complete a manufacturer's terminal assembly/inspection checklist for each terminal installed. The original completed checklist, signed by the manufacturer's representative

or certified installer, shall be provided to the Engineer on the same day that the terminal installation is completed.

When the manufacturer allows it, guardrail terminals may be installed on asphalt or concrete pavement. Guardrail terminals installed on asphalt or concrete pavement shall have leave-outs constructed around the posts. Leave-outs shall be constructed in accordance with Section 8-11.3(1)A. The construction of leave-outs is incidental to the terminal installation.

Beam Guardrail Non-flared Terminals for Type 31 guardrail shall meet the crash test and evaluation criteria in the Manual for Assessing Safety Hardware (MASH).

8-11.3(1)D Removing Guardrail and Guardrail Anchor

Removal of the various types of guardrail shall include removal of the rail, cable elements, hardware, and posts, including transition sections, expansion sections, terminal sections and the rail element of anchor assemblies. Removal of the various types of guardrail anchors shall include removal of the anchor assembly including concrete bases, rebar, steel tubes, and any other appurtenances in the anchor assembly. All holes resulting from the removal of the guardrail posts and anchors shall be backfilled with granular material in layers no more than 6 inches thick and compacted to a density similar to that of the adjacent material. The removed guardrail items shall become the property of the Contractor.

The embedded anchors attaching guardrail posts and guardrail terminal sections specified for removal to existing concrete Structures shall be removed to a minimum of 1 inch beneath the existing concrete surface. The void left by removal of the embedded anchors shall be coated with epoxy bonding agent and filled with mortar conforming to Section 9-20.4(2). The epoxy bonding agent shall be Type II, conforming to Section 9-26.1, with the grade and class as recommended by the epoxy bonding agent manufacturer.

8-11.3(1)E Raising Guardrail

For raising guardrail anchors and raising guardrail terminals, the existing guardrail posts shall be raised to attain the guardrail height shown in the Plans, measured from the top of the rail to the finished Shoulder surface. The material around each post shall be tamped to prevent settlement of the raised post.

For raising all other guardrail, the existing guardrail posts shall not be raised to attain the new mounting height. The existing rail elements and blocks shall be removed from the guardrail post. The Contractor shall field drill new ¾-inch diameter holes in the existing posts to accommodate the ⅝-inch diameter button head bolts. When existing guardrail posts are galvanized steel, the new drill holes shall be painted with two coats of paint, conforming to Section 9-08.1(2)B. The Contractor shall then reinstall the guardrail block and rail element at the new mounting height shown in the Plans, measured from the top of the rail to the finished Shoulder surface. The new position of the top of the block shall not be more than 4 inches above the top of the guardrail post.

The Contractor shall remove and replace any existing guardrail posts and blocks that are not suited for re-use, as staked by the Engineer. The void caused by removal of the post shall be backfilled and compacted. The Contractor shall then furnish and install a new guardrail post to provide the necessary mounting height.

8-11.3(1)F Removing and Resetting Beam Guardrail

The Contractor shall remove and reset existing guardrail posts, rail element, hardware and blocks to the location shown in the Plans. The mounting height of reset rail element shall be at the height shown in the Plans.

The Contractor shall remove and replace any existing guardrail posts and blocks that are not suited for re-use, as staked by the Engineer. The void caused by the removal of the post shall be backfilled and compacted. The Contractor shall then furnish and install a new guardrail post to provide the necessary mounting height.

8-11.3(1)G Plans

The Contractor shall submit Type 2 Working Drawings of such additional detailed plans and shop drawings of rail punching, fittings, and assemblies as may be required by the Engineer.

8-11.3(1)H Guardrail Construction Exposed to Traffic

Any section of beam guardrail that is removed for modification shall be back in place within 5 calendar days of the date the guardrail is removed.

The Contractor's operations shall be conducted in such a manner that fixed objects and beam guardrail posts shall be protected from traffic at all times by attachment of the rail elements and all associated hardware or by a method approved by the Engineer.

At the end of each day, guardrail sections having an exposed end toward oncoming traffic shall have a Type G terminal end section bolted securely in place.

8-11.4 Measurement

Measurement of beam guardrail and beam guardrail with long posts will be by the linear foot measured along the line of the completed guardrail, including expansion section, and will also include the end section for F connections.

Measurement of beam guardrail transition sections will be per each for the type of transition section installed. End sections, except for F connections, will be considered part of the transition section and will be included in the measurement of the transition section.

Measurement of beam guardrail _____ terminal will be per each for the completed terminal.

Measurement of beam guardrail Type 31 buried terminal Type 2 will be per linear foot for the completed terminal.

Measurement of beam guardrail anchor Type 10 will be per each for the completed anchor, including the attachment of the anchor to the guardrail.

Measurement of removal of guardrail will be by the linear foot measured along the line of guardrail removed including transition sections, expansion sections, guardrail anchor rail elements and terminal sections.

Measurement of removal of guardrail anchors will be per each.

Measurement of raising beam guardrail and removing and resetting beam guardrail will be by the linear foot measured along the line of guardrail actually raised or removed and reset. This will include transition sections, expansion sections, anchors, and terminal sections.

Measurement of beam guardrail post used for raising beam guardrail will be per each.

Measurement of beam guardrail blocks used for raising beam guardrail will be per each.

8-11.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Beam Guardrail Type ____", per linear foot.

"Beam Guardrail Type 1- ____ Ft. Long Post", per linear foot.

"Beam Guardrail Type 31-____ Ft. Long Post", per linear foot.

The unit Contract price per linear foot for "Beam Guardrail Type____", "Beam Guardrail

Type 1-____ Ft. Long Post", and "Beam Guardrail Type 31-____ Ft. Long Post", shall be full payment for all costs to obtain and provide materials and perform the Work as described in Sections 8-11.3(1)A and 8-11.3(1)B, including costs for additional rail elements when nested rail is required, when connections to concrete masonry Structures are required, and when constructing leave-outs for guardrail installed in asphalt or concrete pavement.

"Beam Guardrail Transition Section Type ____", per each.

The unit Contract price per each for "Beam Guardrail Transition Section Type ____" shall be full payment for all costs to obtain and provide materials and perform the Work as described in Sections 8-11.3(1)A and 8-11.3(1)B, including costs for additional rail elements when nested rail is required, when connections to concrete masonry Structures are required, and when constructing leave-outs for guardrail transitions installed in asphalt or concrete pavement.

"Beam Guardrail Anchor Type 10", per each.

"Beam Guardrail ____ Terminal", per each.

The unit Contract price per each for "Beam Guardrail Anchor Type ____" and "Beam Guardrail ___ Terminal" shall be full payment for all costs to obtain and provide

materials and perform the Work as described in Section 8-11.3(1)C including costs when constructing leave-outs for guardrail terminals or anchors installed in asphalt or concrete pavement.

“Beam Guardrail Type 31 Buried Terminal Type 2”, per linear foot.

The unit Contract price per linear foot for “Beam Guardrail Type 31 Buried Terminal Type 2” shall be full payment for all costs to obtain and provide materials and perform the Work as described in Section 8-11.3(1)C.

“Removing and Resetting Beam Guardrail”, per linear foot.

The unit Contract price per linear foot for “Removing and Resetting Beam Guardrail” shall be full payment for all costs to perform the Work as described in Section 8-11.3(1)F, except for replacement posts and blocks.

“Raising Existing Beam Guardrail”, per linear foot.

The unit Contract price per linear foot for “Raising Existing Beam Guardrail” shall be full payment for all costs to perform the Work as described in Section 8-11.3(1)E, except for replacement posts and blocks.

“Removing Guardrail”, per linear foot.

The unit Contract price per linear foot for “Removing Guardrail” shall be full payment for all costs to perform the Work as described in Section 8-11.3(1)D.

“Removing Guardrail Anchor”, per each.

The unit Contract price per each for “Removing Guardrail Anchor” shall be full payment for all costs to perform the Work as described in Section 8-11.3(1)D, including rail removal, if there isn’t a Bid item for Removing Guardrail in the run of guardrail connecting to the anchor.

“Beam Guardrail Post”, per each.

“Beam Guardrail Block”, per each.

The unit Contract price per each for “Beam Guardrail Post” and “Beam Guardrail Block” shall be full payment for all costs for furnishing and installing new posts and blocks, removal and disposal of the existing posts and blocks, and backfilling and compacting the void created by post removal when new posts or blocks are required for the Work described in Sections 8-11.3(1)E and 8-11.3(1)F.

8-12 Chain Link Fence and Wire Fence

8-12.1 Description

This Work consists of furnishing and constructing chain link fence and wire fence of the types specified in accordance with the Plans, these Specifications, and the *Standard Plans* at the locations shown in the Plans and in conformity with the lines as staked.

Chain link fence shall be of diamond woven wire mesh mounted on steel posts.

Wire fence shall be of barbed wire or barbed wire combined with wire mesh fastened to posts. Steel posts and steel braces, or wood posts and wood braces may be used, provided only one type shall be selected for use in any Contract.

Gates shall consist of a steel frame or frames covered with chain link or wire mesh.

8-12.2 Materials

Materials shall meet the requirements of the following sections:

Concrete	6-02
Paint	9-08.1(2)B
Chain Link Fence and Gates	9-16.1
Wire Fence and Gates	9-16.2
Grout	9-20.3

8-12.3 Construction Requirements

Clearing of the fence line will be required. Clearing shall consist of the removal and disposal of all trees, brush, logs, upturned stumps, roots of down trees, rubbish, and debris.

For chain link type fences, the clearing width shall be approximately 10 feet. For wire type fences, the clearing width shall be approximately 3 feet. Grubbing will not be required except where short and abrupt changes in the ground contour will necessitate removal of stumps in order to properly grade the fence line. All stumps within the clearing limits shall be removed or close cut.

Grading of the fence line sufficient to prevent short and abrupt breaks in the ground contour that will improve the aesthetic appearance of the top of the fencing when installed shall be required. It is expected that in the performance of this Work, machine operations will be required for chain link fencing, and handwork will be required for wire fencing except where sufficient width exists for machine work.

The fence shall be constructed close to and inside the Right of Way line unless otherwise directed by the Engineer or shown in the Plans. Deviations in alignment to miss obstacles will be permitted only when approved by the Engineer and only when such deviation will not be visible to the traveling public or adjacent property owners.

8-12.3(1) Chain Link Fence and Gates

8-12.3(1)A Posts

Posts shall be placed in a vertical position and, except where otherwise directed by the Engineer, shall be spaced at 10-foot centers. Spacing will be measured parallel to the slope of the ground.

All posts, except line posts, shall be set in concrete to the dimensions shown in the Plans. All concrete footings shall be crowned so as to shed water. Line posts fences shall be set in undisturbed earth either by driving or drilling, except as specified. Driving shall be accomplished in such a manner as not to damage the post. Voids around the post shall be backfilled with suitable material and thoroughly tamped.

Concrete footings shall be constructed to embed the line posts at grade depressions where the tension on the fence will tend to pull the post from the ground.

Where solid rock is encountered without an overburden of soil, line posts shall be set a minimum depth of 14 inches, and end, corner, gate, brace, and pull posts a minimum of 20 inches into the solid rock. The holes shall have a minimum width 1 inch greater than the largest dimension of the post section to be set. The posts shall be cut before installation to lengths that will give the required length of post above ground, or if the Contractor so elects, an even length of post set at a greater depth into the solid rock may be used.

After the post is set and plumbed, the hole shall be filled with Grout Type 4. The grout shall be thoroughly worked into the hole so as to leave no voids. The grout shall be crowned to carry water from the post.

Where solid rock is covered by an overburden of soil or loose rock, the posts shall be set to the full depth shown in the Plans unless penetration into solid rock reaches the minimum depths specified above, in which case the depth of penetration may be terminated. Concrete footings shall be constructed from the solid rock to the top of the ground. After the post is set and plumbed, the hole in the portion of the post in solid rock shall be filled with Grout Type 4. The grout shall be thoroughly worked into the hole so as to leave no voids.

Gate and pull posts shall be braced to the adjacent brace, end, or corner post(s) in the manner shown in the Plans. Changes in line amounting to 2-foot tangent offset or more between posts shall be considered as corners for all types of fence.

Steep slopes or abrupt topography may require changes in various elements of the fence. It shall be the responsibility of the Contractor to provide all posts of sufficient length to accommodate the chain link fabric.

All round posts shall have approved top caps fastened securely to the posts. The base of the top cap fitting for round posts shall feature an apron around the outside of the posts.

8-12.3(1)B Vacant

8-12.3(1)C Tension Wire

Tension Wires shall be attached to the posts as detailed in the Plans or as approved by the Engineer.

8-12.3(1)D Chain Link Fabric

Chain link fabric shall be attached after the cables and wires have been properly tensioned.

Chain link fabric shall be placed on the face of the post away from the Highway, except on horizontal curves where it shall be placed on the face on the outside of the curve unless otherwise directed by the Engineer.

Chain link fabric shall be placed approximately 1 inch above the ground and on a straight grade between posts by excavating high points of ground. Filling of depressions will be permitted only upon approval of the Engineer.

The fabric shall be stretched taut and securely fastened to the posts. Fastening to end, gate, corner, and pull posts shall be with stretcher bars and fabric bands spaced at intervals of 15 inches or less or by weaving the fabric into the fastening loops of roll formed posts. Fastening to posts shall be with tie wire, metal bands, or other approved method attached at 14-inch intervals. The top and bottom edge of the fabric shall be fastened with hog rings to the top and bottom tension wires as may be applicable, spaced at 24-inch intervals.

Rolls of wire fabric shall be joined by weaving a single strand into the ends of the rolls to form a continuous mesh.

8-12.3(1)E Chain Link Gates

Chain link fabric shall be fastened to the end bars of the gate frame by stretcher bars and fabric bands and to the top and bottom bars of the gate frames by tie wires in the same manner as specified for the chain link fence fabric, or by other standard methods if approved by the Engineer.

Welded connections on gate frames where the galvanized coating has been burned shall be thoroughly cleaned by wire brushing and all traces of the welding flux and loose or cracked galvanizing removed. The clean areas shall then be painted with two coats of paint, conforming to Section 9-08.1(2)B.

8-12.3(2) Wire Fence and Gates

8-12.3(2)A Posts

Line posts shall be spaced at intervals not to exceed 14 feet. All intervals shall be measured center to center of posts. In general, in determining the spacing of posts, measurements will be made parallel to the slope of the existing ground, and all posts shall be placed in a vertical position except where otherwise directed by the Engineer.

Line posts may be driven in place provided the method of driving does not damage the post. Steel corner, gate, and pull posts shall be set in concrete footings to the dimensions shown in the Plans and crowned at the top to shed water.

Concrete footings shall be constructed to embed the lower part of steel line posts, and wood anchors shall be placed on wood posts at grade depressions wherever the tension on the line wires will tend to pull the post from the ground. The concrete footings shall be 3 feet deep by 12 inches in diameter and crowned at the top.

Where solid rock is encountered without an overburden of soil, line posts shall be set a minimum depth of 14 inches and end, corner, gate, and pull posts a minimum depth of 20 inches into the solid rock. The hole shall have a minimum dimension 1 inch greater than the largest dimension of the post section to be set. The posts shall be cut before installation to lengths that will give 4½ feet of post above ground, or if the Contractor so elects, 6-foot posts set 18 inches into the solid rock may be used.

After the post is set and plumbed, the hole shall be filled with Grout Type 4. The grout shall be thoroughly worked into the hole so as to leave no voids. The grout shall be crowned to carry water away from the post. Where posts are set in the above manner, anchor plates and concrete footings will not be required.

Where solid rock is covered by an overburden of soil or loose rock, the posts shall be set to the full depth of 2½ feet unless the penetration into solid rock reaches the minimum depths specified above, in which case the depth of penetration may be terminated. When the depth of the overburden is greater than 12 inches, anchor plates will be required on the steel line posts, and concrete footings shall be constructed from the solid rock to the top of the ground on steel end, gate, corner, and pull posts. When the depth of overburden is 12 inches or less, anchor plates and concrete footings will not be required. After the post is set and plumbed, the hole in the portion of the post in solid rock shall be filled with Grout Type 4. The grout shall be thoroughly worked into the hole so as to leave no voids.

Steel braces shall be anchored to soil or loose rock with a commercial concrete footing not less than 18 inches on any one side and set in solid rock to a minimum depth of 10 inches in the same manner as specified above for posts. The braces shall be set on the diagonal as shown in the Plans and connected to the post with an approved connection.

Wood braces shall be dapped ¼ inch into the posts and shall be fastened to each post with three 20d galvanized nails.

Wire braces shall consist of a 9-gage wire passed around the wood posts to form a double wire. The wire shall be fastened to each post with two staples and fastened together to form a continuous wire. The wires shall then be twisted together until the wire is in tension.

Where the new fence joins an existing fence, the two shall be attached in a manner satisfactory to the Engineer, and end or corner posts shall be set as necessary.

Changes in alignment of 30 degrees or more shall be considered as corners, and corner posts shall be installed. Where it is deemed by the Engineer that a change in alignment of less than 30 degrees will materially lessen the strength of the fence, the line post at the angle shall be supported by the addition of braces or wires in a manner satisfactory to the Engineer.

8-12.3(2)B Barbed Wire and Wire Mesh

After the pull posts have been placed and securely braced, the barbed wire and mesh shall be pulled taut to the satisfaction of the Engineer, and each longitudinal wire shall be cut and securely fastened to the pull post with devices customarily used for the purpose. Wire or mesh shall not be carried past a pull post, but shall be cut and fastened to the pull post independently for the adjacent spans.

After the tensioning of the wire or mesh between two pull posts, all longitudinal wires shall be properly fastened at proper height to each intervening line post.

Wire mesh and barbed wire shall be placed on the face of the post which is away from the highway, except that on horizontal curves, the mesh and wires shall be fastened to the face on the outside of the curve unless otherwise directed by the Engineer.

Where unusual ground depressions occur between posts, the fence shall be guyed to the ground by means of a 9-gage galvanized wire attached to a deadman of approximately 100 pounds buried 2 feet in the ground. The guy wire shall be securely attached to each strand of barbed wire and to the top and bottom wires of the wire mesh fabric in a manner to maintain the entire fence in its normal shape. If necessary to guy the fence in solid rock, the guy wire shall be grouted in a hole 2 inches in diameter and 10 inches deep. The operation of guying shall leave the fence snug with the ground.

8-12.3(2)C Vertical Cinch Stays

Vertical cinch stays shall be installed midway between posts on both types of fence. The wire shall be twisted in such a manner as to permit weaving into the horizontal fence wires to provide rigid spacing. All barbed wires and the top, middle, and bottom wire of the wire mesh shall be woven into the stay.

8-12.3(2)D Wire Gates

The wire mesh fabric shall be taut and securely tied to the frame and stays in accordance with recognized standard practice for wire gate construction.

Welded connections on gate frames shall be treated as specified for chain link fence gates.

The drop bar locking device for double wire gates shall be provided with a footing of commercial concrete 12 inches in diameter and 12 inches deep, crowned on top and provided with a hole to receive the locking bar. The diameter and depth of the hole in the footing shall be as specified by the manufacturer of the locking device.

8-12.3(2)E Access Control Gate

Access control gates shall be placed to line and grade as shown in the Plans or as staked. After the posts have been set, the holes shall be backfilled. The postholes shall be of sufficient dimension to allow placement and thorough compaction of selected backfill material completely around the post. Selected backfill material shall consist of earth or fine sandy gravel, free from organic matter, with no individual particles exceeding 1½ inches in diameter.

8-12.4 Measurement

Chain link fence and wire fence will be measured by the linear foot of completed fence, along the ground line, exclusive of openings.

End, gate, corner, and pull posts for chain link fence will be measured per each for the posts furnished and installed complete in place.

Gates will be measured by the unit for each type of gate furnished and installed.

Access control gates will be measured per each.

8-12.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Chain Link Fence Type ____", per linear foot.

The unit Contract price per linear foot for "Chain Link Fence Type ___" shall be full payment for all costs for the specified Work including brace post installation and all other requirements of Section 8-12 for Chain Link Fence, unless covered in a separate Bid Item in this section.

Payment for clearing of fence line for "Chain Link Fence Type ____" shall be in accordance with Section 2-01.5.

"End, Gate, Corner, and Pull Post for Chain Link Fence", per each.

The unit Contract price per each for "End, Gate, Corner, and Pull Post for Chain Link Fence" shall be full payment for all costs for the specified Work.

"Double 14 Ft. Chain Link Gate", per each.

"Double 20 Ft. Chain Link Gate", per each.

"Single 6 Ft. Chain Link Gate", per each.

The unit Contract price per each for "Double 14 Ft. Chain Link Gate", "Double 20 Ft. Chain Link Gate", and "Single 6 Ft. Chain Link Gate", shall be full payment for all costs for the specified Work.

"Wire Fence Type ____", per linear foot.

The unit Contract price per each for "Wire Fence Type ____" shall be full payment for all costs for the specified Work including payment for clearing of the fence line.

"Single Wire Gate 14 Ft. Wide", per each.

"Double Wire Gate 20 Ft. Wide", per each.

The unit contract price per each for "Single Wire Gate 14 Ft. Wide" and "Double Wire Gate 20 Ft. Wide" shall be full payment for all costs for the specified Work.

"Access Control Gate", per each.

The unit contract price per each for "Access Control Gate" shall be full payment for all costs to perform the specified work.

8-13 Monument Cases

8-13.1 Description

This Work consists of furnishing and placing monument cases and covers, in accordance with the *Standard Plans* and these Specifications, in conformity with the lines and locations shown in the Plans or as staked.

8-13.2 Materials

Materials shall meet the requirements of the following sections:

Concrete	6-02
Monument Cases and Covers	9-22.1

8-13.3 Construction Requirements

The concrete base shall be placed on a well compacted foundation. The placing of the monument case and base shall be performed in a manner that will not disturb the monument.

The monument case shall be installed by the Contractor after the final course of surfacing has been placed. After the monument case has been in place for a minimum of 3 days, the Roadway surface shall be patched in a workmanlike manner.

When the monument case and cover are placed in cement concrete pavement, the concrete base will not be required.

The monument will be furnished and set by the Engineer.

8-13.4 Measurement

Measurement of monument case and cover will be by the unit for each monument case and cover furnished and set.

8-13.5 Payment

Payment will be made for the following Bid item when included in the Proposal:

"Monument Case and Cover", per each.

8-14 Cement Concrete Sidewalks

8-14.1 Description

This Work consists of constructing cement concrete sidewalks in accordance with details shown in the Plans and these Specifications and in conformity to lines and grades shown in the Plans or as established by the Engineer.

8-14.2 Materials

Materials shall meet the requirements of the following sections:

Cement	9-01
Aggregates	9-03
Premolded Joint Filler	9-04.1
Concrete Curing Materials and Admixtures	9-23

The Contractor shall use one of the detectable warning surface products listed in the Qualified Products List or seek approval through the WSDOT Request for Approval of Material process. The detectable warning surface shall have the truncated dome shape shown in the Plans. The minimum 2-foot-wide detectable warning surface area shall be yellow and shall match SAE AMS Standard 595, color number 33538. When painting a detectable warning surface is required, such as on a steel detectable warning surface, the yellow paint shall conform to Section 9-08.1(8) and shall match SAE AMS Standard 595, color number 33538.

8-14.3 Construction Requirements

The concrete in the sidewalks and curb ramps shall be air entrained concrete Class 3000 in accordance with the requirements of Section 6-02.

8-14.3(1) Excavation

Excavation shall be made to the required depth and to a width that will permit the installation and bracing of the forms. The foundation shall be shaped and compacted to a firm even surface conforming to the section shown in the Plans. All soft and yielding material shall be removed and replaced with acceptable material.

8-14.3(2) Forms

Forms shall be of wood or metal and shall extend for the full depth of the concrete. All forms shall be straight, free from warp, and of sufficient strength to resist the pressure of the concrete without springing. Bracing and staking of forms shall be such that the forms remain in both horizontal and vertical alignment until their removal. After the forms have been set to line and grade, the foundation shall be brought to the grade required and thoroughly wetted approximately 12 hours before placing the concrete.

8-14.3(3) Placing and Finishing Concrete

The concrete shall be placed in the forms and struck off with an approved straightedge. As soon as the surface can be worked, it shall be troweled smooth with a steel trowel.

After troweling and before installing the contraction joints or perimeter edging, the walking surfaces of the sidewalk and curb ramps shall be brushed in a transverse direction with a stiff bristled broom as shown in the Plans.

Expansion and contraction joints shall be constructed as shown in the Plans. When the sidewalk abuts a cement concrete curb or curb and gutter, the expansion joints in the sidewalk shall have the same spacing as the curb. The expansion joint shall be filled to full cross-section of the sidewalk with ⅜ inch premolded joint filler.

Curb ramps shall be of the type specified in the Plans and shall include the detectable warning surface.

8-14.3(4) Curing

Concrete sidewalks shall be cured for at least 72 hours. Curing shall be by means of moist burlap or quilted blankets or other approved methods. During the curing period, all traffic, both pedestrian and vehicular, shall be excluded. Vehicular traffic shall be excluded for such additional time as the Engineer may specify.

8-14.3(5) Detectable Warning Surface

The detectable warning surface shall be located as shown in the Plans. Placement of the detectable warning surface shall be in accordance with the manufacturer's recommendation for placement in fresh concrete, before the concrete has reached initial set, or on a hardened cement concrete surface or asphalt pavement surface.

Vertical edges of the detectable warning surface shall be flush with the adjoining surface to the extent possible (not more than ¼ inch above the surface of the pavement) after installation.

Embossing or stamping the wet concrete to achieve the truncated dome pattern or using a mold into which a catalyst-hardened material is applied shall not be allowed.

8-14.4 Measurement

Cement concrete sidewalks will be measured by the square yard of finished surface and will not include the surface area of the curb ramps.

Cement concrete curb ramp type _____ will be measured per each for the complete curb ramp type installed and includes the installation of the detectable warning surface.

Detectable warning surfaces will be measured by the square foot of detectable warning surface material installed as shown in the Plans.

8-14.5 Payment

Payment will be made for the following Bid items when included in the Proposal:

"Cement Conc. Sidewalk", per square yard.

"Cement Conc. Sidewalk with Raised Edge", per square yard.

"Monolithic Cement Conc. Curb and Sidewalk", per square yard.

"Cement Conc. Curb Ramp Type ___", per each

The unit Contract price per each for "Cement Conc. Curb Ramp Type____" shall be full pay for installing the curb ramp as specified, including the "Detectable Warning Surface".

Payment for excavation of material not related to the construction of the sidewalk but necessary before the sidewalk can be placed, when and if shown in the Plans, will be made in accordance with the provisions of Section 2-03. Otherwise, the Contractor shall make all excavations including haul and disposal, regardless of the depth required for constructing the sidewalk and curb ramps to the lines and grades shown, and shall include all costs thereof in the unit Contract price per square yard for "Cement Conc. Sidewalk", "Cement Conc. Sidewalk with Raised Edge", "Monolithic Cement Conc. Curb and Sidewalk", or the unit contract price per each for "Cement Conc. Curb Ramp Type ___".

"Detectable Warning Surface", per square foot.

8-15 Riprap

8-15.1 Description

This Work consists of furnishing and placing riprap protection of the type specified at the locations and in conformity with the lines and dimensions shown in the Plans or established by the Engineer.

Riprap will be classified as heavy loose riprap, light loose riprap, and hand placed riprap.

8-15.2 Materials

Materials shall meet the requirements of the following sections:

Filter Blanket ____ (shall meet the gradation requirements for Permeable Ballast)	9-03.9(2)
Gravel Backfill for Drains	9-03.12(4)
Heavy Loose Riprap	9-13
Light Loose Riprap	9-13
Hand Placed Riprap	9-13
Quarry Spalls	9-13

8-15.3 Construction Requirements

8-15.3(1) Excavation for Riprap

The foundation for riprap shall be excavated below probable scour or to the elevation shown in the Plans, and no stone shall be laid or concrete placed until the footing is approved by the Engineer. Excavation below the level of the intersection of the slope to be protected and the adjacent original ground or the channel floor or slope shall be classified, measured, and paid for as channel excavation or ditch excavation in accordance with Section 2-03. All excavation or backfill above the level of the above described intersection and all dressing of the slope to be protected shall be included in the Contract price for the class of riprap to be placed. Before placing riprap, the slopes shall be dressed to the lines and grades as staked.

8-15.3(2) Loose Riprap

Loose riprap shall be placed in such a manner that all relatively large stones shall be essentially in contact with each other, and all voids filled with the finer materials to provide a well graded compact mass. The stone shall be dumped on the slope in a manner that will ensure the riprap attains its specified thickness in one operation. When dumping or placing, care shall be used to avoid disturbing the underlying material. Placing in layers parallel to the slope will not be permitted. A 12-inch tolerance for loose riprap will be allowed from slope plane and grade line in the finished surface.

8-15.3(3) Hand Placed Riprap

The stones shall be laid by hand on prepared slopes to such thickness as may be ordered by the Engineer. The riprap shall be started at the toe of the embankment by digging a trench and placing a course of the largest stones therein. Each stone shall be placed so that it shall rest on the slope of the embankment and not wholly on the stone below, and it shall be thoroughly tamped or driven into place. The exposed face of all hand placed riprap shall be made as smooth as the shape and size of the stones will permit and shall not vary more than 3 inches from a plane surface on the required slope.

8-15.3(4) Vacant

8-15.3(5) Vacant

8-15.3(6) Quarry Spalls

Quarry spalls shall be placed in ditches and on slopes to be protected, in accordance with the Plans or as staked by the Engineer. After placement, the quarry spalls shall be compacted to be uniformly dense and unyielding.

8-15.3(7) Filter Blanket

When required, a filter blanket shall be placed on the prepared slope or area to the full thickness specified in the Plans using methods which will not cause segregation of particle sizes within the bedding. The surface of the finished layer shall be even and free from mounds or windrows. Additional layers of filter material, when required, shall be placed using methods that will not cause mixing of the materials in the different layers.

8-15.4 Measurement

Loose riprap will be measured by the ton or per cubic yard of riprap actually placed.

Hand placed riprap will be measured by the cubic yard of riprap actually placed.

Filter blanket will be measured by the ton or cubic yard of filter blanket actually placed.

Quarry spalls will be measured by the ton or per cubic yard of spalls actually placed.

Channel excavation will be measured by the cubic yard as specified in Section 2-03.

Ditch excavation will be measured by the cubic yard as specified in Section 2-03.

Excavation for toe walls and trenches will be measured by the cubic yard as ditch excavation in accordance with the provisions of Section 2-03.

8-15.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Heavy Loose Riprap", per ton or per cubic yard.

"Light Loose Riprap", per ton or per cubic yard.

"Hand Placed Riprap", per cubic yard.

The unit Contract price per ton or per cubic yard for the class or kind of riprap specified above shall be full pay for furnishing all labor, tools, equipment, and materials required to construct the riprap protection, except for excavation. When it is necessary to dump and sort individual loads, payment will be made only for that portion accepted by the Engineer.

"Quarry Spalls", per ton or per cubic yard.

The unit Contract price per ton or per cubic yard for "Quarry Spalls" shall be full pay for all costs in furnishing, placing, and compacting spalls.

"Ditch Excavation", per cubic yard.

"Filter Blanket", per cubic yard or per ton.

The unit price for "Filter Blanket" shall be full payment for all costs incurred to perform the work in Section 8-15.3(7).

"Channel Excavation", per cubic yard.

"Channel Excavation Incl. Haul", per cubic yard.

"Ditch Excavation Incl. Haul", per cubic yard.

"Payment for "Channel Excavation", "Channel Excavation Incl. Haul", "Ditch Excavation" and "Ditch Excavation Incl. Haul" is described in Section 2-03.5.

8-16 Concrete Slope Protection

8-16.1 Description

This Work consists of constructing concrete slope protection, in accordance with these Specifications and the details shown in the Plans, at the locations and in conformity with the lines, grades, and dimensions as staked.

Concrete slope protection shall consist of reinforced cement concrete poured or pneumatically placed upon the slope with a rustication joint pattern or semi-open concrete masonry units placed upon the slope closely adjoining each other.

8-16.2 Materials

Materials shall meet the requirements of the following sections:

Commercial Concrete	6-02.3(2)B
Concrete Slope Protection	9-13.5
Semi-Open Concrete Masonry Units Slope Protection	9-13.5(1)
Poured Portland Cement or Blended Hydraulic Cement Concrete Slope Protection	9-13.5(2)
Pneumatically Placed Portland Cement or Blended Hydraulic Cement Concrete Slope Protection	9-13.5(3)

8-16.3 Construction Requirements

8-16.3(1) Footing and Preparation of Slope

The footing for the slope protection shall be constructed in accordance with Sections 2-09 and 6-02.

The construction of the footing will be incidental to the slope protection, and no separate measurement or payment will be made.

The surface on which application is to be made shall be thoroughly compacted and neatly trimmed to line and grade as necessary to conform to the detail in the Plans.

8-16.3(2) Placing Semi-Open Concrete Masonry Units

The concrete masonry units shall be placed in a uniform plane and in such a manner that they rest firmly and evenly against the slope with no rocking. The concrete masonry units shall be placed in horizontal parallel courses, and successive courses shall break joints with the preceding course to form a running bond.

8-16.3(3) Poured in Place Cement Concrete

The wire mesh shall lap a minimum of one mesh spacing, and laps shall be securely fastened at the ends. During the placement of the concrete, the reinforcement shall be held so as to provide a minimum of 1¼ inch of cover.

Where commercial concrete is to be placed upon the slope, the method of depositing and compacting shall result in a compact, dense, and impervious concrete which will show a uniform plane surface.

The newly constructed concrete shall be finished by means of a wood float and shall be striated with a rustication joint as shown in the Plans.

Curing shall be performed in accordance with Section 5-05.3(13).

8-16.3(4) Pneumatically Placed Concrete

Workers – Only workers experienced in pneumatically placed concrete shall be employed; and satisfactory evidence of such experience shall be furnished when requested by the Engineer.

Equipment – The Contractor shall furnish the Engineer with two copies of the manufacturer's Specifications and operating instructions for the equipment used. Before placement of any portion of the slope protection, the type of equipment and method of operation shall be approved by the Engineer.

Proportions of Materials – The sand/cement ratio shall be 4½ parts sand to one part cement based on loose dry volume.

Water shall be maintained at a constant pressure that shall be at least 15 psi above atmospheric pressure at the nozzle. For lengths of hose up to 100 feet, pneumatic pressure at the gun shall be 45 psi or greater. Pressure shall be increased 5 psi for each additional 5 feet of hose required. A steady pressure shall be maintained.

Method of Application – Portland cement and sand shall be mixed dry, passed through a cement gun and conveyed by air through a flexible tube, hydrated at a nozzle at the end of the flexible tube, and deposited in place by air pressure.

All surfaces are to be wetted, but application shall not be made on any surface on which free water exists.

Reinforcement – The wire mesh shall lap a minimum of one mesh spacing, and laps shall be securely fastened at the ends. During the placement of the concrete, the reinforcement shall be held so as to provide a minimum of 1¾ inch of cover at the recess.

Finishing – The newly constructed concrete shall be finished by means of a wood float and shall be striated with a rustication joint as shown in the Plans.

Curing – Curing shall be in accordance with Section 5-05.3(13).

Protection of Facilities – During the construction, the Contractor shall protect all retaining walls, columns and Structures from concrete splash or overspray. Suitable covering shall be provided if such protection is deemed necessary by the Engineer.

Test Cylinders – Two test cylinders shall be made for each full day's operation. The Contractor shall furnish cylinders 6 inches in diameter and 12 inches high made of ¾-inch mesh hardware cloth. The test cylinder shall be filled with concrete by utilizing the same pneumatic application described above.

The cylinders shall develop a minimum compressive strength of 3,000 psi at the age of 28 days.

8-16.4 Measurement

Measurement for concrete slope protection will be by the square yard and will include the actual area of the slope covered excluding the footings. The area will be computed on the basis of slope measurements.

8-16.5 Payment

Payment will be made for the following Bid item when included in the Proposal:

"Conc. Slope Protection", per square yard.

8-17 Impact Attenuator Systems

8-17.1 Description

This Work consists of furnishing, constructing, repairing, and removing permanent and temporary impact attenuator systems selected from the approved list shown in the Plans.

8-17.2 Materials

Materials for inertial sand barrel systems shall be provided and installed in conformance with the manufacturer's instructions and specifications.

Undamaged sand barrel impact attenuators that have been previously utilized may be utilized in a temporary impact attenuator array only, if inspected and approved by the Engineer prior to use.

8-17.3 Construction Requirements

The assembly and installation of all attenuator systems, except those utilizing sand barrels, shall be supervised at all times by either a manufacturer's representative or an installer who has been trained and certified by the manufacturer of the system within the last 5 years and for the specific system(s) being installed. If the supervision is provided by a trained installer, a copy of the installer certification shall be provided to the Engineer prior to installation.

Assembly and installation shall be in accordance with the manufacturer's recommendations. This Work shall include the connection to a concrete barrier, bridge abutment or a transition section identified in the Plans, construction of a steel reinforced concrete pad or concrete backup, and anchorage to the pavement, if required by the manufacturer's assembly and installation procedures.

The manufacturer's representative or certified installer shall complete a manufacturer's attenuator assembly/inspection checklist for each attenuator installed. The original completed checklist, signed by the manufacturer's representative or certified installer, shall be provided to the Engineer on the same day that the attenuator installation is completed.

The Contractor shall have a complete set of replacement parts on the jobsite for each type of temporary impact attenuator in use on the project and shall repair all damaged impact attenuators immediately.

When the Engineer determines that a temporary impact attenuator is no longer needed, then the Contractor shall remove that attenuator from the project. The removed equipment shall remain the property of the Contractor.

Permanent impact attenuators shall meet the crash test and evaluation criteria of the Manual for Assessing Safety Hardware (MASH), except as otherwise noted in the Plans or Special Provisions. Temporary impact attenuators shall meet the crash test and evaluation criteria of MASH or the National Cooperative Highway Research Project Report 350 (NCHRP 350) as specified in Section 1-10.2(3).

8-17.4 Measurement

Temporary and permanent impact attenuators will be measured per each for each installation. Only the maximum number of temporary impact attenuators installed at any one time within the project limits will be measured for payment.

Resetting impact attenuators will be measured per each for each installation that is adjusted or reset to a new location on the project. The Contracting Agency will not measure resetting impact attenuators when it is for the benefit of the Contractor's operations.

8-17.5 Payment

Payment will be made for the following Bid items when they are included in the Proposal:

"Temporary Impact Attenuator", per each.

The unit Contract price for "Temporary Impact Attenuator" shall be full pay for all Work associated with the installation, maintenance, and the final removal of the temporary impact attenuator.

"Permanent Impact Attenuator", per each.

The unit Contract price for "Permanent Impact Attenuator" shall be full pay for all Work associated with furnishing, installing and all other costs involved with installing the impact attenuator in accordance with the manufacturer's recommendations.

"Resetting Impact Attenuator", per each.

The unit Contract price for "Resetting Impact Attenuator" shall be full pay for all Work associated with the removing, transporting, and resetting an impact attenuator.

If an impact attenuator is damaged by a third party, repairs shall be made in accordance with Section 1-07.13(4) under the Bid item "Reimbursement For Third Party Damage". No payment will be made for repair of impact attenuators damaged by the Contractor's operations.

8-18 Mailbox Support

8-18.1 Description

This Work consists of removing, maintaining in temporary locations during construction, and reinstalling in permanent locations, all mailboxes affected by Construction work in accordance with the Plans, these Specifications, and the *Standard Plans*.

8-18.2 Materials

Materials shall meet the requirements of the following sections:

Steel Posts	9-32.1
Bracket, Platform, and Anti-Twist Plate	9-32.2
Type 2 Mailbox Support	9-32.7
Timber Sign Posts	9-28.14(1)
Fasteners	9-32.5
Snow Guard	9-32.6
Concrete Base	9-32.8
Steel Pipe	9-32.9
U-Channel Post	9-32.10

Mailboxes will be furnished by others.

8-18.3 Construction Requirements

During construction the mailboxes shall be moved to a temporary location where their usefulness will not be impaired. The boxes shall be reinstalled at the original location or at locations determined by the Engineer in accordance with the *Standard Plans*.

The existing mailboxes shall be reinstalled on new mailbox supports, in accordance with the *Standard Plans*, within 24 hours of being removed. The existing mailbox posts shall be removed and disposed of off the project site.

Excavation for new mailbox supports shall be backfilled with adjacent native material and compacted to the satisfaction of the Engineer.

When a newspaper tube is attached to an existing mailbox installation, it shall be removed and attached under the mailbox on the new support, to the satisfaction of the Engineer.

8-18.3(1) Type 3 Mailbox Support

The concrete base shall be constructed using commercial concrete, with the pipe set to the dimensions shown in the *Standard Plans*. The base shall be crowned so as to shed water. The concrete may be mixed on the jobsite as specified in Section 6-02.3(4)B.

The U-channel post may be driven in place provided the method of driving does not damage the post.

With the Engineer's consent, a Type 3 Mailbox Support design, made of steel or other durable material, that meets the NCHRP 350 or the Manual for Assessing Safety Hardware (MASH) crash test criteria may be used in place of the design shown in the *Standard Plans*. In which case, the manufacturer's recommendations concerning installation shall be followed; however, the mailbox itself shall be positioned on the Roadway according to the dimensions shown in the *Standard Plans*.

8-18.4 Measurement

Mailbox supports will be measured by the unit for each kind of mailbox support furnished and installed in its permanent location.

8-18.5 Payment

Payment will be made for the following Bid item when it is included in the Proposal:

"Mailbox Support, Type ____", per each.

All costs for the snow guard shall be included in the unit Contract price per mailbox support involved.

8-19 Vacant

8-20 Illumination, Traffic Signal Systems, Intelligent Transportation Systems, and Electrical

8-20.1 Description

This Work consists of furnishing, installing and field testing all materials and equipment necessary to complete in place, fully functional system(s) of any or all of the following types including modifications to an existing system all in accordance with approved methods, the Plans, the Special Provisions, and these Specifications:

1. Traffic Signal System
2. Illumination System
3. Intelligent Transportation Systems (ITS)

Unless otherwise noted, the location of signals, controllers, standards, and appurtenances shown in the Plans are approximate; and the exact location will be established by the Engineer in the field.

8-20.1(1) Regulations and Code

All electrical equipment shall conform to the standards of the National Electrical Manufacturers Association (NEMA), Electric Utility Service Equipment Requirements Committee (EUSERC), and California Department of Transportation document entitled Transportation Electrical Equipment Specifications (TEES). Traffic signal control equipment shall conform to the Contract and these *Standard Specifications*: EIA Electronic Industries Alliance, IEEE Institute of Electrical and Electronics Engineers, the American Society for Testing and Materials (ASTM), the American Association of State Highway and Transportation Officials (AASHTO), the American National Standards Institute (ANSI), whichever is applicable, and to other codes listed herein. In addition to the requirements of these Specifications, the Plans, and the Special Provisions, all material and Work shall conform to the requirements of the National Electrical Code, hereinafter referred to as the Code, and any WACs and local ordinances, which may apply.

Wherever reference is made in these Specifications or in the Special Provisions to the Code, the rules, or the standards mentioned above, the reference shall be construed to mean the code, rule, or standard that is in effect on the Bid advertisement date.

In accordance with RCW 39.06.010, the Contractor need not be registered or licensed if the Contractor has been prequalified as required by RCW 47.28.070.

Safe wiring labels normally required by the Department of Labor and Industries will not be required on electrical Work within the Rights-of-Way of Contracting Agency Highways as allowed in RCW 19.28.141.

Persons performing electrical Work shall be certified in accordance with and supervised as required by RCW 19.28.161. Proof of certification shall be worn at all times in accordance with WAC 296-46B-942. Persons failing to meet these certification requirements may not perform any electrical work, and shall stop any active electrical work, until their certification is provided and worn in accordance with this section.

8-20.1(2) Industry Codes and Standards

The following electrical industry codes and standard procedures are listed for reference purposes:

Air Movement and Control Association (AMCA), 30 West University Drive, Arlington Heights, IL 60004.

American Association of State Highway and Transportation Officials (AASHTO), 444 North Capitol Street NW, Suite 225, Washington, D.C. 20001.

American National Standards Institute (ANSI), 70 East 45th Street, New York, NY.

American Society for Testing and Materials (ASTM), 1916 Race Street, Philadelphia, PA.

American Wood Protection Association (AWPA), 836 Seventeenth Street, Washington, D.C.

Bell Company Research and Evaluation (Bellcore) 31220 La Baya DR, Westlake Village, CA 91362.

Edison Electric Institute (EEI), 420 Lexington Avenue, New York, NY.

Electronics Industries Alliance (EIA), 101 Pennsylvania Avenue, Washington, D.C.

Electric Utility Service Equipment Requirements Committee (EUSERC).

Federal Communications Commission (FCC), 445 12th SW, Washington, D.C. 20554.

International Municipal Signal Association (IMSA), PO Box 539, 1115 North Main Street, Newark, NY 14513.

Institute of Electrical and Electronics Engineers (IEEE), 17th Floor, New York, NY 10016

International Telephony Communications Union (ITU) Place des Nations CH 1211 Geneva 20 Switzerland.

Institute of Transportation Engineers (ITE), 2029 K Street, Washington, D.C. 20005.

Insulated Power Cable Engineers' Association (IPCEA), 283 Valley Road, Montclair, NJ.

National Electrical Manufacturers' Association (NEMA), 155 East 44th Street, New York, NY.

National Fire Protection Association – National Electrical Code (NEC), 470 Atlantic Avenue, Boston, MA.

National Television Standards Committee (NTSC), 445 12th SW, Washington, D.C. 20554.

National Transportation Communications for ITS Protocol (NTCIP).

Rural Utilities Service (RUS), 1400 Independence Avenue, Washington, D.C.

Underwriters' Laboratories (UL), 207 East Ohio Street, Chicago, IL.

8-20.1(3) Permitting and Inspections

Electrical installations are subject to electrical inspection in accordance with RCW 19.28.101. Electrical inspections may only be performed by an electrical inspector meeting the requirements of RCW 19.28.321. Electrical installations will not be accepted until they have been inspected and approved by an electrical inspector as required by this section. This inspection is required even if there is no new electrical service or new electrical meter being installed in the Contract.

Installations within WSDOT right of way are subject to a minimum of a final inspection by a WSDOT certified electrical inspector as allowed by RCW 19.28.141. A separate permit is not required for electrical installations within WSDOT right of way. Additional inspections may be required at the discretion of the Engineer.

Installations outside of WSDOT right of way are subject to permitting and inspection by the Washington State Department of Labor and Industries (L&I) or a local jurisdiction approved for that location by L&I. Approved local jurisdictions and their contacts can be found on the L&I website at www.lni.wa.gov/TradesLicensing/Electrical/FeePermInsp/CityInspectors.

8-20.2 Materials

Materials shall meet the requirements of Section 9-29. Unless otherwise indicated in the Plans or specified in the Special Provisions, all materials shall be new.

Where existing systems are to be modified, the existing material shall be incorporated in the revised system, salvaged, or abandoned as specified in the Contract documents, or as ordered by the Engineer.

8-20.2(1) Equipment List and Drawings

Within 20 days following execution of the Contract, the Contractor shall submit to the Engineer a completed “Request for Approval of Material” that describes the material proposed for use to fulfill the Plans and Specifications.

If required to do so, the Contractor shall submit Type 2 Working Drawings consisting of supplemental data, sample articles, or both, of the material proposed for use. Supplemental data includes such items as catalog cuts, product Specifications, shop drawings, wiring diagrams, etc.

If the luminaires are not listed in the Qualified Products List, the Contractor shall submit Type 2 Working Drawings consisting of the following information for each different type of luminaire required on the Contract:

1. Isocandela diagrams showing vertical light distribution, vertical control limits, and lateral light distribution classification.
2. Details showing the lamp socket positions with respect to lamp and refractor for each light distribution type. This requires that the Contracting Agency know what the light pattern available are and the light distribution.

The Contractor shall submit for approval Type 3E Working Drawings in accordance with Section 1-05.3 for each of the following types of standards called for on this project:

1. Light standards without preapproved plans.
2. Signal standards with or without preapproved plans.

The Contractor will not be required to submit shop drawings for approval for light standards and traffic signal standards conforming to the preapproved plans listed in the Special Provisions. The Contractor may use preapproved plans posted on the WSDOT website with a more current revision date than stamped in the Special Provisions.

The Engineer's acceptance of any submitted documentation shall in no way relieve the Contractor from compliance with the safety and performance requirements as specified herein.

Submittals required shall include but not be limited to the following:

1. A Type 2 Working Drawing consisting of a material staging plan, should the Contractor propose Contracting Agency-owned property for staging areas.
2. A Type 2 Working Drawing consisting of a cable vault installation plan showing the exact proposed installation location by Roadway station, offset and the scheduled sequence for each cable vault installation.
3. A Type 2 or 2E Working Drawing consisting of a pit plan, for each boring pit, depicting the protection of traffic and pedestrians, pit dimensions, shoring, bracing, struts, walers, sheet piles, conduit skids, and means of attachment, casing type, and casing size. A Type 2E Working Drawing is only required where shoring, bracing, struts, walers, sheet piles, or casing are used.
4. A Type 2 or 2E Working Drawing consisting of a boring plan depicting the boring system and entire support system. A Type 2E Working Drawing is only required if a support system is used.

8-20.3 Construction Requirements

8-20.3(1) General

All workmanship shall be complete and in accordance with the latest accepted standards of the industry.

Work shall be so scheduled that each electrical system is operational prior to opening the corresponding section of Roadway to traffic.

Existing electrical systems, traffic signal or illumination, or approved temporary replacements, shall be kept in effective operation during the progress of the Work, except when shutdown is permitted to allow for alterations or final removal of the system.

Illumination system shutdowns shall not interfere with the regular lighting schedule, unless permitted by the Engineer. The Contractor shall notify the Engineer prior to performing any Work on existing systems.

Traffic signals shall not be placed in operation for use by the public until all required channelization, pavement markings, illumination, signs, and sign lights are substantially complete and operational unless otherwise allowed by the Engineer. New signal systems may not be turned on any sooner than the next working day following the completion of test number 4 of Section 8-20.3(11).

When field repair of existing conduit, innerduct or outerduct is required, the repair kits shall be installed per manufacturer's recommendations. Repair kits and each connection point between the repair kit and the existing raceway system shall be sealed to prevent air leakage during future cable installation.

All costs incurred by the Contractor for providing effective operation of existing electrical systems shall be included in the associated electrical Bid items.

8-20.3(1)A Maintenance During Construction

The Contractor is responsible for maintenance of all new, existing, and temporary systems included in the work, starting from the first on-site working day and ending upon final acceptance of the system.

For existing systems where only part of an existing system is included in the work, the responsibility for maintenance shall be determined between the Contractor and the Engineer as part of the preconstruction conference. Normally, this will be based on whether a majority of the system is included in the work.

Maintenance responsibilities for these systems includes the following:

1. For all system types, the Contractor is responsible for performing locates for all underground portions of all systems for which the Contractor has maintenance responsibility. Locate requests for these systems will be provided to the Contractor by the Contracting Agency.

2. For illumination and power distribution systems (power connections from a service or transformer cabinet to a system cabinet), the Contractor is responsible for all work necessary to maintain required lighting operational, including providing and replacing lamps and responding to electrical outages.
3. For traffic signal systems, the Contractor is responsible for all equipment outside of the controller cabinet, up to and including the landing of field wiring in the controller cabinet. The Contracting Agency shall retain maintenance responsibility for all equipment inside the traffic signal controller cabinet.
4. For ITS equipment, the Contractor is responsible for all equipment in the system.

8-20.3(1)B Communication System Repairs

If a portion of an existing communication conduit system is damaged due to the Contractor's activities, the affected system shall be restored to original condition. Conduit shall be repaired. Communication cables shall be replaced and the communication system shall be made fully operational within 24 hours of being damaged.

Damaged communication cable shall be replaced between existing termination or splice points. No additional termination or splice points will be allowed. An existing termination or splice point is defined as a location where all existing fiber strands or twisted pair wires are terminated or spliced at one point. Communication cable shall be defined as either copper twisted pair or fiber optic cables. The Contractor may use temporary splices to restore WSDOT communication systems until the permanent communication cable system is restored.

When damage to an existing communication system has occurred, the Contractor shall perform the following in addition to other restoration requirements:

1. Inspect the communication raceway system including locate wire or tape to determine the extent of damage.
2. Contact the Engineer for Fiber Optic Cable and Twisted Pair (TWP) Copper Cable acceptance testing requirements and communication system restoration requirements.
3. Initially perform the acceptance tests to determine the extent of damage and also perform the acceptance tests after repairs are completed. Provide written certification that the communication cable system, including the locate wire or tape, is restored to test standard requirements.

Communication cables shall be restored by Contractor personnel that are WSDOT prequalified for communication installation work. Restoration shall be considered electrical work when the path of the communication system interfaces with electrical systems. Electrical work of this nature shall be performed by Contractor personnel that are WSDOT prequalified for work on both electrical and communication systems.

If the Contractor or Subcontractors are unable or unqualified to complete the restoration work, the Engineer may have the communication or electrical systems restored by other means and subtract the cost from the money that will be or is due the Contractor.

8-20.3(1)C Removal of Embedded Anchors

Where embedded anchors attaching existing electrical, illumination, and traffic signal systems to concrete Structures are specified for removal, they shall be removed a minimum of 1 inch beneath the existing concrete surface. The void left by removal of the embedded anchors shall be coated with epoxy bonding agent and filled with mortar conforming to Section 9-20.4(2). The epoxy bonding agent shall be Type II, conforming to Section 9-26.1, with the grade and class as recommended by the epoxy bonding agent manufacturer. The mortar shall consist of cement and fine aggregate mixed in the proportions to match the color of the existing concrete surface as near as practicable.

8-20.3(2) Excavating and Backfilling

The excavations required for the installation of conduit, foundations, poles and other-accessories shall be performed in a manner that prevents damage to the streets, sidewalks, and other improvements. The trenches shall not be excavated wider than necessary for the proper installation of the electrical accessories and foundations. Excavating shall not be performed until immediately before installation of conduit and other accessories. The material from the excavation shall be placed where the least interference to vehicular and pedestrian traffic, and to surface drainage, will occur.

All surplus excavated material shall be removed and disposed of by the Contractor in accordance with Section 2-03, or as ordered by the Engineer in accordance with Section 1-04.4.

The excavations shall be backfilled in conformance with the requirements of Section 2-09.3(1)E, Structure Excavation.

At the end of each day's Work and at all other times when construction operations are suspended, all equipment and other obstructions shall be removed from that portion of the Roadway open for use by public traffic.

Excavations in the street or Highway shall be performed in such a manner that not more than one traffic lane is restricted in either direction at any time unless otherwise approved by the Engineer.

8-20.3(3) Removing and Replacing Improvements

Improvements such as sidewalks, curbs, gutters, Portland cement concrete and hot mix asphalt pavement, bituminous surfacing, base material, and any other improvements removed, broken, or damaged by the Contractor, shall be replaced or reconstructed with the same kind of materials as found on the Work or with other materials satisfactory to the Engineer.

Whenever a part of a square, slab, or section of existing concrete sidewalk, curb, gutter or driveway is broken or damaged, the entire square, slab or section, curb, gutter, driveway shall be removed and the concrete reconstructed as specified above.

The outline of all areas to be removed in Portland cement concrete sidewalks and pavements and hot mix asphalt pavements shall be cut to a minimum depth of 3 inches with a saw prior to removing the sidewalk, driveway, slabs and pavement material. The cut for the remainder of the required depth may be made by a method satisfactory to the Engineer. Cuts shall be neat and true with no shatter outside the removal area.

8-20.3(4) Foundations

Foundation concrete shall conform to the requirements for the specified class, be cast-in-place concrete and be constructed in accordance with Sections 6-02.2 and 6-02.3. Concrete for Type II, III, IV, V, and CCTV signal standards and light standard foundations shall be Class 4000P and does not require air entrainment. Concrete for pedestals and cabinets, Type PPB, PS, I, FB, and RM signal standards and other foundations shall be Class 3000. Concrete placed into an excavation where water is present shall be placed using an approved tremie. If water is not present, the concrete shall be placed such that the free-fall is vertical down the center of the shaft without hitting the sides, the steel reinforcing bars, or the steel reinforcing bar cage bracing. The Section 6-02.3(6) restriction for 5-feet maximum free-fall shall not apply to placement of Class 4000P concrete into a shaft. Steel reinforcing bars for foundations shall conform to Section 9-07.

The bottom of concrete foundations shall rest on firm ground. If the portion of the foundation beneath the existing ground line is formed or cased instead of being cast against the existing soil forming the sides of the excavation, then all gaps between the existing soil and the completed foundation shall be backfilled and compacted in accordance with Section 2-09.3(1)E.

Foundations shall be cast in one operation where practicable. The exposed portions shall be formed to present a neat appearance.

The top edges of the luminaire foundation, traffic signal standard foundations, electrical service foundations, traffic signal controller cabinets, Transformer cabinets, ITS Standards, and ITS cabinets shall have a ¾-inch chamfer on the top edge of the foundation. Where one or more of the above foundations directly abut each other, no chamfer shall be permitted.

Where soil conditions are poor, the Engineer may order the Contractor to extend the foundations shown in the Plans to provide additional depth. Such additional Work will be paid for according to Section 1-04.4.

When slip bases are installed the conduit, anchor bolts, and other obstructions shall terminate at a height below the elevation of the top of the bottom slip plate. The galvanized surfaces of the slip plates, the keeper plate and the luminaire base plate shall be smooth, without irregularities, to reduce friction and to prevent slacking of bolt tension due to flattening of the irregularities. Slip base luminaire foundations shall have a maximum conduit size of 1-inch.

Forms shall be true to line and grade. Tops of foundations for posts and standards, except special foundations, shall be finished to ground line or sidewalk grade, unless otherwise noted in the Plans.

Forms shall be rigid and securely braced in place. Conduit ends and anchor bolts shall be plumbed and rigidly placed in proper position and to proper height prior to placing concrete and shall be held in place by means of a template until the forms are removed.

Anchor bolts shall be installed so that two full threads extend above the top of the top heavy-hex nut, except that slip base anchor bolt extensions shall conform to the specified slip base clearance requirements. Anchor bolts shall be installed plumb, plus or minus 1 degree.

See Section 8-20.3(9) for additional grounding requirements.

Plumbing of standards shall be accomplished by adjusting leveling nuts. Shims or other similar devices for plumbing or raking will not be permitted except on power installed hot dipped galvanized steel luminaire foundations.

The top heavy-hex nuts of light standards and signal standards shall be tightened in accordance with Section 6-03.3(33), and as follows:

1. The top heavy-hex nuts for all clamping bolts of slip base light standards and Type RM and FB signal standards, shall be tightened using a torque wrench to the torque specified in Sections 8-20.3(13)A and 8-20.3(14)E, respectively.
2. The top heavy-hex nuts for type ASTM F1554 grade 105 anchor bolts shall be tightened by the Turn-of-Nut Tightening Method to a minimum rotation of ¼ turn (90 degrees) and a maximum rotation of ⅓ turn (120 degrees) past snug tight. Permanent marks shall be set on the base plate and nuts to indicate nut rotation past snug tight.
3. The top hex nuts for type ASTM F1554 grade 55 anchor bolts shall be tightened by the Turn-of-Nut Tightening Method to a minimum rotation of ⅛ turn (45 degrees) and a maximum rotation of ⅙ turn (60 degrees) past snug tight. Permanent marks shall be set on the base plate and nuts to indicate nut rotation past snug tight.

Both forms and ground which will be in contact with the concrete shall be thoroughly moistened before placing concrete; however, excess water in the foundation excavation will not be permitted. Foundations shall have set at least 72 hours prior to the removal of the forms. All forms shall be removed, except when the Plans or Special Provisions specifically allow or require the forms or casing to remain.

Class 2 surface finish shall be applied to exposed surfaces of concrete in accordance with the requirements of Section 6-02.3(14)B.

Where obstructions prevent construction of planned foundations, the Contractor shall construct an effective foundation satisfactory to the Engineer.

The combined height of the light standard concrete foundation plus the anchor bolt stub height shall not exceed 4-inches above the ground line.

8-20.3(5) Conduit

8-20.3(5)A General

The ends of all conduit, metallic and nonmetallic, shall be reamed to remove burrs and rough edges. Field cuts shall be made square and true. The ends of unused conduits shall be capped. When conduit caps are removed, the threaded ends of metal conduit shall be provided with approved conduit bushings and non-metal conduit shall be provided with end bells.

Reducing couplings will not be permitted.

Existing conduit in place scheduled for installation of new conductor(s) shall first have any existing conductor(s) removed and a cleaning mandrel shall be pulled through. The existing conduit shall then be prepared subject to the same requirements outlined in this paragraph, for new conduit and innerduct, unless otherwise indicated in the Plans. All new conduit and all innerduct shall be blown clean with compressed air. Then in the presence of the Engineer, an 80 percent sizing mandrel, correctly sized for the raceway, shall be pulled through to ensure that the raceway has not been deformed. This shall be done prior to pulling wire or fiber optic cable and after final assembly is in place. Existing conductor(s) shall be reinstalled unless otherwise indicated in the Plans.

Immediately after the sizing mandrel has been pulled through, install an equipment grounding conductor if applicable (see Section 8-20.3(9)) and any new or existing wire or cable as specified in the Plans.

All conduits shall include a pull tape with the equipment grounding conductor. The pull tape shall be attached to the conduit near the end bell or grounded end bushing, or to duct plugs or caps if present, at both ends of the conduit.

8-20.3(5)A1 Fiber Optic Conduit

Where conduit to contain fiber optic cable or conduit identified to contain future fiber optic cable is installed by open trenching, Detectable Underground Warning Tape shall be placed 12-inches above the conduit unless otherwise detailed in the Plans. Detectable Underground Warning Tape shall extend 2-feet into boxes or vaults. Splicing of the tape shall be per the tape manufacturer's recommended materials and procedures.

8-20.3(5)A2 ITS and Cabinet Outer and Inner Duct Conduit

ITS conduit and both ends of conduit runs entering cabinets, with the exception of the ½-inch grounding conduit, shall be sealed with self expanding water proof foam or mechanical plugs; unless otherwise required. At other locations conduit shall be sealed with Duct Seal.

Outer-duct conduit with non factory assembled innerduct shall be sealed around the innerduct with self-expanding waterproof foam. Outer-duct conduit with factory assembled innerduct shall be sealed around the innerduct with a multiplex expansion plug. Innerduct containing one cable shall be plugged using an expandable split plug. Innerduct with multiple cables shall be sealed with self-expanding waterproof foam.

Duct plugs shall be installed in all unused inner-ducts (those that are specified as empty) at the time of conduit installation. Duct plugs shall be installed in all used inner-ducts (as specified in the Plans), at the time of conduit installation, unless cable pulling for those inner-ducts will commence within 48-hours. Installation shall conform to the manufacturer's recommendations.

Foam sealant shall be installed with the following additional requirements:

1. Penetration of the sealant into the conduit or duct shall be limited using a high temperature backer rod material or rag.
2. Penetration of the sealant into the conduit shall be limited to 1-inch.
3. The foam sealant shall not project outside the end of the conduit or duct.

Where open trenching is allowed and conduit with innerduct is installed, a maximum of 1000-feet of continuous open trench will be allowed unless otherwise approved by the Engineer.

8-20.3(5)B Conduit Type

Conduit shall be rigid polyvinyl chloride (PVC), high density polyethylene (HDPE), rigid metal or flexible metal depending on the application.

Rigid metal conduit shall be installed at the following locations:

1. Within railroad right of way.
2. All surface-mounted conduit, with the exception of pole risers.
3. All runs within slip form placed concrete.
4. Conduits connecting a service or transformer cabinet to a grounding electrode system, unless otherwise specified in the Plans.

Unless otherwise required by the owning utility:

1. Service lateral runs shall be Schedule 80 PVC or Schedule 80 HDPE.
2. Pole risers shall be Schedule 80 PVC.

PVC and HDPE conduits shall be Schedule 80 unless installed as innerduct.

Flexible metal conduit is allowed only at locations called for in the Plans.

Except as described under Non-Metallic Conduit, unless otherwise indicated in the Plans or Standard Plans, the same type of conduit shall be used for the entire length of the run, including conduits for grounding electrode systems, from outlet to outlet.

Innerduct shall have a smooth wall non ribbed interior surface, with factory pre-lubricated coating.

Innerduct within the Traveled Way or Shoulders and innerduct which is not factory installed shall be Schedule 40 HDPE. The innerduct shall be continuous with no splices. Innerduct which is pulled into the outer duct in the field shall be installed with an extra 2 feet of conduit beyond each end of the outer-duct and shall be allowed to finish

contracting for 21 calendar days before it is terminated. Innerduct shall be terminated with end bells flush to ¼-inch out of the outer-duct and the space between the outer-duct and innerduct shall be sealed with rodent and moisture resistant foam designed for this application and installed per manufacturer's recommendations.

8-20.3(5)B1 Rigid Metal Conduit

Slip joints or running threads will not be permitted for coupling metallic conduit; however, running threads will be permitted in traffic signal head spiders and rigid metal conduit (RMC) outer-duct. When installing rigid metal conduit (RMC), if a standard coupling cannot be used, an approved three-piece coupling shall be used. Conduit bodies, fittings and couplings for rigid metal conduit (RMC) shall be cleaned first and then painted with one coat of paint conforming to Section 9-08.1(2)B. The paint shall have a minimum wet film thickness of 3-mils. The painted coating shall cover the entire coupling or fitting. The threads on all metal conduit shall be rust-free, clean, and painted with colloidal copper suspended in a petroleum vehicle before couplings are made. All metallic couplings shall be tightened so that a good electrical connection will be made throughout the entire length of the conduit run. If the conduit has been moved after assembly, it shall be given a final tightening from the ends prior to backfilling.

Rigid metal conduit (RMC) ends shall be terminated with grounded end bushings. Rigid metal conduit (RMC) entering cable vaults or pull boxes shall extend 2-inches beyond the inside wall face (for the installation of grounded end bushing and bonding).

Rigid metal conduit (RMC) entering concrete shall be wrapped in 2-inch-wide pipe wrap tape with a minimum 1-inch overlap for 12-inches on each side of the concrete face. Pipe wrap tape shall be installed per the manufacturer's recommendations.

Rigid metal conduit (RMC) bends shall have a radius consistent with the requirements of Code Article 344.24 and other articles of the Code. Where factory bends are not used, conduit shall be bent, using an approved conduit bending tool employing correctly sized dies, without crimping or flattening, using the longest radius practicable.

Where the coating on galvanized conduit has been damaged in handling or installing, such damaged areas shall be thoroughly painted with paint conforming to Section 9-08.1(2)B.

Metal conduit ends shall be threaded and protected with a snug fitting plastic cap that covers the threads until wiring is started.

8-20.3(5)B2 Non-Metallic Conduit

Where non-metallic conduit is installed, care shall be used in excavating, installing, and backfilling, so that no rocks, wood, or other foreign material will be left in a position to cause possible damage.

PVC conduit ends shall be terminated with end bell bushings. PVC or HDPE conduit entering cable vaults and pull boxes shall terminate with the end bell flush with the inside walls of the Structure.

Non-metallic conduit bends, where allowed, shall conform to Article 352.24 of the Code. Eighteen-inch radius elbows shall be used for PVC conduit of 2-inch nominal diameter or less. Standard sweep elbows shall be used for PVC conduit with greater than 2-inch nominal diameter unless otherwise specified in the Plans. In nonmetallic conduit less than 2-inch nominal diameter, pull ropes or flat tapes for wire installation shall be not less than ¼-inch diameter or width. In nonmetallic conduit of 2-inch nominal diameter or larger, pull ropes or flat tapes for wire installation shall be not less than ½-inch diameter or width. When HDPE conduit is used for directional boring, it shall be continuous, with no joints, for the full length of the bore. The conduit run shall be extended to the associated outlets with the same schedule HDPE or PVC conduit. Entry into associated junction box outlets shall be with the same schedule PVC conduit and elbows. The same requirements apply for extension of an existing HDPE conduit crossing.

PVC conduit and elbows shall be connected to HDPE conduit with an approved mechanical coupling. The connection shall have minimum pullout strength of 700-pounds. Prior to installation of a mechanical coupling, the HDPE conduit shall first be prepared with a clean, straight edge. A water-based pulling lubricant may be applied to the threaded end of the mechanical coupling before installation. Solvent cement or epoxy shall not be used on the threaded joint when connecting the HDPE conduit to the mechanical coupling. The mechanical coupling shall be rotated until the HDPE conduit seats approximately ¾ of the distance into the threaded coupling depth.

For PVC installation through a directional bore, the PVC shall be in rigid sections assembled to form a watertight bell and spigot-type mechanical joint with a solid retaining ring around the entire circumference of the conduit installed per the manufacturer's recommendations. The conduit run shall be extended beyond the length of the bore, to the associated outlets with the same mechanical coupled PVC or with standard PVC conduit of the same schedule. The same requirements apply for extension of an existing PVC conduit Roadway crossing.

PVC conduit shall be assembled using the solvent cement specified in Section 9-29.1.

Conduit ends shall be protected with a snug fitting plastic cap until wiring is started.

Conduit caps, end bells and the section of PVC between the coupling and end bell bushing in cabinet foundations shall be installed without glue.

8-20.3(5)C Conduit Size

The size of conduit used shall be as shown in the Plans. Conduits smaller than 1-inch electrical trade size shall not be used unless otherwise specified, except that grounding conductors at service points may be enclosed in ½-inch-diameter conduit.

Conduit between light standards, PPB, PS, or Type 1 poles and the nearest junction box shall be the diameter specified in the Plans. Larger size conduit is not allowed at these locations. At other locations it shall be the option of the Contractor, at no expense to the Contracting Agency, to use larger size conduit if desired, provided that junction box or vault capacity is not exceeded. Where larger size conduit is used, it shall be for the entire length of the run from outlet to outlet.

Conduit runs with innerduct, shall have 4-inch outer-duct and shall be installed with four 1-inch innerduct unless otherwise indicated in the Plans.

8-20.3(5)D Conduit Placement

Conduit shall be laid so that the top of the conduit is a minimum depth of:

1. 24-inches below the bottom of curb in the sidewalk area.
2. 24-inches below the top of the untreated surfacing on a Roadbed.
3. 48-inches below the bottom of ties under railroad tracks unless otherwise specified by the railroad company.
4. 36-inches below finish grade when installed using conduit plowing method.
5. 24-inches below the finish grade in all other areas.

Conduit entering through the bottom of a junction box shall be located near the end walls to leave the major portion of the box clear. At all outlets, conduit shall enter from the direction of the run, terminating 6 to 8-inches below the junction box lid and within 3-inches of the box wall nearest its entry location.

Conduit runs shown in the Plans are for Bidding purposes only and may be relocated with approval of the Engineer, to avoid obstructions.

8-20.3(5)D1 Surface Mounting

Where surface mounting of conduit is required, supports shall consist of channel with clamps sized for the conduit. Support spacing shall comply with the Code, with the exception that spacing of channel supports for conduit shall not exceed 5-feet.

The minimum distance between adjacent clamps and between the clamp and the end of the channel supports shall be 1-inch. Channel supports shall be installed with stops, to prevent clamps from sliding out of the ends.

8-20.3(5)D2 Structures

All conduits attached to or routed within bridges, retaining walls, and other structures shall be equipped with approved expansion, deflection, and/or combination expansion/deflection fittings at all expansion joints and at all other joints where structure movement is anticipated, including locations where the Contractor, due to construction method, installs expansion and/or construction joints with movement. All conduit fittings shall have movement capacity appropriate for the anticipated movement of the Structure at the joint. Approved deflection fittings shall also be installed at the joint between the bridge end and the retaining wall end, and the transition from bridge, wall, or other structure to the underground section of conduit pipe.

8-20.3(5)E Method of Conduit Installation

Conduit shall be placed under existing pavement by approved directional boring, jacking, or drilling methods at locations approved by the Engineer. The pavement shall not be disturbed unless allowed in the Plans or with the approval of the Engineer in the event obstructions or impenetrable soils are encountered. High density polyethylene (HDPE) conduit runs, which enter the traveled way or shoulders, shall be installed using the directional boring method.

8-20.3(5)E1 Open Trenching

When open trenching is allowed, trench construction shall conform to the following:

1. The pavement shall be saw-cut a minimum of 3-inches deep. The cuts shall be parallel to each other and extend 2-feet beyond the edge of the trench.
2. Pavement shall be removed in an approved manner.
3. Trench depth shall provide a minimum cover for conduit of 24-inches below the top of the roadway base.
4. Trench width shall be 8-inches or the conduit diameter plus 2-inches, whichever is larger.
5. Trenches located within paved Roadway areas shall be backfilled with Controlled density fill (CDF) meeting the requirements of Section 2-09.3(1)E. The controlled density fill shall be placed level to, and at the bottom of, the existing pavement. The pavement shall be replaced with paving material that matches the existing pavement.
6. On new construction, conduit shall be placed prior to placement of base course pavement.

8-20.3(5)E2 Conduit Plowing

All conduit plowing shall be supervised by a licensed electrical Contractor.

The starting point shall be anchored or held such that conduit movement at the start of the plowing operation is kept to a minimum. The conduit reel shall be mounted on the vehicle such that conduit movement is kept to a minimum once it is in the ground. Use of a stationary reel is not allowed. The feed shoe shall have rollers which conform to the conduit at a radius of not less than 15 times the diameter of the conduit. The conduit will not be permitted to pass over stationary guides nor over rollers or sheaves, which will permit a bend radius of less than 15 times conduit diameter. The width of the tooth and feed shoe shall not exceed the conduit diameter by more than two-inches.

The conduit shall be installed using a continuous reel, with no joints, for the full length of the conduit run, unless conduit splicing is allowed as indicated below.

If an obstruction is encountered that cannot be plowed through, the following remedies shall be attempted in order:

1. Contractor shall stop the plowing operation and attempt to remove the obstruction. If the obstruction is removed, plowing operations shall continue along the approved path.
2. Deviations of up to one foot from the projected path may be authorized by the Engineer, provided the new route does not result in total conduit run bends exceeding NEC requirements. Deviations in excess of one foot from the projected path are not allowed and the maximum taper rate is 1-inch per linear foot of conduit.
3. The Contractor may request approval to intercept the installed conduit and route another section of HDPE to avoid the obstruction, provided the new route does not result in total conduit run bends exceeding NEC requirements. Connection between the sections shall be accomplished using an approved fusion splicing method, which is compatible with the conduit manufacturer's recommendations.
4. Where none of the above remedies are successful, all conduit installed so far in that run shall be removed and a new plow path established to avoid the obstruction.

In the event of a breakage, all conduit installed in that run shall be removed.

The conduit run shall be extended to the associated outlets, subject to the same requirements indicated when HDPE is installed using the directional boring method.

The depth of installation shall be continually adjusted as necessary to compensate for changes in terrain.

Plowed conduit shall be laid so that the top of the conduit is a minimum depth of 36-inches below the finish grade with the exception that the conduit shall be swept up to enter the knock outs of associated pull boxes or cable vaults.

The plow placing the conduit shall be marked at a proper distance above the plow's conduit exit point to indicate when the minimum installation depth is not met. The mark shall be visible from a safe distance from the plowing operation when it is exposed above ground. While plowing this mark must remain below ground level at all times, with the exception of the entry and exit points at the end of the run, in order to ensure that minimum burial depth of the conduit is achieved.

If the depth mark on the plow comes above ground, the Contractor shall stop the plowing operation and attempt to correct the placement depth. If the conduit depth can be verified to meet the minimum burial requirements at the location where the depth mark came above ground, the plowing operation shall resume subject to the Engineers approval.

The compacted surface shall be firm, non-yielding, and result in a finished surface that matches the lines and grades of the terrain prior to plowing.

8-20.3(5)E3 Boring

Bore pits shall be backfilled and compacted in accordance with Section 2-09.3(1)E. Directional boring, jacking or drilling pits shall be a minimum of 2-feet from the edge of any type of pavement, unless otherwise approved by the Engineer. Excessive use of water that might undermine the pavement or soften the Subgrade will not be permitted.

When approved by the Engineer, small test holes may be cut in the pavement to locate obstructions. When the Contractor encounters obstructions or is unable to install conduit because of soil conditions, as determined by the Engineer, additional Work to place the conduit will be paid in accordance with Section 1-04.4.

8-20.3(5)E4 Directional Boring

Directional boring for electrical installations shall be supervised by a licensed electrical contractor in accordance with Section 8-20.1(1). Where directional boring is called for, conduit shall be installed using a surface-launched, steerable drilling tool. Drilling shall be accomplished using a high-pressure fluid jet tool-head. The drilling fluid shall be used to maintain the stability of the tunnel, reduce drag on the conduit, and provide backfill between the conduit and tunnel. A guidance system that measures the depth, lateral position, and roll shall be used to guide the tool-head when creating the pilot hole. Once the pilot hole is established, a reamer and swivel shall be used to install the conduit. Reaming diameter shall not exceed 1.5 times the diameter of the conduits being installed. Conduit that is being pulled into the boring shall be installed in such a manner that the conduit is not damaged during installation. The pullback force on the conduit shall be controlled to prevent damage to the conduit. A vacuum spoils extraction system shall be used to remove any excess spoils generated during the installation. Excess drilling fluid and spoils shall be disposed of. The method and location used for disposal of excess drilling fluid and spoils shall be subject to the Engineer's approval. Drilling fluid returns (caused by fracturing of formations) at locations other than the entry and exit points shall be minimized. Any drilling fluid that surfaces through fracturing shall be cleaned up immediately. Mobile spoils-removal equipment capable of quickly removing spoils from entry or exit pits and areas with returns caused by fracturing shall be used as necessary during drilling operations.

8-20.3(5)E5 Boring with Casing

Where boring with casing is called for, the casing shall be placed using an auger inside the casing to remove the soil as the casing is jacked forward. The auger head shall proceed no more than 4-inches ahead of the pipe being jacked. Boring operations shall be conducted to prevent caving ahead of the pipe. Installed casing pipe shall be free from grease, dirt, rust, moisture, and any other deleterious contaminants.

The space between the conduit and casing shall be plugged with sandbags and a grout seal 12-inches thick at each end of the casing. Casing abandoned due to an encountered obstruction shall be grout sealed in the same manner. Grout shall conform to Section 9-20.3(4).

In lieu of sandbags and grout, unopened prepackaged concrete and grout may be used to seal the casing.

Material shall not be removed from the boring pit by washing or sluicing.

All joints shall be welded by a Washington State certified welder. Welding shall conform to AWS D 1.1-80 Structural Welding Code, Section 3, Workmanship.

8-20.3(6) Junction Boxes, Cable Vaults, and Pull boxes

Standard Duty and Heavy-Duty junction boxes, pull boxes, and cable vaults shall be installed at the locations shown in the Plans. The Contractor may install, at no expense to the Contracting Agency, such additional boxes as may be desired to facilitate the Work. Junction box installation shall conform to details in the *Standard Plans*.

Cable vaults and pull boxes shall be installed in accordance with the following:

1. Excavation shall be performed in accordance with Section 2-09.
2. Cable vaults and pull boxes shall be installed on 6-inches of crushed surfacing, in accordance with Section 9-03.9(3), placed on a compacted or undisturbed level foundation.
3. All openings around conduits shall be sealed and filled with grout in accordance with Sections 6-02.3(20), and 9-20.3(4) to prevent water and debris from entering the vaults or pull boxes.
4. Backfilling around the Work shall not be allowed until the concrete or mortar has set.
5. Pull boxes shall be installed in accordance with Plans and details.
6. Pull boxes shall be configured such that the tensile and bending limitations of the fiber optic and other cables are not compromised. Pull boxes shall be configured to mechanically protect the fiber optic and other cables against installation force as well as inert forces after cable pulling operations.
7. Upon acceptance of Work, cable vaults, and pull boxes shall be free of debris and ready for cable installation. All grounding requirements shall be met prior to cable installation.
8. Where installed near steel casings, the pull boxes and cable vaults shall be offset 3 feet, minimum, from the centerline of the casing. Factory bends shall be used to route the conduits to the cable vault or pull box.

Adjustments involving raising or lowering the junction boxes shall require conduit modification if the resultant clearance between the top of the conduit and the junction box lid becomes less than 6 inches or more than 10 inches in accordance with the Plans.

Cable vaults and pull boxes shall be adjusted to final grade using risers or rings manufactured by the cable vault and pull box manufacturer. Cable vaults and pull boxes with traffic bearing lids shall be raised to final grade using ring risers to raise the cover only. All voids resulting from the adjustment shall be backfilled with materials matching adjacent surfacing material and compacted in accordance with Section 2-09.3(1)E.

Damage to the junction boxes, pull boxes, cable vaults and the associated conduit system, or wiring resulting from the Contractor's operations, shall be repaired to the Engineer's satisfaction at no additional cost to the Contracting Agency.

Both existing and new junction boxes, pull boxes, and cable vaults shall be adjusted to be flush with the finished grade as well as with the grade during the various construction stages proposed in the Contract.

Where conduit and junction boxes are placed in barrier, the Contractor shall coordinate the Work of the Contractor constructing the barrier and the electrical Contractor so that each junction box placed in the barrier is placed in correct alignment with respect to the barrier, with the face of the box flush or uniformly chamfered within ⅛ inch of the barrier surface. If any point on the surface of the junction box placed in barrier is recessed more than ⅛ inch from the surface of the barrier, the Contractor shall install a box extension meeting the Engineer's approval and grout around the extension or remove and replace the entire section of barrier.

Standard Duty pull boxes, cable vaults, and concrete junction boxes installed in sidewalks, walkways, and shared-use paths shall have slip-resistant surfaces, be flush with the surface, and match the grade of the sidewalk, walkway, and shared-use path. The boxes, vaults, and junction boxes shall not be placed in curb ramps, curb ramp landings, or the gutter areas associated with the curb ramps.

8-20.3(7) Messenger Cable, Fittings

Messenger cable shall be secured to steel strain poles by means of pole bands, and to timber poles by means of single strand guy eye bolts. Pole bands and eyebolts shall be installed as detailed in the Plans.

Messenger cable shall be secured to eye bolts or strain clamps at poles by the use of approved self-locking cable clamp type dead-ending devices. Messenger cable shall be secured to bull rings and anchors by two approved U-bolt connectors and guy thimbles.

Traffic signal control cable shall be secured to the messenger cable by cable ties. The ties shall be black nylon with ultraviolet protection and rated at 120-pound minimum unlocking strength.

Down guy assemblies shall be installed as detailed in the *Standard Plans*.

8-20.3(8) Wiring

All underground wiring shall be installed in conduit unless specifically noted otherwise in the Contract. All wiring in conduit shall be installed with a lubricant recommended by cable/conductor manufacturer.

With the exception of induction loop circuits, magnetometer circuits and illumination circuits, all wiring shall run continuously, without splices, from a terminal located in a cabinet, compartment, pedestrian push button assembly, or signal head to a similarly located terminal. Illumination circuit terminals and traffic circuit signal terminals located

below grade will not be allowed. Video detection systems cable installation shall follow manufacturer's Specification, except no below grade terminals will be allowed.

All splices in underground illumination circuits, induction loops circuits, and magnetometer circuits shall be installed in junction boxes. The only splice allowed in induction loop circuits and magnetometer circuits shall be the splice connecting the induction loop lead in conductors or magnetometer lead in conductors to the shielded lead in cable. Splices for induction loop circuits and magnetometer circuits shall be: heat shrink type with moisture blocking, material sized for conductors, epoxy filled clear rigid mold splice kits or rigid re-enterable type splice kits. Conductors for rigid mold kits shall be centered in the splice mold prior to installation of the encapsulation material. Magnetometer and induction loop splices shall be soldered. All connections with #10 and smaller wire shall use copper crimped connectors installed with a positive action (ratchet) tool, except where setscrew connections are allowed for quick disconnects as described in Section 9-29.7. The non-insulated die shall be an indent type and insulated die shall be of a smooth shape capable of crimping pre-insulated terminals and connectors. The tool shall be compound lever type with a ratchet mechanism to ensure positive closure for full crimping cycle. The tool shall be field adjustable to proper calibration with common tools and materials. All connectors installed in splices shall be wrapped with two layers of electrical tape. All epoxy splice kits shall be physically separated from other splices and wiring within the junction box to avoid damage from heat during the casting process.

All termination for traffic signal control systems shall follow the conductor sequence color code as shown in the following table.

Conductor Number	Color Code	Color Trace	Use
1	R	Red	Red or Don't Walk
2	O	Orange	Yellow or Spare
3	G	Green	Green or Walk
4	W	White	Neutral
5	B	Black	Ped Call or Spare
6	Wb	White/Black	Neutral or Spare
7	Bl	Blue	Ped Call or Spare
8	Rb	Red/Black	Red or Don't Walk
9	Ob	Orange/Black	Yellow or Spare
10	Gb	Green/Black	Green or Walk

Splices and taps on underground circuits shall be made with solderless crimp connectors meeting the requirements of Section 9-29.12.

Only one conductor or one multiconductor cable per wire entrance will be allowed in any rigid mold splice.

Aerial illumination splices shall employ vice or crimp type pressure connectors. Splice insulation may be epoxy, heat shrink, or tape. Tape splice insulation, where allowed, shall consist of thermoplastic electrical insulating tape equivalent to the original wire insulation rating. It shall be well lapped over the original insulation, and there shall be a coating of

moisture resistant varnish applied and allowed to dry. Two layers of friction tape will then be applied, and the splice shall be finished with a second complete coating of moisture resistant varnish.

Quick disconnect connectors shall be installed in the base of all poles supporting a luminaire. Every conductor above ground potential shall be served by a fused quick disconnect kit. Every conductor at ground potential shall be served by an unfused quick disconnect kit.

Pole and bracket cable meeting the requirements of Section 9-29.3(2)D shall be installed between the quick disconnects and the luminaire and between the sign light hand hole and the isolation switch. In addition, the conductors from the isolation switch and the sign light shall be minimum AWG 14, meeting the requirements of Sections 9-29.3(2)A or 9-29.3(2)B. Pole and bracket cable jacket shall be removed from the quick disconnect to within 2 inches below the support bracket clamp.

Sufficient slack wire shall be installed at each junction box to allow any conductor, cable, or splice within the junction box to be raised a minimum of 18 inches outside of the box.

Insulated neutral conductors shall be identified in accordance with the NEC requirements. Every conductor at every wire termination, connector, or device shall have an approved wire marking sleeve bearing as its legend, the circuit number indicated in the Contract. All terminal strips shall also bear the circuit number consistent with the Contract.

At all illumination circuit splices, each wire entering the splice shall have an approved wire marking sleeve bearing as its legend the circuit number indicated in the Contract.

All wiring, exclusive of the previously mentioned illumination circuits, at all junction boxes, pull boxes, cable vaults, poles, and cabinets shall have an approved tag with legends as follows:

1. Individual conductors – the circuit number indicated in the Contract.
2. Multiconductor cable – the numbers of the signal heads and/or pedestrian push buttons served.
3. Loop lead-in cable – the numbers of the loops served.
4. Magnetometer cable – the numbers of the magnetometers served.
5. Video detection camera lead-in cable – the numbers of the phases the camera served.
6. ITS cameras – the number of the camera indicated in the Contract and the number of the associated cabinet as indicated in the Plans.
7. Communication cable – labeled as Comm.

Drip loops shall be provided on all aerial conductors where they enter poles, signal heads, or weather heads.

When conductors, either cable or single, are being installed, the Contractor shall not exceed the tension limitations recommended by the manufacturer. Conductors may

be pulled directly by hand or with mechanical assistance. If conductors are pulled by any mechanical means, a dynamometer with drop-needle hand shall be used on every mechanically assisted pull.

On mechanically assisted pulls, insulation shall be stripped off the individual conductor and the conductor formed into a pulling eye and firmly attached to the pulling rope/tape, or a cable grip shall be used. The Contractor shall determine the maximum allowable pulling tension, taking into account the direction of the pull, type of raceway, cable geometry, weight of the cable, the coefficient of friction, and side wall pressure, using the information from the cable manufacturer. If there are bends in the raceway or sheaves are used for the cable pull, the contractor shall use the cable manufacture's side wall pressure limits to determine the maximum pulling tension. The maximum pulling force applied directly to the conductor when pulling eyes are used or when the conductor is formed into a loop, shall be limited to that shown in the following table for copper conductor. When a cable grip is applied over nonmetallic sheathed cables, the maximum pulling force shall be limited to 1,000 pounds provided this is not in excess of the force as determined above.

Conductor	Pounds
8	132
6	210
4	334
3	421
2	531
1	669
1/0	845
2/0	1,065
3/0	1,342
4/0	1,693
250 Kcmil	2,000
500 Kcmil	4,000

Adequate lubrication of the proper type to reduce friction in conduit and duct pulls shall be utilized. The grease and oil-type lubricants used on lead sheathed cables shall not be used on nonmetallic sheathed cables. Pulling tape shall meet the requirements of Section 9-29.1(10). Pull string may not be used.

When wiring is noted for future connection, the ends of each wire or cable shall be sealed with an approved heat shrink end cap.

If loop lead splices are not installed immediately after the installation of the loop leads into the adjacent junction box, the ends of the two conductor "home run" cable shall be sealed with heat shrink end caps to prevent entry of moisture into the two conductor cable. All coaxial cables shall have heat shrink end caps installed prior to aerial or underground installation of the cables to prevent moisture entry into the cable.

Multiconductor cable for signal displays shall be installed entirely through the mounting fitting to a point a minimum of 1 inch inside the signal display housing before the outer insulation is stripped back for the connection of individual conductors to the terminal block.

Installation of coaxial or coaxial/Siamese cable or data cables with a 600 VAC rating will be allowed in the same raceway with 480 VAC illumination cable.

8-20.3(9) Bonding, Grounding

All metallic appurtenances containing electrical conductors (luminaires, light standards, cabinets, metallic conduit, etc.) shall be made mechanically and electrically secure to form continuous systems that shall be effectively grounded.

Install an equipment grounding conductor in all new conduit, whether or not the equipment grounding conductor is called for in the wire schedule.

For each new conduit with innerduct install an equipment grounding conductor in only one of the innerducts unless otherwise required by the NEC or the plans.

Bonding jumpers and equipment grounding conductors meeting the requirements of Section 9-29.3(2)A3 shall be minimum #8 AWG, installed in accordance with the NEC. Where existing conduits are used for the installation of new circuits, an equipment grounding conductor shall be installed unless an existing equipment ground conductor, which is appropriate for the largest circuit, is already present in the existing raceway. The equipment ground conductor between the isolation switch and the sign lighter fixtures shall be minimum #14 AWG stranded copper conductor. Where parallel circuits are enclosed in a common conduit, the equipment-grounding conductor shall be sized by the largest overcurrent device serving any circuit contained within the conduit.

Junction boxes with metallic lids shall have one 4-foot long tinned braided copper equipment bonding strap with full circle connector lugs installed from each metallic junction box lid(s) to the junction box frame. A non-insulated stranded copper conductor, minimum #8 AWG, with a full circle crimp on connector (crimped with a manufacturer recommended crimper) shall be connected to the junction box frame or frame bonding stud, the other end shall be crimped to the equipment bonding conductor, using a “C” type crimp connector. The equipment ground conductor shall not be cut or spliced except at junction boxes.

Supplemental grounding shall be provided at light standards, signal standards, cantilever and sign bridge Structures. Steel sign posts which support signs with sign lighting or flashing beacons shall also have supplemental grounding. The supplemental ground conductor shall be connected to the foundation rebar (all rebar crossings shall be wire tied) by means of a grounding connector listed for use in concrete, and lead up directly adjacent to a conduit installed within the foundation. The free end of the conductor shall be terminated to the ground terminal, with an approved clamp, within the pole. If no ground terminal is provided, bond to standard or post. Three-feet of slack shall be provided inside the standard. Where a concrete and rebar foundation is not used the supplemental ground shall be a grounding electrode placed in the hole next to the post

prior to back fill. For light standards, signal standards, cantilever and sign bridge Structures the supplemental grounding conductor shall be #4 AWG non-insulated stranded copper conductor. For steel sign posts which support signs with sign lighting or flashing beacons the supplemental grounding conductor shall be #6 AWG non-insulated stranded copper conductor.

All connectors between bonding jumpers and equipment grounding conductors shall be installed in accordance with the NEC. Identification of the equipment grounding conductor shall conform to all code requirements.

Bonding of the equipment grounding system and neutral at the service point shall be accomplished as required under the NEC. Grounding of the neutral shall be accomplished only at the service or at a separately derived system.

Install a two grounding electrode system at each service entrance point, at each electrical service installation and at each separately derived power source. The service entrance grounding electrode system shall conform to the "Service Ground" detail in the *Standard Plans*. If soil conditions make vertical grounding electrode installation impossible an alternate installation procedure as described in the NEC may be used. Maintain a minimum of 6 feet of separation between any two grounding electrodes within the grounding system. Grounding electrodes shall be bonded copper, ferrous core materials and shall be solid rods not less than 10 feet in length if they are ½ inch in diameter or not less than 8 feet in length if they are ⅝ inch or larger in diameter.

The connection of the grounding electrode conductor to the grounding electrode shall be made with two approved ground clamps.

Messenger cable shall be bonded to steel strain poles by means of a bond strap connected between an approved U-bolt connector and a bonding lug on the pole.

At points where shields or shielded conductors are grounded, the shields shall be neatly wired and terminated on grounding terminal strip.

All system bonding and grounding shall be complete and approved before energizing associated circuits or equipment.

8-20.3(10) Service, Transformer, and Intelligent Transportation System (ITS) Cabinets

Power sources shown in the Plans are approximate only; exact location will be determined in the field.

Aerial fed transformer cabinets and type A, type B, or type C service cabinets shall include a timber pole, as specified in Section 9-29.6(3), a meter base, installed in accordance with serving utility requirements, a 2- or 3-wire service breaker of size noted in the Plans, the necessary conduit risers and ground assembly as noted in the *Standard Plans*. The timber pole shall be set at a depth of 10 percent of the total pole length plus 2 feet. Modified type B, type D and type E services shall be installed per Contract Plan, and service description in *Standard Plans*. Pad mounted transformer cabinets shall be installed per Contract Plans.

The service breaker shall be a standard thermal circuit breaker encased in a raintight housing that can be padlocked.

Upon request of the Contractor, the Engineer will make the necessary arrangements with the serving utility to complete the service connections. Electrical energy used prior to Completion of the Contract will be charged to the Contractor, except that the cost of energy used for public benefit, when the Engineer orders such operation, will be borne by the Contracting Agency.

The service, transformer and ITS cabinets shall be marked with the service agreement letters and numbers as noted in the Plans. The markings shall be installed on the outside cabinet door near the top of the cabinet. The markings shall be series C using stencils and black enamel alkyd gloss paint conforming to Federal Specification TT-E-489F.

8-20.3(11) Testing

The Contractor shall conduct the following tests on all electrical circuits with nominal operating voltage between 115-volts and 600-volts, in the presence of the Engineer:

1. Test the continuity of each circuit.
2. Test for grounds in each circuit, which shall consist of the physical examination of the installation to ensure that all required ground jumpers, devices, and appurtenances do exist and are mechanically firm.
3. Using a megohm meter, a 500-volt test on each new circuit between the conductor and ground with all switch boards, panel boards, fuse holders, switches, receptacles, and overcurrent devices in place. All readings shall be recorded. The Contractor shall furnish the Engineer with three copies of the test results identifying observed readings with their respective circuits.

   The insulation resistance shall not be less than 50 megohms between the conductor and ground on new circuits with a total single conductor length of 2,500 feet and over, nor less than 50 megohms on new circuits with single conductor length of less than 2,500 feet.

   Any change in the above stated minimum readings must be approved in writing by the Engineer. Only those factors based on dialectric properties of conductor insulations, splicing insulations, terminal strip castings, etc., will be cause for consideration of a variance.
4. A functional test in which it is demonstrated that each and every part of the system functions as specified.

For those new circuits below 115-volts nominal, except induction loop circuits and test direct burial circuits, the circuits shall be tested with a 500-volt megger for continuity, ground, and a test to demonstrate the circuit functions as specified. The megger test shall show an insulation resistance of not less than 8-megohms to ground.

Any fault in any material or in any part of the installation revealed by these tests shall be replaced or repaired by the Contractor in a manner approved by the Engineer, and the same test shall be repeated until no fault appears.

When the project includes a traffic signal system, the Contractor shall conduct tests noted in Section 8-20.3(14)D. The Contractor shall provide the Engineer a minimum of 5 days advance written notice of the proposed traffic signal turn-on date and time. The traffic signal turn-on procedure shall not begin until all required channelization, pavement markings, illumination, signs, and sign lights are substantially complete and operational unless otherwise allowed by the Engineer. The Contractor shall provide traffic control to stop all traffic from entering the intersection. The Contracting Agency electronics technician will program the controller and enter the timing data, then turn the traffic signal system to its flash mode to verify proper flash indications. The Contracting Agency electronics technician will then conduct functional tests to demonstrate that each part of the traffic signal system, illumination system, or other electrical system, functions as specified. These demonstrations shall be conducted in the presence of a Contracting Agency electronic technician, the Contracting Agency electrical Inspector, and Regional Traffic Engineer or his/her designee. The Contracting Agency electronics technician will then turn the traffic signal to stop and go operation for no less than one full cycle. Based on the results of the turn-on, the Engineer will direct the Contracting Agency electronics technician to either turn the traffic signal on to normal stop and go operation, to turn the signal to flash mode for a period not to exceed 5 calendar days, or to turn the signal off and require the Contractor to cover all signal displays and correct all deficiencies.

If the Contractor is directed to turn off the traffic signal, the Contractor shall schedule a new turn-on date with the Engineer in accordance with the previously mentioned procedures.

Unless approved by the Engineer no change to signal stop and go operation will be allowed between 6:00 a.m. to 10:00 a.m. and 2:00 p.m. to 7:00 p.m. on Monday through Thursday, nor will signal operation changes be allowed on Friday, weekends, holidays, or the day preceding a holiday.

8-20.3(12) Painting

All painting required shall be done in conformance with applicable portions of Section 6-07.

8-20.3(13) Illumination Systems

8-20.3(13)A Light Standards

Light standards shall be handled when loading, unloading, and erecting in such a manner that they will not be damaged. Any parts that are damaged due to the Contractor's operations shall be repaired or replaced at the Contractor's expense.

Light standards shall not be erected on concrete foundations until foundations have set at least 72 hours or attained a compressive strength of 2,400 psi, and shall be raked sufficiently to be plumb after all load has been placed.

Slip base installation shall conform to the following:

1. The slip plane shall be free of obstructions such as protruding conduit or anchor bolts. The anchor bolts, and other obstructions shall terminate at a height below the elevation of the top of the slip plate. Conduit shall extend a maximum of 1 inch above the top of the foundation, including grounding end bushing or end bell bushing.
2. Washers in the slip plane shall be placed between the slip plate and the keeper plate.
3. Anchor bolts shall extend through the top heavy-hex nut two full threads to the extent possible while conforming to the specified slip base clearance requirements. Anchor bolts shall be tightened by the Turn-of-Nut Tightening Method in accordance with Sections 6-03.3(33) and 8-20.3(4).
4. Clamping bolts shall be tightened in accordance with Sections 6-03.3(33) and 8-20.3(4). The clamping bolts shall be tightened to the specified torque, plus or minus 2 percent, in two stages using an accurately calibrated torque wrench before erecting the light standard. Except as otherwise specified, the Contractor shall install 1-inch diameter clamping bolts in all slip bases to a torque of 95 foot-pounds.
5. The galvanized surfaces of the slip plates, the keeper plate and the luminaire base plate shall be smooth, without irregularities, to reduce friction and to prevent slackening of bolt tension due to flattening of the irregularities.
6. Anchor bolts damaged after the foundation concrete is placed shall not be repaired by bending or welding. The Contractor's repair procedure is to be submitted to the Engineer for approval prior to making any repairs. The procedure is to include removing the damaged portion of the anchor bolt, cutting threads on the undamaged portion to remain, the installation of an approved threaded sleeve nut and stud, and repairing the foundation with epoxy concrete. Epoxy concrete shall meet the requirements of Section 9-26.3(1)B.
7. The grout pad shall not extend above the elevation of the bottom of the anchor plate.
8. Wiring for slip base installation shall conform to details in the *Standard Plans*.

Breakaway coupling installation shall conform to the following:

1. At existing foundations, the anchor nuts, pole, grout pad, and leveling nuts shall be removed. Conduits shall be cut to a maximum height of 2 inches above the foundation including grounding end bushing or end bell bushing. Paint, conforming to Section 9-08.1(2)B, shall be applied to the cut conduit that has been threaded. Anchor bolts that are damaged shall be repaired with approved sleeve nuts as noted under slip base installation procedures.
2. All existing anchor bolts shall be cut off 2½ to 3 inches above the foundation. At new foundations, the anchor bolts shall be installed with top of bolt 2½ to 3 inches above the foundation.

3. Couplings shall be installed to within ⅛ to ⅜ inch of the foundation. Couplings shall then be leveled.
4. The pole shall be set and plumbed; and washers, nuts, and skirt installed per manufacturer's recommendations.
5. The conduit installed in a luminaire foundation shall not exceed 1 inch, trade size.

Slip base insert installations shall conform to details in the *Standard Plans*, and shall conform to items 1 through 8 above for slip base installation, except that the specified torque for the ⅞-inch diameter clamping bolts shall be 50 foot-pounds.

Prior to installation all relocated metal light standards shall have existing painted identification markings removed. Manufactures Identification tag shall not be removed. Damaged surfaces and coatings shall be repaired with material matching the existing coating.

All new light standards shall have an approved metal tag riveted to the pole above the handhole. The information provided on the tag shall be as noted on the preapproved drawings.

All new and relocated metal light standards shall be numbered for identification using painted 4 inch block gothic letters (similar to series C highway lettering) and numbers installed 3 feet above the base facing the Traveled Way. Paint shall be black enamel alkyd gloss conforming to Federal Specification TT-E-489. The following information shall be provided as shown in the Plans:

NN

CC-SSSS

VVV

Where:

NN	=	Is the pole number as identified in the Plans. May be one or more characters.
CC	=	Is the circuit letter as identified in the Plans. May be one or more characters.
SSSS	=	Is the service cabinet number as identified in the Plans. Do not include the two or three letter prefix. Up to four digits - do not include leading zeros.
VVV	=	Is the operating voltage of the luminaire. Always three digits.

In setting timber poles, the Contractor shall provide a minimum burial of 10 percent of the total pole length plus 2 feet and shall rake the poles as shown in the Plans.

8-20.3(13)B Vacant

8-20.3(13)C Luminaires

The Contractor shall mark the installation date on the inside of the luminaire ballast or driver housing using a permanent marking pen.

All luminaires shall be mounted level, both transverse and longitudinally, as measured across points specified by the manufacturer. Leveling and orientation shall be accomplished after pole plumbing.

8-20.3(13)D Sign Lighting

Sign illumination equipment shall include fixtures, brackets, conduit, electrical wire, and other material required to make the sign lighting system operable. Sign illumination fixtures shall be fused according to the table in Section 9-29.7.

8-20.3(13)E Sign Lighting Luminaires

The sign lighting luminaire shall be supported by a lighting bracket assembly as detailed in the Plans. If the sign Structure includes a maintenance walkway, the luminaire fixture mounting plate shall be bolted to the walkway grating.

An isolation switch shall be provided in the line side conductors, mounted over the Shoulder to de-energize all luminaires for maintenance purposes. The switch shall be single pole, single throw, or double-pole, single throw as necessary to open all conductors to the luminaires other than neutral and ground conductors. The switch shall contain 600-volt terminal strips on the load side with solderless box lugs as required plus 4 spare lugs per strip. The switch enclosure shall be rated NEMA 3R.

8-20.3(14) Signal Systems

8-20.3(14)A Signal Controllers

All control cabinets and control equipment shall be factory wired ready for operation. Field work will be limited to placing cabinets and equipment and connecting the field wiring to field terminal strips. All controller cabinets shall be installed on a silicone seal pad.

Controllers for portable traffic signal systems shall conform to the requirements of Section 9-29.13(7).

8-20.3(14)B Signal Heads

Unless ordered otherwise by the Engineer, signal heads shall not be installed at any intersection until all other signal equipment is installed and the controller is in place, inspected, and ready for operation at that intersection, except that the signal heads may be mounted if the faces are covered to clearly indicate the signal is not in operation.

Three section displays mounted on type M mounts shall have the plumbizer between the top and second display. Four and five section vertical displays mounted on type M mounts shall have the plumbizer between the second and third display.

8-20.3(14)C Induction Loop Vehicle Detectors

Induction loops shall be constructed as detailed in the Contract and the following:

1. Loop wire shall conform to Section 9-29.3.
2. Lead-in cable shall conform to Section 9-29.3.
3. All loops shall be installed after grinding or prior to paving the final lift of asphalt designated in the Contract. Loop conductors shall be held at the bottom of the saw

cut by high temperature backer rod (sized to fit snugly in the saw cut). Two-inch-long pieces of the backer rod shall be installed on 24-inch centers along the entire loop and home run(s) and at the entrance and exit of all turns greater than 45 degrees. If new loops are installed over existing the old loops shall be removed by grinding and the grinding shall be deep enough to destroy any existing operational loop conductors. If not listed as incidental to another item or paid for under another Bid item the additional Work to remove the existing loops shall be paid in accordance with Section 1-04.4.

4. Each loop shall be the size and number of turns indicated in the Plans.
5. No loop installation will be done in rainy weather or when the pavement is wet.
6. All sawcuts shall be cleaned with a high-pressure washer and dried with 100 psi minimum air pressure, to the satisfaction of the Engineer. If traffic is allowed over the sawcut prior to wire installation, the sawcuts shall be cleaned again.
7. Wiring shall be installed with a blunt-nosed wooden wedge.
8. Prior to the installation of the high temperature backer rod all slack shall be removed from the wiring. Kinks in wiring or folding back of excess wiring will not be allowed.
9. High temperature backer rod, sized for snug fit shall be installed in the saw cut on 2-foot centers and at all sharp turns.
10. Install sealant as per Contract or as approved by the Engineer.
11. Sealant shall be applied such that air bubbles or foam will not be trapped in the sawcut.

8-20.3(14)D Test for Induction Loops and Lead-In Cable

All tests shall be performed by the Contractor in the presence of the Engineer for each loop. The tests shall be performed at the amplifier location after complete installation of the loop. All costs associated with testing shall be included in the unit Contract prices of the respective Bid items.

Test A – The DC resistance between the two lead-in cable wires will be measured by a volt ohmmeter. The resistance shall not exceed 10 ohms.

Test B – A megohm meter test at 500 volts DC shall be made between the lead-in cable shield and grounding, prior to connection to grounding. The resistance shall equal or exceed 100 megohms.

Test C – A megger test shall be made between the loop circuit and grounding. The resistance shall equal or exceed 100-megohms.

Test D – An inductance test to determine the inductance level of each inductance loop. The Contractor shall record the inductance level of each inductance loop installed on the project and shall furnish the findings to the Engineer. An inductance level below 150 microhenries is considered a failure for a Type 1 loop, any one round loop and an inductance level below 75 microhenries is considered a failure for a Type 2 loop.

If any of the installations fails to pass all tests, the loop installation or lead-in cable shall be repaired and replaced and then retested.

8-20.3(14)E Signal Standards

Traffic signal standards shall be furnished and installed in accordance with the methods and materials noted in the Contract and the following:

1. All dimensions and orientations will be field verified by the Engineer prior to fabrication.
2. The signal standard component identification shall conform to details in the Plans.
3. Disconnect connectors complete with pole and bracket cable shall be installed in any signal standard supporting a luminaire. Illumination wiring installation shall conform to details in the Plans for slip base wiring.
4. No field drilling will be allowed on signal mast arms except for the installation of any required pre-empt indicators, pre-empt detectors, microwave detector, or type “N” signal mountings. The maximum diameter shall be 1 inch.
5. All pole entrances required for pole-mounted signal heads, cabinets, signs, pedestrian push button assemblies, etc., shall be field drilled.
6. Damage to the galvanized pole surface resulting from field drilling shall be repaired with approved zinc rich paint.
7. Field welding will not be allowed, except as shown in the Plans.
8. All tenons shall be factory installed.
9. All welding shall be completed prior to galvanizing.
10. Foundations shall be constructed to provide the pole orientation noted in the Plans. Anchor bolts shall be tightened in accordance with Sections 6-03.3(33) and 8-20.3(4).
11. Slip base installation for Type RM and FB signal standards shall conform to the slip base installation requirements specified in Section 8-20.3(13)A, except that the specified torque for the ¾-inch diameter clamping bolts shall be 50 foot-pounds.
12. The pole shall be plumbed after signal heads are installed.
13. The space between the bottom base plate and the top of foundation shall be filled with grout with a ⅜-inch plastic drain tube.

Signal standards shall not be erected on concrete foundations until the foundations have attained 2,400 psi or 14 days after concrete placement. Signal standards without mast arms may be erected after 72 hours. Type IV and V strain pole standards may be erected but the messenger cable (span wire) shall not be placed until the foundation has attained 2400 psi or 14 days after concrete placement.

Signal supports used with portable traffic signal systems shall provide a minimum of two signal displays, spaced a minimum of 8 feet apart.

When portable traffic signals are used to provide alternating one-way control, a minimum of one of the signal displays shall be suspended over the Traveled Way. The minimum vertical clearance to the Traveled Way for this signal display is 16′ 6″.

Timber strain poles shall be set a burial depth of 10 percent of the total length plus 2 feet and shall be raked as noted in the Plans.

8-20.3(15) Grout

Grout shall conform to the requirements of Section 6-02.3(20) and 9-20.3(4).

8-20.3(16) Reinstalling Salvaged Material

When the Contract requires salvaged electrical equipment to be reinstalled, the Contractor shall furnish and install all necessary materials and equipment, including anchor bolts, nuts, washers, concrete, etc., required to install the salvaged equipment.

8-20.3(17) "As Built" Plans

Upon Physical Completion of the Work, the Contractor shall submit corrected shop drawings, schematic circuit diagrams, or other drawings necessary for the Engineer to prepare corrected Plans to show the Work as constructed.

These drawings shall be on sheets conforming in size to the provisions of Section 1-05.3.

8-20.4 Measurement

Conduit of the kind and diameter specified will be measured, through the junction boxes, by the linear foot of conduit placed, unless the conduit is included in an illumination system, signal system, intelligent transportation system, or other type of electrical system lump sum Bid item.

Casing will be measured by the linear foot for the actual length of casing placed, unless the casing is included in an illumination, signal, or other electrical system lump sum Bid item.

Directional boring will be measured by the linear foot for the length of the boring tunnel.

8-20.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Illumination System ____", lump sum.

"Traffic Signal System ____", lump sum.

"ITS ____", lump sum.

The lump sum Contract price for "Illumination System, ____", "Traffic Signal System ____", or "ITS _____" shall be full pay for the construction of the complete electrical system, modifying existing systems, or both, including sign lighting systems, as described above and as shown in the Plans, and herein specified, including excavation, backfilling, concrete foundations, conduit, wiring, restoring facilities destroyed or damaged during construction, salvaging existing materials, and for making all required tests. All additional materials and labor, not shown in the Plans or called for herein and which are required to complete the electrical system, shall be included in the lump sum Contract price.

"Conduit Pipe ____ In. Diam.", per linear foot.

The unit Contract price per linear foot for "Conduit Pipe____ In. Diam." shall be full pay for furnishing all pipe, pipe connections, elbows, bends, caps, reducers, conduits, unions, junction boxes, and fittings; for placing the pipe in accordance with the above provisions, including all excavation, jacking, or drilling required, backfilling of any voids around casing, conduits, pits, or trenches; restoration of native vegetation disturbed by the operation, chipping of pavement, and bedding of the pipe; and all other Work necessary for the construction of the conduit, except that when conduit is included on any project as an integral part of an illumination, traffic signal, or ITS system, and the conduit is not shown as a pay item, it shall be included in the lump sum price for the system shown.

All costs for installing conduit containing both signal and illumination wiring shall be included in the Contract prices for the signal system.

All costs for installing junction boxes containing both illumination and signal wiring shall be included in the Contract prices for the signal system.

"Casing", per linear foot.

The unit Contract price per linear feet for "casing" shall be full payment for boring, jacking or drilling for installing casing, and backfilling any voids around the casing and pits or back filling of the trenches required to install the casing. This cost will also include any restoration of native vegetation disturbed by the operation.

"Directional Boring", per linear foot

The unit Contract price per linear foot for "Directional Boring", shall be full pay for furnishing all labor, materials, equipment and electrical supervision associated with the directional boring.

8-21 Permanent Signing

8-21.1 Description

This Work consists of furnishing and installing permanent signing, sign removal, sign relocation, and refacing existing signs in accordance with the Plans, these Specifications, and at the locations shown in the Plans or where designated by the Engineer.

8-21.2 Materials

Materials shall meet the requirements of the following sections:

Roadside Sign Structures	9-06.16
Permanent Signs	9-28
Sign Support Structures	9-28.14
Temporary Casing	9-36.1(2)
Synthetic Slurry	9-36.2(2)
Water Slurry	9-36.2(3)

The Contractor shall submit a Manufacturer's Certificate of Compliance for all permanent signs in accordance with Section 1-06.3; a copy of the Manufacturer's Certificate of Compliance shall be available at the fabricator's plant. Permanent signs will be inspected at the fabricator's plant prior to shipment to the project unless otherwise accepted by the Engineer. Signs without an approved decal will not be installed on the project with the exception of double-faced signs which do not receive decals or fabricator's stickers.

8-21.3 Construction Requirements

8-21.3(1) Location of Signs

Signs are located in the Plans by station numbers. These are tentative locations subject to change by the Engineer. The post lengths specified in the Plans are estimated for Bid purposes only. Final lengths of timber posts will be determined or verified by the Engineer at the request of the Contractor prior to fabrication. Final lengths of steel posts will be determined by the Engineer prior to fabrication.

8-21.3(2) Placement of Signs

All reflectorized signs located less than 30 feet from the edge of the lane should be turned out approximately 3 degrees from the pavement edge of oncoming traffic lanes, and those located 30 feet or more from the edge of the lane should be turned in approximately 3 degrees from the pavement edge of oncoming traffic lanes. All sign posts shall be plumb and signs level. The signs shall be inspected at night by the Engineer and, if specular glare occurs from failure to install at 3 degrees as stipulated, the Contractor shall reinstall the signs at no expense to the Contracting Agency. The post holes shall be of sufficient dimensions to allow placement and thorough compaction of selected backfill material completely around the post. Selected backfill material shall consist of earth or fine sandy gravel free from organic matter with no individual particles exceeding 1½ inches in diameter.

8-21.3(3) Sign Covering

When notified by the Engineer, the Contractor shall cover or uncover certain signs to facilitate and control the operation of the project. The covering shall consist of 4 mils minimum thickness black polyethylene sheeting of sufficient size to entirely cover the sign, unless otherwise approved by the Engineer, and shall extend over the edges of the sign and fastened on the back. The Contractor shall not use any type of adhesive tape on the face of the signs. Other methods of covering may be considered if approved by the Engineer.

8-21.3(4) Sign Removal

Where shown in the Plans or ordered by the Engineer, the existing signs and, if so indicated, the sign Structures shall be removed by the Contractor.

Sign Structures shall include sign bridges, cantilever sign Structures, bridge-mounted sign brackets, and any other sign-mounting Structure shown in the Plans to be removed by the Contractor.

The embedded anchors attaching signs and sign Structures specified for removal to existing concrete Structures shall be removed a minimum of 1 inch beneath the existing concrete surface. The void left by removal of the embedded anchors shall be coated with epoxy bonding agent and filled with mortar conforming to Section 9-20.4(2). The epoxy bonding agent shall be Type II, conforming to Section 9-26.1, with the grade and class as recommended by the epoxy bonding agent manufacturer and as approved by the Engineer. The mortar shall consist of cement and fine aggregate mixed in the proportions to match the color of the existing concrete surface as near as practicable.

Where indicated, the Contractor shall remove concrete pedestals to a minimum of 2 feet below Subgrade or finished ground elevation and backfill the hole to the satisfaction of the Engineer. Where an existing sign post is located within a sidewalk area, the Contractor shall remove the post and finish the area so as to make the sidewalk continuous. Where signs are removed from existing overhead sign Structures, the existing vertical sign support braces shall also be removed. The removed aluminum signs, wood signs, wood sign posts, wood structures, metal sign posts, wind beams, and other metal structural members and all the existing fastening hardware connecting such members shall become the property of the Contractor and shall be removed from the project. Salvage value of the removed signs and sign Structure members shall be reflected in the Contractor's Bid price for other items of Work.

8-21.3(5) Sign Relocation

Where shown in the Plans, the existing signs and, if so indicated, the sign Structures shall be relocated by the Contractor to the location noted. Where the existing sign Structure is mounted on concrete pedestals, the Contractor shall remove the pedestal to a minimum of 2 feet below finished grade and backfill the remaining hole with material similar to that surrounding the hole. Where the existing Structure is to be relocated, the Contractor shall provide necessary materials, labor, and hardware, and if so indicated, electrical conduit,

conductors, etc., electrical services, and connections so as to erect and provide an operable unit to the satisfaction of the Engineer. All materials damaged by the Contractor shall be replaced at no cost to the Contracting Agency. Unless otherwise allowed, relocation of each existing sign and Structure shall be accomplished during the day in which it was removed. Relocation of overhead signs and Structures shall be accomplished during the hours between 12 midnight and 4:00 a.m. or as approved by the Engineer.

8-21.3(6) Sign Refacing

Where indicated in the Plans or in the Special Provisions, the Contractor shall reface existing signs with sheet aluminum overlay panels. Unless otherwise indicated in the Plans or allowed by the Engineer, all Work shall be accomplished while the existing sign is in place. Modifications to each sign shall be completed during the same day in which the Work is commenced.

Prior to the installation of overlay panels, the existing legend (message and border) shall be removed. The aluminum overlay panels shall be butt jointed. Aluminum or stainless steel screws, a minimum of ½ inch in length, shall be used to attach overlay panels to existing plywood signs. In addition to the screws, two ¼-inch diameter by 1-inch-long aluminum or stainless steel bolts shall be installed through the top of each panel and the plywood sign. Aluminum blind rivets shall be used to attach overlay panels to existing aluminum signs. Screws or rivets shall be installed at 24-inch centers. Unless otherwise noted, sign background material shall be in accordance with Section 9-28.

After installation of overlay panels, the existing legend shall be reinstalled or, where indicated in the Plans, new legend or portions thereof shall be furnished and installed by the Contractor. Direct applied legend shall be applied to the new face prior to resurfacing. Layout and letter spacing shall be in accordance with Contracting Agency standards unless otherwise approved by the Engineer. New legend components shall be of the same type and size as the existing materials, and it shall be the Contractor's responsibility to verify material type and size. Materials damaged by the Contractor shall be replaced at no expense to the Contracting Agency.

8-21.3(7) Sign Message Revision

Where indicated in the Plans or in the Special Provisions, the Contractor shall revise existing sign messages or layouts. The Contractor shall remove and reinstall portions of or all of the existing message or furnish and install new message components as necessary to provide the revised message as indicated. Prior to installing the revised message, the Contractor shall thoroughly clean the sign face and plug all existing rivet holes with aluminum blind rivets painted the same color as the sign background. Plugging screw holes in plywood signs will not be required. Modifications to the sign shall be completed during the same day in which Work is commenced and while the sign is in place. All new materials necessary to accomplish this Work shall be the same type and size as the existing components, and it shall be the Contractor's responsibility to verify such component type and size. Materials damaged by the Contractor shall be replaced at no expense to the Contracting Agency. Existing materials not reinstalled shall become the property of the Contractor and shall be removed from the project.

8-21.3(8) Sign Cleaning

Signs shall be cleaned after relocation or installation to the satisfaction of the Engineer. The Contractor shall not use cleaning solvents that would be harmful to the sign finish.

8-21.3(9) Sign Structures

8-21.3(9)A Fabrication of Steel Structures

Fabrication shall conform to the applicable requirements of Sections 6-03 and 9-06. All welded connections of sign bridge and cantilever sign Structure posts, arms, and beams, including base and connection plates, shall be cleaned prior to welding to remove all mill scale from within 2 inches of the weld. As an alternative to the blast cleaning requirements of Section 6-03.3(13), the Contractor may perform the cleaning using power hand tools as approved by the Engineer. Unless otherwise specified in the Plans or Special Provisions, metal surfaces shall not be painted.

All fabrication, including repairs, adjustments or modifications of previously fabricated sign structure members and connection elements, shall be performed in the shop, under a Working Drawing prepared and submitted by the Contractor for the original fabrication or the specific repair, adjustment or modification. Sign structure fabrication repair, adjustment or modification of any kind in the field is not permitted. If fabrication repair, adjustment or modification occurs after a sign structure member or connection element has been galvanized, the entire member or element shall be re-galvanized in accordance with AASHTO M 111.

8-21.3(9)A1 Fabrication of Monotube Sign Bridges and Cantilever Sign Structures

The fabricator shop will provide a Certified Welding Inspector. The inspector shall be a AWS Certified Welding Inspector (CWI) qualified and certified in accordance with the provisions of AWS QCI Standard for Qualification and Certification.

Welds shall be inspected as follows:

1. Visual Inspection in accordance with Section 6-03.3(25)A1.
2. Magnetic Particle Inspection in accordance with Section 6-03.3(25)A4.
3. Ultrasonic Inspection in accordance with Section 6-03.3(25)A3.
4. Dye-Penetrant or Magnetic Particle Inspection

The post to beam connection weld shall have 100 percent of its length inspected using dye-penetrant or magnetic-particle testing techniques. The inspection shall be performed after the root pass and after completion of the weld.

All bolted connections shall be made using the direct tension indicator method in accordance with Section 6-03.3(33). Splice connections made using the direct tension indicator method are not required to be inspected in accordance with Section 6-03.3(33)B and will be accepted based on feeler gauge measurements conforming to Table 3 in Section 6-03.3(33).

All bolted connection faying surfaces shall be flat after fabrication as required to provide a solid fit upon assembly in accordance with Section 6-03.3(33). The flatness of the faying surfaces shall be flat to within a tolerance of 1/32 inch in 12 inches and a tolerance of 1/16 inch overall. Base plates with leveling nuts shall be flat to within a tolerance of 1/8 inch in 12 inches and a tolerance of 3/16 inch overall.

In order to achieve the flatness requirements, the Contractor may need to mill or machine the plates. The Contractor shall increase plate thicknesses as needed to ensure the remaining section meets the specified thickness after such machining or milling.

At bolted connections, both faying surfaces shall be at right angles to the bolt axis, parallel to each other, and shall be in full contact in the assembled condition. Full contact is defined as 90-percent of the outside and inside perimeters of the splice plates being visually in contact. The outside surface shall be inspected just inside the shell of the monotube and the inside shall be inspected at the handhole. Splices shall be fabricated such that the required camber remains continuous and smooth across the field splice.

Prior to galvanizing, the Contractor shall shop assemble the completed Structure lying on its side in an undeflected position to ensure correct alignment, accuracy of holes, fit of joints, smooth camber profile, and the specified amount of camber. The joints shall be bolted with a sufficient number of bolts tightened snug tight to close the joints in full contact as they would be in the final field assembled position as defined above. The Contractor shall not disassemble the sign structure for galvanizing as specified until receiving the Engineer's acceptance of the shop assembled structure.

All galvanized surfaces exposed to view after erection shall be shop painted or shop powder coated in accordance with Section 6-07.3(11), except when the Plans or Special Provisions require field painting only in accordance with Sections 6-07.3(9)I and 6-07.3(11)A. Contact surfaces of the field bolted connections shall be left as galvanized without any overcoat.

Unless otherwise specified in the Special Provisions the color of the finish coat shall match SAE AMS Standard 595 color number 35257 when dry.

All galvanized surfaces specified to be painted or powder coated shall be prepared for coating in accordance with Section 6-07.3(11).

After completing erection, the Contractor shall repair all metal surfaces with damaged paint or powder coatings and exposed metal with a field repair coating in accordance with Section 6-07.3(9)I and Section 6-07.3(11)A (for paint) or Section 6-07.3(11)B (for powder coating). The color of the finish coat of the field repair coating, when dry, shall match the color specified above.

The Contractor shall furnish and install the vibration damper as shown in the Plans. The damper shall be installed before the sign structure is erected.

8-21.3(9)B Erection of Steel Structures

Erection shall conform to the applicable requirements of Sections 6-03 and 8-21.3(9)F. Section 8-21.3(9)F notwithstanding, the Contractor may erect a sign bridge prior to completion of the shaft cap portion of one foundation for one post provided the following conditions are satisfied:

1. The Contractor shall submit a Type 2E Working Drawing consisting of design calculations and details of the temporary supports and falsework supporting the sign bridge near the location of the incomplete foundation. The submittal shall include the method of releasing and removing the temporary supports and falsework without inducing loads and stress into the sign bridge.
2. The Contractor shall submit a Type 2 Working Drawing consisting of the method used to secure the anchor bolt array in proper position with the sign bridge while casting the shaft cap concrete to complete the foundation.
3. The Contractor shall erect the sign bridge and temporary supports and falsework, complete the remaining portion of the incomplete foundation, and remove the temporary supports and falsework, in accordance with the accepted Working Drawings.

8-21.3(9)C Timber Posts

Timber sign posts shall conform to the requirements of Section 9-28.14(1).

8-21.3(9)D Aluminum Structures

Welding of aluminum shall be in accordance with Section 9-28.14(3).

8-21.3(9)E Bridge Mounted Sign Brackets

The Contractor shall fabricate and install sign supports for mounting signs on bridge Structures at the locations and as shown in the Plans, including inserts and anchor bolts. Fabrication and installation shall be in accordance with applicable requirements of Sections 6-03 and 9-06. Metal surfaces shall not be painted.

The quantity of structural carbon steel shown in the Contract is listed only for the convenience of the Contractor in determining the volume of Work involved and is not guaranteed to be accurate. The prospective Bidders shall verify this quantity before submitting a Bid. No adjustments other than for approved changes will be made in the lump sum Contract price for the bridge mounted sign brackets, even though the actual quantity of structural carbon steel required may deviate from that listed.

8-21.3(9)F Foundations

The excavation and backfill shall conform to the requirements of Section 2-09.3. Where obstructions prevent construction of planned foundations, the Contractor shall construct an effective foundation satisfactory to the Engineer.

The bottom of concrete foundations shall rest on firm ground. If the portion of the foundation beneath the existing ground line is formed or cased instead of being cast

against the existing soil forming the sides of the excavation, then all gaps between the existing soil and the completed foundation shall be backfilled and compacted in accordance with Section 2-09.3(1)E.

Concrete placed into an excavation where water is present shall be placed using an approved tremie. If water is not present, the concrete shall be placed such that the free-fall is vertical down the center of the shaft without hitting the sides, the steel reinforcing bars, or the steel reinforcing bar cage bracing. The Section 6-02.3(6) restriction for 5-feet maximum free-fall shall not apply to placement of Class 4000P concrete into a shaft.

Foundations shall be cast in one operation where practicable. The exposed portions shall be formed to present a neat appearance. Class 2 surface finish shall be applied to exposed surfaces of concrete in accordance with the requirements of Section 6-02.3(14)B.

Where soil conditions are poor, the Engineer may order the Contractor to extend the foundations shown in the Plans to provide additional depth. Such additional work shall be paid for according to Section 1-04.4.

Forms shall be true to line and grade. Tops of foundations for roadside sign structures shall be finished to ground line unless otherwise shown in the Plans or directed by the Engineer. Tops of foundations for sign bridges and cantilever sign structures shall be finished to the elevation shown in the Plans.

Both forms and ground that will be in contact with the concrete shall be thoroughly moistened before placing concrete; however, excess water in the foundation excavation will not be permitted. Forms shall not be removed until the concrete has set at least 3 days. All forms shall be removed, except when the Plans or Special Provisions specifically allow or require the forms or casing to remain.

Foundation concrete shall conform to the requirements for the specified class, be cast-in-place concrete, and be constructed in accordance with Sections 6-02.2 and 6-02.3.

After construction of concrete foundations for sign bridge and cantilever sign structures, the Contractor shall survey the foundation locations and elevations, the anchor bolt array locations and lengths of exposed threads. The Contractor shall confirm that the survey conforms to the sign structure post, beam, span and foundation design geometry shown in the Plans prior to completion of the sign structure foundation, and shall identify any deviations from the design geometry shown in the Plans. When deviations are identified, the Contractor shall notify the Engineer and submit a Type 2 Working Drawing consisting of the Contractor's proposed method(s) of addressing the deviations.

Sign structures shall not be erected on concrete foundations until the Contractor confirms that the foundations and the fabricated sign structures are either compatible with each other and the design geometry shown in the Plans, or have been modified in accordance with this section and as accepted by the Engineer to be compatible with each other, and the foundations have attained a compressive strength of 2,400-psi.

In addition to the basic requirements, sign bridges and cantilever sign structures shall be installed in accordance with the following:

1. Foundation excavations shall conform to the requirements of Section 2-09.3(3).
2. Tops of foundations for sign bridges and cantilever sign structures shall be finished to the elevation shown in the Plans.
3. Steel reinforcing bars shall conform to Section 9-07.
4. Concrete shall be Class 4000P, except as otherwise specified. The concrete for the shaft cap (the portion containing the anchor bolt array assemblies above the construction joint at the top of the shaft) shall be Class 4000.
5. All bolts and anchor bolts shall be installed so that two full threads extend beyond the top of the top heavy-hex nut. Anchor bolts shall be installed plumb, plus or minus 1 degree.
6. Plumbing of sign bridges and cantilever sign structures shall be accomplished by adjusting leveling nuts. Shims or other similar devices for plumbing or raking will not be permitted.
7. The top heavy-hex nuts of sign bridges and cantilever sign structures shall be tightened in accordance with Section 6-03.3(33), and by the Turn-of-Nut Method to a minimum rotation of ¼ turn and a maximum of ⅓ turn past snug tight. Permanent marks shall be set on the base plate and nuts to indicate nut rotation past snug tight.

In addition to the basic requirements, roadside sign structures shall be installed in accordance with the following:

1. Tops of foundations shall be finished to final ground line unless otherwise shown in the Plans or staked by the Engineer.
2. Steel reinforcement, including spiral reinforcing, shall conform to Section 9-07.2.
3. Unless otherwise shown in the Plans, concrete shall be Class 4000P. Class 4000P concrete for roadside sign structures does not require air entrainment.
4. The assembly and installation of all Type TP-A or Type TP-B bases for roadside sign structures shall be supervised at all times by either a manufacturer's representative or an installer who has been trained and certified by the manufacturer of the system. If the supervision is provided by a trained installer, a copy of the installer's certification shall be provided to the Engineer prior to installation.
5. For all Type TP-A or TP-B bases, the Contractor shall attach four female anchors to a flat rigid template following the manufacturer's recommendations. The Contractor shall lower the anchor assembly into fresh concrete foundation and vibrate into position such that the tops of the anchor washers are flush with the finished top surface of the foundation. The Contractor shall support the template such that all anchors are level and in their proper position.

Slip base and hinge connection nuts of roadside sign structures shall be tightened using a torque wrench to the torque, following the procedure specified in the Plans.

8-21.3(9)F1 Shafts for Monotube Sign Bridge and Cantilever Sign Structure Foundations

Shafts for monotube sign bridge and cantilever sign structure foundations shall be constructed in accordance with Section 6-19.3, except as follows:

The tolerance for placing the center at the top of the shaft under Section 6-19.3(1)A is revised for sign bridge and cantilever sign structure shafts to be within four-inches of the Plan location.

Non-destructive testing of shafts under Sections 6-19.3(1)B and 6-19.3(9) and associated Work under Section 6-19.3(6) does not apply.

Temporary casing shall be advanced during excavation operations within the limits of temporary casing shown in the Plans for all shaft locations specified in the Special Provisions as requiring temporary casing. Excavation in advance of the casing tip shall not exceed 3-feet, except in no case shall shaft excavation and casing placement extend below the bottom of shaft excavation as shown in the Plans. Unless partial depth temporary casing is shown in the Plans, temporary casing shall be full depth of the shaft.

When the rate of advance of the excavation to the design tip elevation is significantly reduced relative to previous rate of excavation advance in the same geological unit, then the Contractor shall remove, break-up, or push aside, the obstruction under the provisions of Section 8-21.5.

Slurry, if used, shall be synthetic slurry or water slurry as specified in Sections 9-36.2(2) and 9-36.2(3), respectively.

The concrete cover dimensions under Section 6-19.3(5)C are revised for sign bridge and cantilever sign structure shafts to be 3-inches minimum for shafts of diameters of 3-feet or less, and 4-inches minimum for shafts with diameters greater than 3-feet.

Sign bridge and cantilever sign structure shaft concrete shall be Class 4000P.

All temporary casing shall be completely removed.

8-21.3(9)G Sign Structure Identification Information

Whenever existing bridge-mounted sign brackets, cantilever sign structures, or sign bridge structures are removed from their anchorage, whether temporary or permanent, the Contractor shall provide the sign structure identification information, attached to the sign structures, to the Engineer. The identification information may be in the form of a riveted plate, sticker, or other means.

8-21.3(10) Sign Attachment

Sign panels consisting of sheet aluminum or fiberglass reinforced plastic shall be attached or mounted to signposts or sign structures as shown in the Plans.

Signs not conforming to the above, including all variable message sign (VMS) assemblies and other message boardtype assemblies, shall be attached or mounted to signposts or

sign structures by means of positive connections—defined as through-bolted connections. The use of clips or clamps to accomplish the attachment or mounting of such signs and assemblies is prohibited.

8-21.3(11) Multiple Panel Signs

After installation of multiple panel signs, the Contractor shall furnish and install an approved reinforced aluminized tape on the reverse side of the sign to prevent visible light through the seam. The tape shall be pressure sensitive and a minimum of 2 inches wide and 2 mils thick. In lieu of tape, the Contractor may use 1-inch-wide aluminum sheeting riveted to the sign back. The aluminum shall be a minimum of 0.032 inch thick. Rivet heads shall match the sign face color.

8-21.3(12) Steel Sign Posts

For roadside sign structures on Type TP-A or Type TP-B bases, the Contractor shall use the following procedures and manufacturer's recommendations:

1. The couplings, special bolts, bracket bolts, and hinge connection nuts on all Type TP-A or Type TP-B bases shall be tightened using the Turn-of-Nut Tightening Method to a maximum rotation of ½ turn past snug tight.
2. The Contractor shall shim as necessary to plumb the steel signposts.

For roadside sign structures on all Type PL and SB slip bases, the Contractor shall use the following procedures:

1. The Contractor shall assemble the steel signpost to stub post with bolts and flat washers as shown in the Plans.
2. Each bolt shall be tightened using a torque wrench to the torque, following the procedures specified in the Plans.

For roadside sign structures on SB-1, SB-2, or SB-3 slip bases, the Contractor shall use the following procedures and manufacturer's recommendations:

1. The Contractor shall attach the perforated square steel post or solid square steel post to the upper slip plate with bolts, nuts, and washers as shown in the Plans.
2. The three bolts connecting the upper and lower slip plates shall be tightened to torque, using a torque wrench, following the procedures in the Plans.

For roadside structures on ST-2 and ST-4 sign supports, the Contractor shall use the following procedures:

1. The Contractor shall attach the perforated square steel post to the lower sign post support with bolts, nuts, and washers as shown in the Plans.

8-21.4 Measurement

Sign covering will be measured in square feet of the area of the sign covered.

8-21.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Permanent Signing", lump sum.

"Sign Bridge No. ____", lump sum.

"Cantilever Sign Structure No. ____", lump sum.
All costs in connection with surveying completed concrete foundations for sign bridges and cantilever sign structures shall be included in the lump sum contract price for "Structure Surveying", except that when no Bid item is included in the Proposal for "Structure Surveying" then such costs shall be included in the lump sum contract price(s) for "Sign Bridge No. ___" and "Cantilever Sign Structure No. ___".

"Bridge Mounted Sign Bracket No. ____", lump sum.

"Sign Covering", per square foot.

"Removing Sign Structure Shaft Obstructions", estimated.

Payment for removing obstructions, as defined in Section 8-21.3(9)F1, will be made for the changes in shaft construction methods necessary to remove the obstruction. The Contractor and the Engineer shall evaluate the effort made and reach agreement on the equipment and employees utilized, and the number of hours involved for each. Once these cost items and their duration have been agreed upon, the payment amount will be determined using the rate and markup methods specified in Section 1-09.6. For the purpose of providing a common Proposal for all bidders, the Contracting Agency has entered an amount for the item "Removing Sign Structure Shaft Obstructions" in the bid Proposal to become a part of the total bid by the Contractor.

If the shaft construction equipment is idled as a result of the obstruction removal work and cannot be reasonably reassigned within the project, then standby payment for the idled equipment will be added to the payment calculations. If labor is idled as a result of the obstruction removal work and cannot be reasonably reassigned within the project, then all labor costs resulting from Contractor labor agreements and established Contractor policies will be added to the payment calculations.

The Contractor shall perform the amount of obstruction work estimated by the Contracting Agency within the original time of the contract. The Engineer will consider a time adjustment and additional compensation for costs related to the extended duration of the shaft construction operations, provided:

1. the dollar amount estimated by the Contracting Agency has been exceeded, and
2. the Contractor shows that the obstruction removal work represents a delay to the completion of the project based on the current progress schedule provided in accordance with Section 1-08.3.

8-22 Pavement Marking

8-22.1 Description

This Work consists of furnishing, installing, and removing pavement markings upon the Roadway surface in accordance with the Plans, *Standard Plans*, the FHWA publication Standard Alphabet for Highway Signs and Pavement Markings and these Specifications, at locations shown in the Contract or as ordered by the Engineer in accordance with Section 1-04.4.

Pavement Markings may be either Longitudinal (long) Line Markings or Transverse Markings. Longitudinal line markings are generally placed parallel and adjacent to the flow of traffic. Transverse markings are generally placed perpendicular and across the flow of traffic. Word and symbol markings are classified as transverse markings. Traffic letters used in word messages shall be sized as shown in the Plans.

8-22.2 Materials

Material for pavement marking shall be paint or plastic as noted in the Bid item meeting the requirements of Section 9-34. Glass beads for paint shall meet the requirements of Section 9-34.4. Glass beads for plastic shall be as recommended by the material manufacturer.

8-22.3 Construction Requirements

8-22.3(1) Preliminary Spotting

The Engineer will provide necessary control points at intervals agreed upon with the Contractor to assist in preliminary spotting of the lines before marking begins. The Contractor shall be responsible for preliminary spotting of the lines to be marked. Approval by the Engineer is required before marking begins. Preliminary spotting to guide the striping machine is required for all longitudinal lines except where a clearly visible separation is present. Preliminary spotting shall be provided at a spacing of 100 feet maximum on tangents and 25-feet maximum on curves. The color of the material used for spotting shall match the color of the permanent marking.

8-22.3(2) Preparation of Roadway Surfaces

All surfaces shall be dry, free of any loose debris, and within the proper temperature range prior to striping. When required by the pavement marking manufacturer's installation instructions, pavement markings that will adversely affect the bond of new pavement marking material to the roadway surface shall be removed from pavement surfaces in accordance with Section 8-22.3(6).

Remove all other contaminants from pavement surfaces that may adversely affect the installation of new pavement marking.

Apply materials to new HMA that is sufficiently cured according to the manufacturer's recommendations. Typically, Type D material applied to new HMA pavement requires a pavement cure period of 21 days. This cure period may be reduced if the manufacturer performs a successful bond test and approves the reduction of the pavement cure period.

For new Portland cement concrete surfaces, remove curing compounds and laitance by an approved mechanical means. Air blast the pavement with a high-pressure system to remove extraneous or loose material. Apply materials to concrete that has reached a minimum compressive strength of 2,500 psi and that is sufficiently cured according to the manufacturer's recommendations. Typically, Type D material applied to Portland cement concrete pavement requires a pavement cure period of 28 days. This cure period may be reduced if the manufacturer performs a successful bond test and approves the reduction of the pavement cure period.

After the pavement surface is clean and dry, apply primer as recommended by the manufacturer to the area receiving the pavement markings. Apply the primer in a continuous, solid film according to the recommendations of the primer manufacturer and the pavement markings manufacturer.

8-22.3(3) Marking Application

8-22.3(3)A Marking Colors

Lane line and right edge line shall be white in color. Centerline and left edge line shall be yellow in color. Transverse markings shall be white, except as otherwise noted in the *Standard Plans*.

8-22.3(3)B Line Patterns

Solid Line – A continuous line without gaps.

Broken Line – A line consisting of solid line segments separated by gaps.

Dotted Line – A broken line with noticeably shorter line segments separated by noticeably shorter gaps.

8-22.3(3)C Line Surfaces

Flat Lines – Pavement marking lines with a flat surface.

Profiled Marking – A profiled pavement marking is a marking that consists of a base line thickness and a profiled thickness, which is a portion of the pavement marking line that is applied at a greater thickness than the base line thickness. Profiles shall be applied using the extruded method in the same application as the base line. The profiles may be slightly rounded provided the minimum profile thickness is the same throughout the length of the profile. See the Plans for the construction details.

Embossed Plastic Line – Embossed plastic lines consist of a flat line with transverse grooves. An embossed plastic line may also have profiles. See the Plans for the construction details.

8-22.3(3)D Line Applications

Surface Line – A line constructed by applying pavement marking material directly to the pavement surface or existing pavement marking.

Grooved Line – A line constructed by grinding or saw cutting a groove into the pavement surface and spraying, extruding, or gluing pavement marking material into the groove. Groove depth is measured vertically from the bottom of a 2 foot or longer straightedge placed on the roadway surface to the ground surface. The groove depth is dependent upon the material used, the pavement surface, and the location. See these *Standard Specifications*, the project Plans, and Special Provisions. Grooved line pavement marking shall not be constructed on bridge decks or on bridge approach slabs.

8-22.3(3)E Installation

Apply pavement marking materials to clean, dry pavement surfaces and according to the following:

1. Place material according to the manufacture's recommendations,
2. Place parallel double lines in one pass,
3. The top of pavement marking shall be smooth and uniform,
4. Line ends shall be square and clean,
5. Place pavement marking lines parallel and true to line, and
6. Place markings in proper alignment with existing markings.

When applying paint, Type A or Type C material, ensure that both the pavement surface and the air temperature at the time of application are not less than 50°F and rising. When applying Type B or Type D material, ensure that both the pavement surface and the air temperature at the time of application are not less than 40°F and rising.

Ensure that the Type A thermoplastic material meets the manufacturer's temperature specifications when it contacts the pavement surface.

Two applications of paint will be required to complete all paint markings. The second application of paint shall be squarely on top of the first pass. The time period between paint applications will vary depending on the type of pavement and paint (low VOC waterborne or low VOC solvent) as follows:

Pavement Type	Paint Type	Time Period
Bituminous Surface Treatment	Low VOC Waterborne	4 hours min., 48 hours max.
Hot Mix Asphalt Pavement	Low VOC Waterborne	4 hours min., 30 days max.
Cement Concrete Pavement	Low VOC Waterborne	4 hours min., 30 days max.
Bituminous Surface Treatment	Low VOC Solvent	40 min. min., 48 hrs. max.
Hot Mix Asphalt Pavement	Low VOC Solvent	40 min. min., 30 days max.
Cement Concrete Pavement	Low VOC Solvent	40 min. min., 30 days max.

Centerlines on two-lane Highways with broken line patterns, paint, or plastic shall be applied in the increasing milepost direction so they are in cycle with existing broken line patterns at the beginning of the project. Broken line patterns applied to multilane or divided Roadways shall be applied in cycle in the direction of travel.

Where paint is applied on centerline on two-way roads with bituminous surface treatment or centerline rumble strips, the second paint application shall be applied in the opposite (decreasing milepost) direction as the first application (increasing milepost) direction. This will require minor broken line pattern corrections for curves on the second application.

8-22.3(3)F Application Thickness

Pavement markings shall be applied at the following base line thickness measured above the pavement surface or above the groove bottom for grooved markings in thousandths of an inch (mils):

Marking Material Application		HMA	PCC	BST	Groove Depth
Paint – first coat	spray	10	10	10	
Paint – second coat	spray	15	15	15	
Type A – flat/transverse & symbols	extruded	125	125	125	
Type A – flat/long line & symbols	spray	90	90	120	
Type A – with profiles	extruded	90	90	120	
Type A – embossed	extruded	160	160	160	
Type A – embossed with profiles	extruded	160	160	160	
Type A – grooved/flat/long line	extruded	230	230	230	250
Type B – flat/transverse & symbols	heat fused	125	125	125	
Type C-2 – flat/transverse & symbols	adhesive	90	90	NA	
Type C-1 & 2 – flat/long line	adhesive	60	60	NA	
Type C-1 – grooved/flat/long line	adhesive	60	60	NA	100
Type D – flat/transverse & symbols	spray	120	120	120	
Type D – flat/transverse & symbols	extruded	120	120	120	
Type D – flat/long line	spray	90	90	120	
Type D – flat/long line	extruded	90	90	120	
Type D – profiled/long line	extruded	90	90	120	
Type D – grooved/flat/long line	extruded	230	230	230	250

Liquid pavement marking material yield per gallon depending on thickness shall not exceed the following:

Mils thickness	Feet of 4″ line/gallon	Square feet/gallon
10	483	161
15	322	108
18	268	89
20	242	80
22	220	73
24	202	67
30	161	54
40	122	41
45	107	36
60	81	27
90	54	18
90 with profiles	30	10
120	40	13
120 with profiles	26	9
230	21	7

Solid pavement marking material (Type A) yield per 50-pound bag shall not exceed the following:

Mils thickness	Feet of 4″ line/50# bag	Square feet/50# bag
30 – flat	358	120
45 – flat	240	80
60 – flat	179	60
90 – flat	120	40
90 – flat with profiles	67	23
120 – flat	90	30
120 – flat with profiles	58	20
125 – embossed	86	29
125 – embossed with profiles	58	20
230 – flat grooved	47	15

All grooved lines shall be applied into a groove cut or ground into the pavement. For Type A or Type D material, the groove shall be cut or ground with equipment to produce a smooth square groove 4 inches wide. For Type C-1 material, the groove shall be cut with equipment to produce a smooth bottom square groove with a width in accordance with the material manufacturer's recommendation. After grinding, clean the groove. Immediately before placing the marking material, clean the groove with high-pressure air.

8-22.3(3)G Glass beads

Top dress glass beads shall be applied to all spray and extruded pavement marking material. Glass beads shall be applied by a bead dispenser immediately following the pavement marking material application. Glass bead dispensers shall apply the glass beads in a manner such that the beads appear uniform on the entire pavement marking surface with 50 to 60 percent embedment. Hand casting of beads will not be allowed.

Glass beads shall be applied to 10 or 15 mil thick paint at a minimum application rate of 7 pounds per gallon of paint. For plastic pavement markings, glass bead type and application rate shall be as recommended by the marking material manufacturer.

When two or more spray applications are required to meet thickness requirements for Type A and Type D materials, top dressing with glass beads is only allowed on the last application. The cure period between successive applications shall be in accordance with the manufacturer's recommendations. Any loose beads, dirt or other debris shall be swept or blown off the line prior to application of each successive application. Successive applications shall be applied squarely on top of the preceding application.

8-22.3(4) Tolerances for Lines

Allowable tolerances for lines are as follows:

Length of Line – The longitudinal accumulative error within a 40 foot length of broken line shall not exceed plus or minus 1 inch. The broken line segment shall not be less than 10 feet.

Width of Line – The width of the line shall not be less than the specified line width or greater than the specified line width plus ¼ inch.

Lane Width – The lane width, which is defined as the lateral width from the edge of pavement to the center of the lane line or between the centers of successive lane lines, shall not vary from the widths shown in the Contract by more than plus or minus 4 inches.

Thickness – A thickness tolerance not exceeding plus 10 percent will be allowed for thickness or yield in paint and plastic material application.

Parallel Lines – The gap tolerance between parallel lines is plus or minus ½ inch.

8-22.3(5) Installation Instructions

Installation instructions for plastic markings shall be provided for the Engineer. The instructions shall include equipment requirements, approved work methods and procedures, material application temperature range, air and pavement surface temperature requirements, weather limitations, precautions, and all other requirements for successful application and material performance. Do not use materials with incomplete or missing instructions. All materials including glass beads shall be installed according to the manufacturer's recommendations. A manufacturer's technical representative shall be present at the initial installation of plastic material to approve the installation procedure or the material manufacturer shall certify that the Contractor will install the plastic material in accordance with their recommended procedure.

8-22.3(6) Removal of Pavement Markings

Pavement markings to be removed shall be obliterated until all blemishes caused by the pavement marking removal conform to the coloration of the adjacent pavement.

Grinding to remove pavement markings in their entirety is allowed in areas designated for applications of either Hot Mix Asphalt (HMA) or Bituminous Surface Treatment (BST). Pavement marking removal shall be performed from April 1st through September 30th and only in those areas that shall be paved within the same time window as the grinding, unless otherwise allowed by the Engineer in writing.

For all cement concrete pavement and areas that will not be overlaid with hot mix asphalt or BST, grinding is allowed to a depth just above the pavement surface and then Water blasting or shot blasting shall be required to remove the remaining pavement markings.

If in the opinion of the Engineer, the pavement is materially damaged by pavement marking removal, such damage shall be repaired by the Contractor in accordance with Section 1-07.13(1). Sand or other material deposited on the pavement as a result of removing lines and markings shall be removed as the Work progresses to avoid hazardous conditions. Accumulation of sand or other material which might interfere with drainage will not be permitted.

8-22.4 Measurement

Center line, center line with no pass line, double center line, double lane line, edge line, solid lane line, dotted extension line, lane line, reversible lane line, and two-way left-turn center line will be measured by the completed linear foot as “Paint Line”, “Plastic Line”, “Embossed Plastic Line”, “Profiled Plastic Line”, “Profiled Embossed Plastic Line” or Grooved Plastic Line”.

The measurement for “Paint Line” will be based on a marking system capable of simultaneous application of three 4-inch lines with two 4-inch spaces. No deduction will be made for the unmarked area when the marking includes a broken line such as center line, dotted extension line, center line with no-pass line, lane line, reversible lane line, or two-way left-turn center line. No additional measurement will be made when more than one line can be installed on a single pass such as center line with no-pass line, double center line, double lane line, reversible lane line, or two-way left-turn center line.

The measurement for “Plastic Line”, “Embossed Plastic Line”, “Profiled Plastic Line”, “Profiled Embossed Plastic Line”, or “Grooved Plastic Line” will be based on the total length of each 4 inch wide plastic line installed. No deduction will be made for the unmarked area when the marking includes a broken line such as, center line, dotted extension line, center line with no-pass line, lane line, reversible lane line, or two-way left-turn center line.

The measurement for “Painted Wide Lane Line”, “Plastic Wide Lane Line”, “Profiled Plastic Wide Lane Line”, “Painted Barrier Center Line”, “Plastic Barrier Center Line”, “Painted Stop Line”, “Plastic Stop Line”, “Painted Wide Dotted Entry Line”, or “Plastic Wide Dotted Entry Line” will be based on the total length of each painted, plastic or profiled plastic line

installed. No deduction will be made for the unmarked area when the marking includes a broken line such as, wide broken lane line, drop lane line, wide dotted lane line or wide dotted entry line. The measurement for double wide lane line will be based on the total length of each wide lane line installed.

No additional measurement for payment will be made for the required second application of paint. No additional measurement for payment will be made for additional applications required to meet thickness requirements for plastic markings.

Diagonal lines used to delineate parking stalls that are constructed of painted or plastic 4-inch lines will be measured as “Paint Line” or “Plastic Line” by the linear foot of line installed. Crosswalk line will be measured by the square foot of marking installed.

Crosshatch markings used to delineate median and gore areas will be measured by the completed linear foot as “Painted Crosshatch Marking” or “Plastic Crosshatch Marking”.

The measurement for “Painted Crosshatch Marking” and for “Plastic Crosshatch Marking” will be based on the total length of each 8-inch or 12-inch wide line installed.

Traffic arrows, traffic letters, access parking space symbols, HOV symbols, railroad crossing symbols, drainage markings, junction box markings, bicycle lane symbols, aerial surveillance full, and ½ markers, yield line symbols, yield ahead symbols, and speed bump symbols will be measured per each. Type 1 through 6 traffic arrows will be measured as one unit each, regardless of the number of arrow heads.

Removal of lines, 4, 8, 18, and 20 inches in width will be measured by the linear foot, with no deduction being made for the unmarked area when the marking includes a gap.

Removal of traffic arrows, traffic letters, access parking space symbol, HOV lane symbol, railroad crossing symbol, bicycle lane symbols, drainage markings, aerial surveillance full and ½ markers, yield line symbol, yield ahead symbol, and speed bump symbol will be measured per each. Removal of crosswalk lines will be measured by the square foot of lines removed.

8-22.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

“Paint Line”, per linear foot.

“Plastic Line”, per linear foot.

“Embossed Plastic Line”, per linear foot.

“Profiled Plastic Line”, per linear foot.

“Profiled Embossed Plastic Line”, per linear foot.

“Grooved Plastic Line”, per linear foot.

“Painted Wide Lane Line”, per linear foot.

“Plastic Wide Lane Line”, per linear foot.

“Profiled Plastic Wide Lane Line”, per linear foot.

“Painted Barrier Center Line”, per linear foot.

“Plastic Barrier Center Line”, per linear foot.

“Painted Stop Line”, per linear foot.

“Plastic Stop Line”, per linear foot.

“Painted Crosswalk Line”, per square foot.

“Plastic Crosswalk Line”, per square foot.

“Painted Crosshatch Marking”, per linear foot.

“Plastic Crosshatch Marking”, per linear foot.

“Painted Wide Dotted Entry Line”, per linear foot.

“Plastic Wide Dotted Entry Line”, per linear foot.

“Painted Traffic Arrow”, per each.

“Plastic Traffic Arrow”, per each.

“Painted Traffic Letter”, per each.

“Plastic Traffic Letter”, per each.

“Painted Access Parking Space Symbol”, per each.

“Plastic Access Parking Space Symbol”, per each.

“Painted Railroad Crossing Symbol”, per each.

“Plastic Railroad Crossing Symbol”, per each.

“Painted Bicycle Lane Symbol”, per each.

“Plastic Bicycle Lane Symbol”, per each.

“Painted Drainage Marking”, per each.

“Plastic Drainage Marking”, per each.

“Painted Junction Box Marking”, per each.

“Plastic Junction Box Marking”, per each.

“Painted Aerial Surveillance Full Marker”, per each.

“Plastic Aerial Surveillance Full Marker”, per each.

“Painted Aerial Surveillance ½ Marker”, per each.

“Plastic Aerial Surveillance ½ Marker”, per each.

“Painted Access Parking Space Symbol with Background”, per each.

“Plastic Access Parking Space Symbol with Background”, per each.

“Painted HOV Lane Symbol”, per each.

“Plastic HOV Lane Symbol”, per each.

"Painted Yield Line Symbol", per each.

"Plastic Yield Line Symbol", per each.

"Painted Yield Ahead Symbol", per each.

"Plastic Yield Ahead Symbol", per each.

"Painted Speed Bump Symbol", per each.

"Plastic Speed Bump Symbol", per each.

"Removing Paint Line", per linear foot.

"Removing Plastic Line", per linear foot.

"Removing Painted Crosswalk Line", per square foot.

"Removing Plastic Crosswalk Line", per square foot.

"Removing Painted Traffic Marking", per each.

"Removing Plastic Traffic Marking", per each.

The unit Contract price for the aforementioned Bid items shall be full payment for all costs to perform the Work as described in Section 8-22.

8-23 Temporary Pavement Markings

8-23.1 Description

The Work consists of furnishing and installing temporary pavement markings. Temporary pavement markings shall be provided where noted in the Plans and for all lane shifts and detours resulting from construction activities; or when permanent markings are removed because of construction operations.

8-23.2 Materials

Materials for temporary markings shall be paint, plastic, tape, raised pavement markers or flexible raised pavement markers. Materials for pavement markings shall meet the following requirements:

Raised Pavement Marker	9-21
Temporary Marking Paint	9-34.2(6)
Plastic	9-34.3
Glass Beads for Pavement Marking Materials	9-34.4
Temporary Pavement Marking Tape	9-34.5
Temporary Flexible Raised Pavement Markers	9-34.6

8-23.3 Construction Requirements

8-23.3(1) General

The Contractor shall select the type of pavement marking material in accordance with the Contract.

8-23.3(2) Preliminary Spotting

All preliminary layout and marking in preparation for application and the application and removal of temporary pavement markings shall be the responsibility of the Contractor.

8-23.3(3) Preparation of Roadway Surface

Surface preparation for temporary pavement markings shall be in accordance with the manufacturer's recommendations.

8-23.3(4) Pavement Marking Application

8-23.3(4)A Temporary Pavement Markings – Short Duration

Temporary pavement markings – short duration shall meet the following requirements:

Temporary Center Line – A BROKEN line used to delineate adjacent lanes of traffic moving in opposite directions. The broken pattern shall be based on a 40-foot unit, consisting of a 4-foot line with a 36-foot gap if paint or tape is used. If temporary raised pavement markers are used, the pattern shall be based on a 40-foot unit, consisting of a grouping of three temporary raised pavement markers, each spaced 3 feet apart, with a 34 foot gap.

Temporary Edge Line – A SOLID line used on the edges of Traveled Way. The line shall be continuous if paint or tape is used. If temporary raised pavement markers are used, the line shall consist of markers installed continuously at 5-foot spacings.

Temporary Lane Line – A BROKEN line used to delineate adjacent lanes with traffic traveling in the same direction. The broken pattern shall be based on a 40-foot unit, consisting of a 4-foot line with a 36-foot gap, if paint or tape is used. If temporary raised pavement markers are used, the pattern shall be based on a 40-foot unit, consisting of a grouping of three temporary raised pavement markers, each spaced 3 feet apart, with a 34 foot gap.

Lane line and right edge line shall be white in color. Center line and left edge line shall be yellow in color. Edge Lines shall be installed only if specifically required in the Contract. All temporary pavement markings shall be retroreflective.

8-23.3(4)A1 Temporary Pavement Marking Paint

Paint used for short duration temporary pavement markings shall be applied in one application at a thickness of 15 mils or 108 square feet per gallon. Glass beads shall be in accordance with Section 8-22.3(3)G.

8-23.3(4)A2 Temporary Pavement Marking Tape

Application of temporary pavement marking tape shall be in conformance with the manufacturer's recommendations.

Black mask pavement marking tape shall mask the existing line in its entirety.

8-23.3(4)A3 Temporary Raised Pavement Markers

Temporary raised pavement markers are not allowed on bituminous surface treatments.

8-23.3(4)A4 Temporary Flexible Raised Pavement Markers

Flexible raised pavement markers are required for new applications of bituminous surface treatments. Flexible raised pavement markers are not allowed on other pavement types unless otherwise specified or approved by the Engineer. Flexible raised pavement markers shall be installed with the protective cover in place. The cover shall be removed immediately after spraying asphaltic material.

8-23.3(4)B Temporary Pavement Markings – Long Duration

Application of paint, pavement marking tape and plastic for long duration pavement markings shall meet the requirements of Section 8-22.3(3); application of raised pavement markers shall meet the requirements of Section 8-09.3; and application of flexible pavement markings shall be in conformance with the manufacturer's recommendations.

8-23.3(4)C Tolerance for Lines

Tolerance for lines shall conform to Section 8-22.3(4).

8-23.3(4)D Maintenance of Pavement Markings

Temporary pavement markings shall be maintained in serviceable condition throughout the project until permanent pavement markings are installed. As directed by the Engineer; temporary pavement markings that are damaged, including normal wear by traffic, shall be repaired or replaced immediately. Repaired and replaced pavement markings shall meet the requirements for the original pavement marking.

8-23.3(4)E Removal of Pavement Markings

Removal of temporary paint is not required prior to paving; all other temporary pavement markings shall be removed.

All temporary pavement markings that are required on the wearing course prior to construction of permanent pavement markings and are not a part of the permanent markings shall be completely removed concurrent with or immediately subsequent to the construction of the permanent pavement markings in accordance with the manufacturer's permanent marking application instructions. Temporary flexible raised pavement markers on bituminous surface treatment pavements shall be cut off flush with the surface if their location conflicts with the alignment of the permanent pavement markings. All other temporary pavement markings shall be removed in accordance with Section 8-22.3(6).

All damage to the permanent Work caused by removing temporary pavement markings shall be repaired by the Contractor at no additional cost to the Contracting Agency.

8-23.4 Measurement

Temporary pavement markings will be measured by the linear foot of each installed line or grouping of markers, with no deduction for gaps in the line or markers and no additional measurement for the second application of paint required for long duration paint lines. Short duration and long duration temporary pavement markings will be measured for the initial installation only.

8-23.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Temporary Pavement Marking – Short Duration", per linear foot.

"Temporary Pavement Marking – Long Duration", per linear foot.

The unit Contract price per linear foot for "Temporary Pavement Marking – Short Duration" and "Temporary Pavement Marking – Long Duration" shall be full pay for all Work.

8-24 Rock and Gravity Block Wall and Gabion Cribbing

8-24.1 Description

This Work consists of constructing rock and gravity block wall(s), and gabion cribbing in accordance with the Plans, Special Provisions, these Specifications, or as designated by the Engineer.

8-24.2 Materials

Materials shall meet the requirements of the following Sections:

Rock for Rock Wall and Chinking Material	9-13.7(1)
Backfill for Rock Wall	9-13.7(2)
Gabion Cribbing	9-27.3
Wire Mesh Fabric	9-27.3(1)
PVC Coating for Welded Wire Mesh Fabric	9-27.3(2)
Gabion Basket Fasteners	9-27.3(4)
Stone	9-27.3(6)
Construction Geotextile	9-33

Materials for gravity block walls shall be as specified in the Special Provisions.

8-24.3 Construction Requirements

8-24.3(1) Rock Wall

8-24.3(1)A Geometric Tolerances

The completed wall shall meet the following tolerances:

1. Wall batter shall be 6:1 or flatter as specified in the Plans.
2. The exterior slope plane and grade in the finished surface of the wall shall be plus or minus 6 inches.
3. The maximum void between adjacent rocks shall be 6 inches as measured at the smallest dimensions of the void within the thickness of the wall.

8-24.3(1)B Excavation

Excavation shall conform to Section 2-09.3(4), and to the limits and construction stages shown in the Plans.

The Contractor shall restrict the excavation limits to the length of rock wall that can be constructed in 1 day's Work, except as otherwise noted. The Engineer may permit excavation beyond the limits that can be completed in 1 day's Work provided the Contractor either demonstrates that the excavation will remain stable until the rock wall is completed, or shores the excavation in accordance with Section 2-09.3(4).

Slope above the rock wall shall be established prior to excavating for the wall.

8-24.3(1)C Foundation Preparation

The foundation for the wall shall be graded as shown in the Plans.

Prior to rock placement, the foundation, if not in rock, shall be compacted as approved by the Engineer. Any foundation soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C.

Base course rocks shall have full contact with the foundation soils. If necessary, the excavation shall be shaped to fit the rocks. Rocks may be dropped to shape the ground provided the rocks do not crack. Cracked rocks shall be replaced and the foundation regraded to fit the replacement rock.

8-24.3(1)D Construction Geotextile

Construction geotextile shall be of the type, and shall be placed, as shown in the Plans.

8-24.3(1)E Rock Placement and Backfill

Rocks shall be placed so there are no continuous joint planes in either the vertical or lateral direction.

Where possible, rocks shall be placed so that the rock shall bear on at least two rocks below it. Rocks shall be oriented so that flat surface contact points between adjacent rocks are maximized. Point-to-point contact between adjacent rocks shall be minimized. Each rock in a course shall be arranged so that the natural irregularities in the rocks key the rocks together and so that the courses are keyed together.

Rocks shall increase in size from the top of the wall to the bottom at a uniform rate. The minimum rock sizes, as referenced from the top of the wall, shall be as follows:

Depth From Top of Wall (feet)	Minimum Rock Size at Depth From Top of Wall
6	Three Man
9	Four Man
12	Five Man

Rocks at the top of the wall shall be Two Man or larger.

Where voids larger than 6 inches are present, chinking rock shall be keyed between the rocks to fill the void.

Backfill for the rock wall shall be placed behind each course and tamped to provide a stable condition prior to placing rocks for the next successive course.

For rock walls constructed in fills, the fill shall be overbuilt and cut back to construct the wall.

8-24.3(2) Gravity Block Wall

Excavation shall conform to Section 2-09.3(4), and to the limits and construction stages shown in the Plans. Foundation soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C. Slope above the gravity block wall shall be established prior to beginning any excavation for the wall.

Gravity block walls are defined as a wall of modular blocks acting as a gravity wall to retain soil. The modular blocks may have features designed to interlock the blocks together. However there shall be no reinforcement of the retained soil nor any reinforcement connection between the modular blocks and the retained soil.

Gravity block walls shall be constructed as specified in the Special Provisions and as shown in the Plans.

8-24.3(3) Gabion Cribbing

8-24.3(3)A Foundations

Before placing any gabion cribbing, the Contractor shall excavate the foundation or bed to the specified grade in accordance with Section 2-09.3(4). Foundation soils found to be unsuitable shall be removed and replaced in accordance with Section 2-09.3(1)C.

8-24.3(3)B Baskets

Baskets may be fabricated from either woven or welded steel wire; however, a gabion Structure shall not include both. Baskets may be assembled with either lacing wire or clip fasteners; however, a perimeter or diaphragm edge shall not include both.

8-24.3(3)C Dimensions

The Contractor shall supply gabion baskets in the lengths and heights the Plans require. Each length shall be a multiple (double, triple, or greater) of horizontal width. Horizontal width shall be 36 inches. All baskets from the same manufacturer shall be the same width and shall be within a tolerance of 5 percent of the manufacturer's stated sizes.

8-24.3(3)D Fabrication of Baskets

Gabions shall be made so that the sides, ends, lid, and diaphragms can be assembled into rectangular baskets of the required sizes at the construction site. Common-wall construction may be used in gabion Structures up to 12 feet high. Common-wall construction includes any basket where its top serves as the bottom of the one above it, or where one wall also serves an adjacent basket. When gabion Structures are more than 12 feet high, the baskets shall have independent sides, ends, top, and bottom.

Each gabion shall be divided by diaphragms into cells the same length as horizontal basket width. Diaphragms shall be made of the same mesh and gage as the basket body.

All perimeter and diaphragm edges shall be laced or clipped together so that joints are at least as strong as the body of the mesh itself. The ends of the lacing shall be anchored by three tight turns around the selvage wire.

8-24.3(3)E Filling Baskets

Baskets shall be filled with stone. The stone shall be placed and compacted to meet the unit weight requirements of Section 8-24.3(3)F.

The stone shall be placed in compacted layers not more than 14 inches deep. If cross-connecting wires are required, the Contractor shall adjust the number and depth of layers so that wires occur between the compacted layers of stone.

8-24.3(3)F Unit Weight Requirements and Test

The unit weight of the filled gabion basket shall be at least 100 pounds per cubic foot. Should the unit weight be less than 100 pounds per cubic foot, the gabion will be rejected and the Engineer will require the Contractor to conduct and pass additional unit weight tests before completing other gabions.

The Contractor shall conduct either of the following unit weight tests to prove the density of completed gabions:

1. A filled gabion basket shall be selected from the completed Structure and weighed.
2. A gabion basket shall be filled with stone from a loaded truck that has been weighed. After filling, the truck and unused stone shall be weighed again. The difference between the two weights shall be used to determine the weight per cubic foot of the stone in the gabion.

The Contractor shall conduct one unit weight test for each 500 cubic yards of gabions placed. The Engineer may reduce the specified frequency of these tests provided the specified minimum unit weight has been consistently achieved.

In conducting unit weight test 1 or 2, the Contractor shall provide and use scales conforming to Section 1-09.2.

8-24.3(3)G Gabion Cribbing Erection

Each row or tier of baskets shall be reasonably straight and shall conform to alignment and grade. Hexagonal mesh baskets shall be stretched endwise before filling. The stone shall be carefully placed in layers, then tamped or vibrated. The last layer of stones shall fill each basket completely so that the secured lid will rest upon the stones. Each basket shall be laced securely to all adjacent baskets and its lid then laced or clipped to the sides, ends, and diaphragms.

All selvage wires of ends of adjacent baskets shall be laced together. The bottom selvage of the basket being constructed on a previously constructed basket shall be laced to the top of that basket.

Backfilling behind or around gabions shall conform to Section 2-09.3(1)E.

8-24.4 Measurement

Rock for rock walls and backfill for rock walls will be measured by the ton of rock actually placed.

Gabion cribbing will be measured by the calculated neat line volume of gabion baskets in place, using the manufacturer's stated dimensions.

Gravity block wall will be measured by the square foot of completed wall in place. The vertical limits for measurement are from the bottom of the bottom layer of blocks to the top of the top layer of blocks. The horizontal limits for measurement are from the end of wall to the end of wall.

Construction geotextile will be measured by the square yard for the surface area actually covered.

Structure excavation Class B, Structure excavation Class B including haul, and shoring or extra excavation Class B, will be measured in accordance with Section 2-09.4.

8-24.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Rock for Rock Wall", per ton.

The unit Contract price per ton for "Rock for Rock Wall" shall also include furnishing and installing chinking materials.

"Backfill for Rock Wall", per ton.

"Gabion Cribbing", per cubic yard.

"Gravity Block Wall", per square foot.

"Construction Geotextile", per square yard.

"Structure Excavation Class B", per cubic yard.

"Structure Excavation Class B Incl. Haul", per cubic yard.

"Shoring or Extra Excavation Class B", per square foot.

8-25 Glare Screen

8-25.1 Description

This Work consists of furnishing and constructing glare screen of the types specified, in accordance with the Plans, these Specifications, the *Standard Plans*, and as ordered by the Engineer in accordance with Section 1-04.4.

Glare screen consists of diamond woven wire mesh fence of aluminum, galvanized or aluminum coated steel wire, fabricated and placed to reduce glare from headlights of opposing traffic or other adjacent light sources.

8-25.2 Materials

Materials shall meet the requirements of Section 9-16.6.

8-25.3 Construction Requirements

8-25.3(1) Glare Screen Fabric

Glare screen fabric shall be placed on the face of the posts designated by the Engineer. On curves, the fabric shall be placed on the face of the post that is on the outside of the curve.

The fabric shall be stretched taut and securely fastened to the posts. Fastening to end, corner, and pull posts shall be with stretcher bars and fabric bands spaced at 1-foot intervals. The fabric shall be cut and each span attached independently at all pull and corner posts. Fabric shall be securely fastened to line and brace posts with tie wires, metal bands, or other approved methods, attached at 14-inch intervals. The top and bottom of the fabric shall be fastened to the tension wire with hog rings spaced at 24-inch intervals.

Rolls of wire fabric shall be joined by weaving a single strand into the end of the rolls to form a continuous mesh.

8-25.3(2) Slats

The slats shall be fastened into the weave by using staples, screws, or other methods as approved by the Engineer. Allowing the tension of the mesh to hold the slats in place will not be permitted.

Slats broken or split during construction shall be removed and replaced by the Contractor at no expense to the Contracting Agency.

8-25.3(3) Posts

Posts shall be constructed in accordance with the *Standard Plans* and applicable provisions of Section 8-12.3(1)A.

Posts for Type 1 Design A shall be bolted to the beam guardrail posts as detailed in the *Standard Plans*. Drilling of the guardrail posts shall be done in such a manner to ensure that the glare screen posts are set plumb and centered over the guardrail posts unless otherwise directed.

All round posts for Type 1 Design B and Type 2 glare screen shall be fitted with a watertight top securely fastened to the post. Line posts shall have tops designed to carry the top tension wire.

8-25.3(4) Tension Wire

Tension wires shall be attached to the posts as detailed in the *Standard Plans* or as approved by the Engineer.

8-25.4 Measurement

Measurement of glare screen will be by the linear foot of completed glare screen for the particular type and design specified.

8-25.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Glare Screen Type 1 Design ____", per linear foot.

"Glare Screen Type 2", per linear foot.

8-26 Vacant

8-27 Vacant

8-28 Vacant

8-29 Wire Mesh Slope Protection

8-29.1 Description

This Work consists of furnishing and installing the anchors and the wire mesh slope protection in accordance with these Specifications and the details shown in the Plans and in conformity with the lines and dimensions shown in the Plans or specified by the Engineer.

8-29.2 Materials

Materials shall meet the requirements of Section 9-16.4.

8-29.3 Construction Requirements

8-29.3(1) Submittals

The Contractor shall submit a Type 2 Working Drawing consisting of a wire mesh slope protection plan. The wire mesh slope protection plan shall include the following:

1. Plan sheets for anchor layout and installation, and the equipment and process used to confirm the capacity of the constructed anchors including the calibration data for the stressing devices used to proof test the anchors, as completed by an independent testing laboratory within 60 calendar days of the wire mesh slope work.
2. Working drawings for the temporary yoke or load frame to be used for anchor proof testing in accordance with Section 6-01.9.
3. Plans and details for assembling wire mesh and erecting the assembled mesh on the slope.

All the costs for the Work required for Submittals shall be included in the unit Bid price detailed in Section 8-29.5.

8-29.3(2) Anchors

The Contractor shall install anchors of the type shown in the Plans and in conformance with the layout shown in the wire mesh protection plan. The spacing and number of the anchors and wire ropes as shown in the Plans are approximate only, and upon review of the wire mesh slope protection plan, the Engineer may arrange the spacing to better hold the wire mesh against the slope. Backfill material shall be thoroughly compacted with a mechanical compactor.

The Contractor shall proof test up to 25 percent of the anchors in vertical pullout to the minimum allowable anchor capacity specified in the Plans. Proof testing of anchors shall be performed against a temporary yoke or load frame. No part of the temporary yoke or load frame shall bear within three feet of the anchor being tested. For vertical pullout proof testing, an anchor is acceptable if it sustains the specified capacity for 10 minutes with no loss of load. Anchors that fail this criterion shall be replaced and retested. If more than three anchors fail, the Contractor shall proof test all anchors.

8-29.3(3) Wire Rope

All wire rope loops shall include a thimble. No wire rope splicing will be allowed.

8-29.3(4) Wire Mesh

The wire mesh shall be fastened to the completed wire rope assembly as shown in the Plans. High tensile steel fasteners on the vertical seams shall be staggered across width of the seam. Horizontal splices joining 2 rolls of mesh shall be made by overlapping the mesh approximately 3 feet and either weaving 3 rows of lacing wires through every mesh opening or using 4 rows of high tensile steel fasteners placed on approximately 3-inch spacing. All top and bottom laps shall be made by folding the mesh to the outside, away from the slope, to avoid the possibility of falling material hanging up in the folds. The bottom of the mesh shall be located as shown in the Plans. The ends of all lacing wires shall be secured to the mesh with a minimum of 1½-turns.

The wire mesh shall not be tensioned in any direction, but is to remain loose so as to increase its dampening effect on rolling rocks. The Contractor shall use care in the handling and installing of the wire mesh and wire rope. Any mesh or wire rope damaged due to the Contractor's operations shall be replaced by the Contractor at no expense to the Contracting Agency.

8-29.4 Measurement

Measurement of anchors will be per each for the completed anchor. Anchor types will not be differentiated.

Wire mesh slope protection will be measured by the square foot of wire mesh erected on the slope. There will be no deduction made for overlapping the wire mesh material as required for splices or for coverage due to variations in the slope or ground conditions.

8-29.5 Payment

Payment will be made for each of the following Bid items that are included in the Proposal:

"Wire Mesh Slope Protection Anchor", per each.
The unit Contract price per each for "Wire Mesh Slope Protection Anchor" shall be full payment for all costs for the Work described in Sections 8-29.3(1) and 8-29.3(2).

"Wire Mesh Slope Protection", per square foot.
The unit Contract price per square foot for "Wire Mesh Slope Protection" shall be full payment for all costs for the Work described in Sections 8-29.3(3) and 8-29.3(4).

9-00 Definitions and Tests

9-00.1 Fracture

"Fractured aggregate is defined as an angular, rough, or broken surface of an aggregate particle created by crushing, or by other means. A face is considered a "fractured face" whenever one-half or more of the projected area, when viewed normal to that face, is fractured with sharp and well-defined edges: this excludes small nicks.

9-00.2 Wood Waste

Wood waste is defined as all material which, after drying to constant weight, has a specific gravity of less than 1.0.

9-00.3 Test for Mass of Galvanizing

At the option of the Engineer, the weight of zinc in ounce per square foot required by the various galvanizing Specifications may be determined by an approved magnetic thickness gage suitably checked and demonstrated for accuracy, in lieu of the other methods specified.

9-00.4 Sieves for Testing Purposes

Test sieves shall be made of either: (1) woven wire cloth conforming to ASTM E11, or (2) square-hole, perforated plates conforming to ASTM E323.

9-00.5 Dust Ratio

The dust ratio is defined as the percent of material passing the No. 200 sieve divided by the percent of material passing the No. 40 sieve.

9-00.6 Sand/Silt Ratio

The sand/silt ratio is defined as the percent of material passing the No. 10 sieve divided by the percent of material passing the No. 200 sieve.

9-00.7 Galvanized Hardware, AASHTO M232

An acceptable alternate to hot-dip galvanizing in accordance with AASHTO M 232 will be zinc coatings mechanically deposited in accordance with ASTM B695, providing the minimum thickness of zinc coating is not less than that specified in AASHTO M232, and the process will not produce hydrogen embrittlement in the base metal. Sampling and testing will be made by the Engineer in accordance with commonly recognized national standards and methods used in the laboratory of the Department of Transportation.

9-00.8 Sand Equivalent

The sand equivalent will be the average of duplicate determinations from a single sample. The sand equivalent sample will be prepared in accordance with the FOP for AASHTO T 176.

For acceptance, there must be a clear line of demarcation. If no clear line of demarcation has formed at the end of a 30-minute sedimentation period, the material will be considered as failing to meet the minimum specified sand equivalent.

9-00.9 Field Test Procedures

Field test procedures may be either a Standard Operating Procedure (SOP) or a Field Operating Procedure (FOP) for an AASHTO, ASTM, or WAQTC test procedure. A Field Operating Procedure is a technically equivalent abridged version of an AASHTO, ASTM, or WAQTC test procedure for use in field conditions. References to manuals containing all of these tests and procedures can be found in Section 1-06.2(1).

9-01 Cement

9-01.1 Types of Cement

Cement shall be classified as portland cement, blended hydraulic cement, or rapid hardening hydraulic cement.

9-01.2 Specifications

9-01.2(1) Portland Cement

Portland cement shall meet the requirements of AASHTO M85 or ASTM C150 Types I, II, or III portland cement, except that the cement shall not contain more than 0.75 percent alkalies by weight calculated as Na_2O plus 0.658 K_2O and the content of Tricalcium aluminate (C_3A) shall not exceed 8 percent by weight.

The time of setting shall be determined by the Vicat Test method in accordance with AASHTO T 131 or ASTM C191.

9-01.2(1)A Low Alkali Cement

When low alkali portland cement is required, the percentage of alkalies in the cement shall not exceed 0.60 percent by weight calculated as Na_2O plus 0.658 K_2O. This limitation shall apply to all types of portland cement.

9-01.2(1)B Blended Hydraulic Cement

Blended hydraulic cement shall be either Type IP(X)(MS), Type IS(X)(MS), Type IT(PX)(LY), Type IT(SX)(LY), or Type IL(X) cement conforming to AASHTO M240 or ASTM C595, except that the portland cement used to produce blended hydraulic cement shall not contain more than 0.75 percent alkalies by weight calculated as Na_2O plus 0.658 K_2O and shall meet the following additional requirements:

1. Type IP(X)(MS) – Portland-Pozzolan Cement where (X) equals the targeted percentage of fly ash, the fly ash is limited to a maximum of 35 percent by weight of the cementitious material; (MS) indicates moderate sulfate resistance.
2. Type IS(X)(MS) – Portland Blast- Furnace Slag Cement, where: (X) equals the targeted percentage of ground granulated blast-furnace slag, the ground granulated blast furnace slag is limited to a maximum of 50 percent by weight of the cementitious material; (MS) indicates moderate sulfate resistance.
3. Type IT(PX)(LY), where (PX) equals the targeted percentage of pozzolan, and (LY) equals the targeted percentage of limestone. The pozzolan (PX) shall be Class F fly ash and shall be a maximum of 35 percent. (LY) shall be a minimum of 5 percent and a maximum of 15 percent. Separate testing of each source of fly ash each at each proposed replacement level shall be conducted in accordance with ASTM C1012. Expansion at 180 days shall be 0.10 percent or less.

4. Type IT(SX)(LY), where (SX) equals the targeted percentage of slag cement, and (LY) equals the targeted percentage of limestone. (SX) shall be a maximum of 50 percent. (LY) shall be a minimum of 5 percent and a maximum of 15 percent. Separate testing of each source of slag at each proposed replacement level shall be conducted in accordance with ASTM C1012. Expansion at 180 days shall be 0.10 percent or less.
5. Type IL(X), where (X) equals the targeted percentage of limestone, and shall be a minimum of 5 percent and a maximum of 15 percent. Testing shall be conducted in accordance with ASTM C1012. Expansion at 180 days shall be 0.10 percent or less.

The source and weight of the fly ash or ground granulated blast furnace slag shall be certified on the cement mill test report or cement certificate of analysis and shall be reported as a percent by weight of the total cementitious material. The fly ash or ground granulated blast furnace slag constituent content in the finished cement will not vary more than plus or minus 5 percent by weight of the finished cement from the certified value.

Fly ash shall meet the requirements of Section 9-23.9 of these *Standard Specifications*.

Ground granulated blast furnace slag shall meet the requirements of Section 9-23.10 of these *Standard Specifications*.

Limestone shall meet the requirements of AASHTO M240 or ASTM C595.

9-01.2(2) Rapid Hardening Hydraulic Cement

Rapid hardening hydraulic cement shall meet the requirements of ASTM C 1600.

9-01.3 Tests and Acceptance

Cement may be accepted by the Engineer based on the cement mill test report number or cement certificate of analysis number indicating full conformance to the Specifications. All shipments of the cement to the Contractor or concrete supplier shall identify the applicable cement mill test report number or cement certificate of analysis number and shall be provided by the Contractor or concrete supplier with all concrete deliveries.

Cement producers/suppliers that certify portland cement or blended hydraulic cement shall participate in the Cement Acceptance Program as described in WSDOT Standard Practice QC 1. Rapid hardening hydraulic cement producers/suppliers are not required to participate in WSDOT Standard Practice QC 1.

Each mixing facility or plant utilizing portland cement shall be equipped with a suitable means or device for obtaining a representative sample of the cement. The device shall enable the sample to be readily taken in proximity to the cement weigh hopper and from a container or conveyor holding only cement.

Cement may be tested using samples taken at the job site by the Engineer for submission to the State Materials Laboratory for testing.

9-01.4 Storage on the Work Site

At the request of the Engineer, the Contractor shall provide test data to show that cement stored on site for longer than 60 days meets the requirements of Section 9-01. Tests shall be conducted on samples taken from the site in the presence of the Engineer. Test results that meet the requirements of Section 9-01 shall be valid for 60 days from the date of sampling, after which the Engineer may require further testing.

9-02 Bituminous Materials

9-02.1 Asphalt Material, General

Asphalt furnished under these Specifications shall not have been distilled at a temperature high enough to produce flecks of carbonaceous matter, and upon arrival at the Work, shall show no signs of separation into lighter and heavier components.

The Asphalt Supplier of Performance Graded (PG) asphalt binder and emulsified asphalt shall have a Quality Control Plan (QCP) in accordance with WSDOT QC 2 "Standard Practice for Asphalt Suppliers That Certify Performance Graded and Emulsified Asphalts". The Asphalt Supplier's QCP shall be submitted and approved by the WSDOT State Materials Laboratory. Once accepted, any change to the QCP will require a new QCP to be submitted for acceptance. The Asphalt Supplier of PG asphalt binder and emulsified asphalt shall certify through the Bill of Lading that the PG asphalt binder or emulsified asphalt meets the Specification requirements of the Contract.

9-02.1(1) Vacant

9-02.1(2) Vacant

9-02.1(3) Vacant

9-02.1(4) Performance Graded (PG) Asphalt Binder

PG asphalt binder meeting the requirements of AASHTO M332 Table 1 of the grades specified in the Contract shall be used in the production of HMA. For HMA with greater than 20 percent RAP by total weight of HMA, or any amount of RAS, the new asphalt binder, recycling agent and recovered asphalt (RAP and/or RAS) when blended in the proportions of the mix design shall meet the PG asphalt binder requirements of AASHTO M332 Table 1 for the grade of asphalt binder specified by the Contract.

In addition to AASHTO M 332 Table 1 specification requirements, PG asphalt binders shall meet the following requirements:

		Additional Requirements by Performance Grade (PG) Asphalt Binders					
Property	Test Method	PG 58 S-22	PG 58 H-22	PG 58 V-22	PG 64 S-28	PG 64 H-28	PG 64 V-28
RTFO Residue: Average percent Recovery @ 3.2 kPa	AASHTO T 350[1]			30% Min.	20% Min.	25% Min.	30% Min.

[1]Specimen conditioned in accordance with AASHTO T 240 – RTFO.

The RTFO J_{nrdiff} and the PAV direct tension specifications of AASHTO M 332 are not required.

9-02.1(5) Vacant

9-02.1(6) Cationic Emulsified Asphalt

Cationic Emulsified Asphalt meeting the requirements of AASHTO M 208 Table 1 of the grades specified in the Contract shall be used.

If the particle charge test for CSS-1 and CSS-1h is inconclusive, material having maximum pH value of 6.7 when tested in accordance with ASTM E 70 will be acceptable.

9-02.1(6)A Polymerized Cationic Emulsified Asphalt CRS-2P

CRS-2P shall be a polymerized cationic emulsified asphalt. The polymer shall be milled into the asphalt or emulsion during the manufacturing of the emulsified asphalt. CRS-2P shall meet the following requirements:

	AASHTO Test Method	Specifications	
		Minimum	Maximum
Viscosity @122°F, SFS	T 59	100	400
Storage Stability 1 day %	T 59		1
Demulsibility 35 ml. 0.8% Dioctyl Sodium Sulfosuccinate	T 59	40	
Particle Charge	T 59	positive	
Sieve Test %	T 59		0.30
Distillation			
Oil distillate by vol. of emulsion %	T 59[1]	0	3
Residue	T 59[1]	65	
Tests on the Residue From Distillation			
Penetration @77°F	T 49	100	250
Elastic Recovery %	T 301[2]	50	

[1]Distillation modified to use 300 grams of emulsified asphalt heated to 350°F ± 9°F and maintained for 20 minutes.
[2]The residue material for T 301 shall come from the modified distillation per note 1.

9-02.1(7) Vacant

9-02.1(8) Flexible Bituminous Pavement Marker Adhesive

Flexible bituminous pavement marker adhesive is a hot melt thermoplastic bituminous material used for bonding raised pavement markers and recessed pavement markers to the pavement.

The adhesive material shall conform to the following requirements when prepared in accordance with WSDOT SOP 318 in the WSDOT *Materials Manual* M 46-01:

Property	Test Method	Requirement
Penetration, 77°F, 100g, 5 sec, dmm	AASHTO T 49	30 Max.
Softening Point, F	AASHTO T 53	200 Min.
Rotational Thermosel Viscosity, cP, #27 spindle, 20 RPM, 400°F	AASHTO T 316	5000 Max.
Ductility, 77°F, 5 cm/minute, cm	AASHTO T 51	15 Min.
Ductility, 39.2°F, 1 cm/minute, cm	AASHTO T 51	5 Min.
Flexibility, 1", 20°F, 90 deg. Bend, 10 sec., ⅛"× 1" × 6" specimen	ASTM D3111[1]	Pass
Bond Pull-Off Strength	WSDOT T 426	Greater than 50 psi

[1]Flexibility test is modified by bending specimen through an arc of 90 degrees at a uniform rate in 10 seconds over a 1-inch diameter mandrel.

9-02.2 Sampling and Acceptance

9-02.2(1) Certification of Shipment

Bituminous materials may be accepted by the Engineer based on the asphalt binder supplier's Certification of Compliance incorporated in their Bill of Lading. The Certification will include a statement certifying Specification compliance for the product shipped. Failure to provide this Certification with the shipment shall be cause for rejection of the material. The following information is required on the Bill of Lading:

1. Date
2. Contract Number and/or Project Name
3. Grade of Commodity and Certification of Compliance
4. Anti-strip Type
5. Percent Anti-strip
6. Mass (Net Tons)
7. Volume (Gross Gallons)
8. Temperature of Load (F)
9. Bill of Lading Number
10. Consignee and Delivery Point
11. Signature of Supplier's Representative
12. Supplier (Bill of Lading Generator)
13. Supplier's Address
14. Refiner
15. Refiner's Location

The Bill of Lading shall be supplied at the time of shipment of each truck load, truck and trailer, or other lot of asphalt binder. In addition to the copies the Contractor requires, one copy of the Bill of Lading including the Certification Statement shall be sent with the shipment for agency use.

9-02.2(2) Samples

When requested by the Engineer, the asphalt supplier shall ship, by prepaid express or U.S. mail, samples of asphalt that represent current production.

9-02.3 Temperature of Asphalt

The temperature of paving asphalts in storage tanks when loaded for transporting shall not exceed the maximum temperature recommended by the asphalt binder manufacturer.

9-02.4 Anti-Stripping Additive

Anti-stripping additive shall be a product listed in the current WSDOT Qualified Products List (QPL).

Hydrated lime, when used in HMA as an anti-strip additive shall conform to the requirements of either AASHTO M 303 Type I or ASTM C1097.

9-02.5 HMA Additive

Additives for HMA shall be accepted by the Engineer.

9-03 Aggregates

9-03.1 Aggregates for Concrete

9-03.1(1) General Requirements

Concrete aggregates shall be manufactured from ledge rock, talus, or sand and gravel in accordance with the provisions of Section 3-01. Reclaimed aggregate may be used if it complies with the specifications for concrete. Reclaimed aggregate is aggregate that has been recovered from plastic concrete by washing away the cementitious materials.

Aggregates for Concrete shall meet the following test requirements:

Los Angeles Wear, 500 Rev.	35 max.
Degradation Factor (Structural and Paving Concrete)	30 min.
Degradation Factor (Other as defined in 6-02.3(2)B	20 min.

Aggregates tested in accordance with AASHTO T 303 with expansion greater than 0.20 percent are Alkali Silica Reactive (ASR) and will require mitigating measures. Aggregates tested in accordance with ASTM C1293 with expansion greater than 0.04 percent are Alkali Silica Reactive (ASR) and will require mitigating measures.

Aggregates for use in Commercial Concrete as defined in Section 6-02.3(2)B shall not require mitigation.

Mitigating measures for aggregates with expansions from 0.21 to 0.45 percent, when tested in accordance with AASHTO T 303, may be accomplished by using low alkali cement as per Section 9-01.2(1)A or by using 25 percent Class F fly ash by total weight of the cementitious materials. The Contractor may submit an alternative mitigating measure through the Engineer to the State Materials Laboratory for approval along with evidence in the form of test results from ASTM C1567 that demonstrate the mitigation when used with the proposed aggregate controls expansion to 0.20 percent or less. The agency may test the proposed ASR mitigation measure to verify its effectiveness. In the event of a dispute, the agency's results will prevail.

Mitigating measures for aggregates with expansions greater than 0.45 percent when tested in accordance with AASHTO T 303 shall include the use of low alkali cement per Section 9-01.2(1)A and may include the use of fly ash, lithium compound admixtures, ground granulated blast furnace slag or other material as approved by the Engineer. The Contractor shall submit evidence in the form of test results from ASTM C1567 through the Engineer to the State Materials Laboratory that demonstrate the proposed mitigation when used with the aggregates proposed will control the potential expansion to 0.20 percent or less before the aggregate source may be used in concrete. The agency may test the proposed ASR mitigation measure to verify its effectiveness. In the event of a dispute, the agency's results will prevail.

The use of fly ash that does not meet the requirements of Table 2 of AASHTO M295 may be approved for use. The Contractor shall submit test results according to ASTM C1567 through the Engineer to the State Materials Laboratory that demonstrate that the proposed fly ash when used with the proposed aggregates and cement will control the potential expansion to 0.20 percent or less before the fly ash and aggregate sources may be used in concrete. The Contracting Agency may test the proposed ASR mitigation measure to verify its effectiveness. In the event of a dispute, the Contracting Agency's results will prevail.

ASTM C1293 sampling and testing must be coordinated through the WSDOT State Materials Laboratory, Documentation Section utilizing the ASA (Aggregate Source Approval) process. Cost of sampling, testing, and processing will be borne by the source owner.

9-03.1(2) Fine Aggregate for Concrete

Fine aggregate shall consist of natural sand or manufactured sand, or combinations thereof, accepted by the Engineer, having hard, strong, durable particles free from adherent coating. Fine aggregate shall be washed thoroughly to meet the specifications.

9-03.1(2)A Deleterious Substances

The amount of deleterious substances in the washed aggregate shall be tested in accordance with AASHTO M 6 and not exceed the following values:

Material finer than No. 200 Sieve	2.5 percent by weight
Clay lumps and friable particles	3.0 percent by weight
Coal and lignite	0.25 percent by weight
Particles of specific gravity less than 2.00	1.0 percent by weight

Organic impurities shall be tested in accordance with AASHTO T 21 by the glass color standard procedure and results darker than organic plate no. 3 shall be rejected. A darker color results from AASHTO T 21 may be used provided that when tested for the effect of organic impurities on strength of mortar, the relative strength at 7 days, calculated in accordance with AASHTO T 71, is not less than 95 percent.

9-03.1(2)B Grading

Fine aggregate shall be graded to conform to the following requirements expressed as percentages by weight:

Sieve Size	Class 1 Percent Passing		Class 2 Percent Passing	
	Min.	Max.	Min.	Max.
⅜″	99	100	99	100
No. 4	95	100	95	100
No. 8	68	86		
No. 16	47	65	45	80
No. 30	27	42		
No. 50	9	20	10	30
No. 100	0	7	2	10
No. 200	0	2.5	0	2.5

For fine aggregate Class 1, individual test variations under the minimum or over the maximum will be permitted as follows, provided the average of three consecutive tests is within the Specification limits:

Sieve Size	Permissible percent of Variation in Individual Tests
No. 30 and coarser	2
No. 50 and finer	0.5

Within the gradation limits for fine aggregate Class 2, uniformity of gradation shall be limited to a range of plus or minus 0.20 of the reference fineness modulus. The reference fineness modulus shall be determined from a representative sample from the proposed source as submitted by the Contractor.

9-03.1(3) Vacant

9-03.1(4) Coarse Aggregate for Concrete

Coarse aggregate for concrete shall consist of gravel, crushed stone, or combinations thereof having hard, strong, durable pieces free from adherent coatings. Coarse aggregate shall be washed to meet the specifications.

9-03.1(4)A Deleterious Substances

The amount of deleterious substances in the washed aggregate shall be tested in accordance with AASHTO M 80 and not exceed the following values:

Material finer than No. 200	1.0[1] percent by weight
Clay lumps and Friable Particles	2.0 percent by weight
Shale	2.0 percent by weight
Wood waste	0.05 percent by weight
Coal and Lignite	0.5 percent by weight
Sum of Clay Lumps, Friable Particles, and Chert (Less Than 2.40 specific gravity SSD)	3.0 percent by weight

[1]If the material finer than the No. 200 sieve is free of clay and shale, this percentage may be increased to 1.5.

9-03.1(4)B Vacant

9-03.1(4)C Grading

Coarse aggregate for concrete when separated by means of laboratory sieves shall conform to one or more of the following gradings as called for elsewhere in these Specifications, Special Provisions, or in the Plans:

Passing	AASHTO Grading No. 467		AASHTO Grading No. 4		AASHTO Grading No. 57		AASHTO Grading No. 67		AASHTO Grading No. 7		AASHTO Grading No. 8	
Sieve Size	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
2″	99	100	99	100								
1½″	95	100	90	100	99	100						
1″			20	55	95	100	99	100				
¾″	35	70	0	15			90	100	99	100		
½″					25	60			90	100	99	100
⅜″	10	30	0	5			20	55	40	70	85	100
No. 4	0	5			0	10	0	10	0	15	10	30
No. 8					0	5	0	5	0	5	0	10
No. 16											0	5

All percentages are by weight.

Where coarse aggregate size 467 is used, the aggregate may be furnished in at least two separate sizes. Coarse aggregate shall contain no piece of greater size than two times the maximum sieve size for the specified grading measured along the line of greatest dimension.

9-03.1(5) Combined Aggregate Gradation for Concrete

As an alternative to using the fine aggregate sieve grading requirements in Section 9-03.1(2)B, and coarse aggregate sieve grading requirements in Section 9-03.1(4)C, a combined aggregate gradation conforming to the requirements of Section 9-03.1(5)A may be used.

9-03.1(5)A Deleterious Substances

The amount of deleterious substances in the washed aggregates ⅜ inch or larger shall not exceed the values specified in Section 9-03.1(4)A and for aggregates smaller than ⅜ inch they shall not exceed the values specified in Section 9-03.1(2)A.

9-03.1(5)B Grading

The combined aggregate shall conform to the following requirements based upon the nominal maximum aggregate size.

Nominal Maximum Aggregate Size	3	2-½	2	1-½	1	¾	½	⅜	No. 4
3½″	99-100								
3″	93-100*	99-100							
2½″		92-100*	99-100						
2″	76-90		90-100*	99-100					
1½″	66-79	71-88		87-100*	99-100				
1″	54-66	58-73	64-83		82-100*	99-100			
¾″	47-58	51-64	55-73	62-88		87-100*	99-100		
½″	38-48	41-54	45-61		57-83		81-100*	99-100	
⅜″	33-43	35-47	39-54	43-64		60-88		86-100*	99-100
No. 4	22-31	24-34	26-39	29-47	34-54	41-64	48-73		68-100*
No. 8	15-23	16-25	17-29	19-34	22-39	27-47	31-54	39-73	
No. 16	9-17	10-18	11-21	12-25	14-29	17-34	20-39	24-54	28-73
No. 30	5-12	6-14	6-15	7-18	8-21	9-25	11-29	13-39	16-54
No. 50	2-9	2-10	3-11	3-14	3-15	4-18	5-21	6-29	7-39
No. 100	0-7	0-7	0-8	0-10	0-11	0-14	0-15	0-21	0-29
No. 200	0-2.0	0-2.0	0-2.0	0-2.0	0-2.0	0-2.0	0-2.0	0-2.0	0-2.5

*Nominal Maximum Size
All percentages are by weight.

Nominal maximum size for concrete aggregate is defined as the smallest standard sieve opening through which the entire amount of the aggregate is permitted to pass. Standard sieve sizes shall be those listed in ASTM C33.

The Contracting Agency may sample each aggregate component prior to introduction to the weigh batcher or as otherwise determined by the Engineer. Each component will be sieve analyzed separately in accordance with FOP for WAQTC/AASHTO T 27/T 11. All

aggregate components will be mathematically re-combined by the proportions (percent of total aggregate by weight), provided by the Contractor on Concrete Mix Design Form 350-040.

9-03.2 Aggregate for Job-Mixed Portland Cement or Blended Hydraulic Cement Mortar

Fine aggregate for portland cement or blended hydraulic cement mortar shall consist of sand or other inert materials, or combinations thereof, accepted by the Engineer, having hard, strong, durable particles free from adherent coating. Fine aggregate shall be washed thoroughly to remove clay, loam, alkali, organic matter, or other deleterious matter.

The amount of deleterious substances in the washed aggregate shall not exceed the limit specified in Section 9-03.1(2)A.

9-03.2(1) Grading for Surface Finishing Applications

Fine aggregate shall be graded to conform to the following requirements expressed as percentage by weight:

Sieve	Percent Passing			
	Natural Sand		Manufactured Sand	
	Min.	Max.	Min.	Max.
No. 4	99	100	99	100
No. 8	90	100	90	100
No. 16	60	90	60	90
No. 30	35	70	35	70
No. 50	10	30	20	40
No. 100	0	5	10	25
No. 200	0	3	0	10

9-03.2(2) Grading for Masonry Mortar Applications

Fine aggregate shall be graded to conform to the following requirements expressed as percent age by weight:

Sieve	Percent Passing			
	Natural Sand		Manufactured Sand	
	Min.	Max.	Min.	Max.
No. 4	99	100	99	100
No. 8	95	100	95	100
No. 16	70	100	70	100
No. 30	40	75	40	75
No. 50	10	35	20	40
No. 100	2	15	10	25
No. 200	0	5	0	10

9-03.3 Vacant

9-03.4 Aggregate for Bituminous Surface Treatment

9-03.4(1) General Requirements

Aggregate for bituminous surface treatment shall be manufactured from ledge rock, talus, or gravel, in accordance with Section 3-01. Aggregates for Bituminous Surface Treatment shall meet the following test requirements:

Los Angeles Wear, 500 Rev.	35 percent max.
Degradation Factor	30 min.

9-03.4(2) Grading and Quality

Aggregate for bituminous surface treatment shall conform to the requirements in the table below for grading and quality. The particular type or grading to be used shall be as shown in the Plans. All percentages are by weight.

The material shall meet the requirements for grading and quality when placed in hauling vehicles for delivery to the roadway, or during manufacture and placement into a temporary stockpile. The exact point of acceptance will be determined by the Engineer.

Crushed Screening percent Passing					
	¾″-½″	⅝″-No. 4	½″-No. 4	⅜″-No. 4	No. 4-0
1″	99-100				
¾″	95-100	99-100			
⅝″		95-100	99-100		
½″	0-20		90-100	99-100	
⅜″	0-5		60-85	70-90	99-100
No. 4		0-10	0-3	0-5	76-100
No. 10		0-3			30-60
No. 200	0-1.5	0-1.5	0-1.5	0-1.5	0-10.0
% fracture, by weight, min.	90	90	90	90	90

All percentages are by weight.

The fracture requirement shall be at least one fractured face and will apply to the combined aggregate retained on the No. 4 sieve in accordance with FOP for AASHTO T 335.

The finished product shall be clean, uniform in quality, and free from wood, bark, roots, and other deleterious materials.

Crushed screenings shall be substantially free from adherent coatings. The presence of a thin, firmly adhering film of weathered rock shall not be considered as coating unless it exists on more than 50 percent of the surface area of any size between successive laboratory sieves.

The portion of aggregate for bituminous surface treatment retained on a No. 4 sieve shall not contain more than 0.1 percent deleterious materials by weight.

Fine aggregate used for choke stone applications meeting the grading requirements of Section 9-03.1(2)B may be substituted for the No. 4-0 gradation.

9-03.5 Vacant

9-03.6 Vacant

9-03.7 Vacant

9-03.8 Aggregates for Hot Mix Asphalt

9-03.8(1) General Requirements

Aggregates for Hot Mix Asphalt shall meet the following test requirements:

Los Angeles Wear, 500 Rev.	30 percent max.
Degradation Factor, Wearing Course	30 min.
Degradation Factor, Other Courses	20 min.
Sand Equivalent	45 min.

Aggregate sources that have 100 percent of the mineral material passing the No. 4 sieve shall be limited to no more than 5 percent of the total weight of aggregate.

Aggregates shall be uniform in quality, substantially free from wood, roots, bark, extraneous materials, and adherent coatings. The presence of a thin, firmly adhering film of weathered rock will not be considered as coating unless it exists on more than 50 percent of the surface area of any size between consecutive laboratory sieves.

Aggregate removed from deposits contaminated with various types of wood waste shall be washed, processed, selected, or otherwise treated to remove sufficient wood waste so that the oven dried material retained on a No. 4 sieve shall not contain more than 0.1 percent by weight of material with a specific gravity less than 1.0.

9-03.8(2) HMA Test Requirements

Aggregate for HMA shall meet the following test requirements:

1. Vacant
2. The fracture requirements for the combined coarse aggregate shall apply to the material retained on the No. 4 sieve and above, when tested in accordance with FOP for AASHTO T 335.

ESAL's (millions)	# Fractured Faces	% Fracture
< 10	1 or more	90
≥ 10	2 or more	90

3. The uncompacted void content for the combined fine aggregate is tested in accordance with FOP for AASHTO T 304, Method A. The minimum percent voids shall be as required in the following table:

Traffic	HMA Evaluation	
ESAL's (millions)	Statistical	Commercial
< 3	40	40
≥ 3	44	40

4. The minimum sand equivalent for the aggregate shall be 45.

The mix design shall produce HMA mixtures when combined with RAP, RAS, coarse and fine aggregate within the limits set forth in Section 9-03.8(6) and mixed in the laboratory with the designated grade of asphalt binder, using the Superpave gyratory compactor in accordance with FOP for AASHTO T 312, and at the required gyrations for N initial, N design, and N maximum with the following properties:

Mix Criteria	HMA Class							
	⅜ inch		½ inch		¾ inch		1 inch	
	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Voids in Mineral Aggregate (VMA), %	15.0		14.0		13.0		12.0	
Voids Filled With Asphalt (VFA), %								
ESAL's (millions)	VFA							
< 0.3	70	80	70	80	70	80	67	80
0.3 to < 3	65	78	65	78	65	78	65	78
≥ 3	73	76	65	75	65	75	65	75
Dust/Asphalt Ratio	0.6	1.6	0.6	1.6	0.6	1.6	0.6	1.6

Test Method	ESAL's (millions)	Number of Passes
Hamburg Wheel-Track Testing, FOP for AASHTO T 324	< 0.3	10,000
Minimum Number of Passes with no Stripping Inflection Point and Maximum Rut Depth of 10 mm	0.3 to < 3	12,500
	≥ 3	15,000
Indirect Tensile (IDT) Strength (psi) of Bituminous Materials FOP for ASTM D6931	175 Maximum	

	ESAL's (millions)	N initial	N design	N maximum
% Gmm	< 0.3	≤ 91.5	96.0	≤ 98.0
	0.3 to < 3	≤ 90.5	96.0	≤ 98.0
	≥ 3	≤ 89.0	96.0	≤ 98.0
Gyratory Compaction (number of gyrations)	< 0.3	6	50	75
	0.3 to < 3	7	75	115
	> 3	8	100	160

The mix criteria for Hamburg Wheel-Track Testing and Indirect Tensile Strength do not apply to HMA accepted by commercial evaluation.

When material is being produced and stockpiled for use on a specific contract or for a future contract, the uncompacted void content, fracture, and sand equivalent requirements shall apply at the time of stockpiling. When material is used from a stockpile that has not been tested as provided above, the Specifications for uncompacted void content, fracture, and sand equivalent shall apply at the time of its introduction to the cold feed of the mixing plant.

9-03.8(3) Grading

9-03.8(3)A Gradation

The Contractor may furnish aggregates for use on the same contract from multiple stockpiles. The gradation of the aggregates shall be such that the completed mixture complies in all respects with the pertinent requirements of Section 9-03.8(6).

Acceptance of the aggregate gradation shall be based on samples taken from the final mix.

9-03.8(3)B Gradation – Recycled Asphalt Pavement and Mineral Aggregate

The gradation for the new aggregate used in the production of the HMA shall be the responsibility of the Contractor, and when combined with recycled material, the combined material shall meet the gradation Specification requirements for the specified Class HMA as listed in Section 9-03.8(6) or as shown in the Special Provisions. The new aggregate shall meet the general requirements listed in Section 9-03.8(1) and Section 9-03.8(2). No contamination by deleterious materials shall be allowed in the old asphalt concrete used.

For HMA with greater than 20 percent RAP by total weight of HMA the RAP shall be processed to ensure that 100 percent of the material passes a sieve twice the size of the maximum aggregate size for the class of mix to be produced.

When any amount of RAS is used in the production of HMA the RAS shall be milled, crushed or processed to ensure that 100 percent of the material passes the ½ inch sieve. Extraneous materials in RAS such as metals, glass, rubber, soil, brick, tars, paper, wood and plastic shall not exceed 2.0 percent by mass as determined on material retained on the No. 4 sieve.

9-03.8(4) Vacant

9-03.8(5) Mineral Filler

Mineral filler, when used in HMA mix, shall conform to the requirements of AASHTO M 17.

9-03.8(6) HMA Proportions of Materials

The materials of which HMA is composed shall be of such sizes, grading, and quantity that, when proportioned and mixed together, they will produce a well graded mixture within the requirements listed below.

The aggregate percentage refers to completed dry mix, and includes mineral filler when used.

Aggregate Gradation Control Points				
Sieve Sizes Percent Passing	⅜ inch	½ inch	¾ inch	1 inch
1½″				99-100
1″			99-100	90-100
¾″		99-100	90-100	90 Maximum
½″	99-100	90-100	90 Maximum	
⅜″	90-100	90 Maximum		
No. 4	90 Maximum			
No. 8	32-67	28-58	23-49	19-45
No. 200	2.0-7.0	2.0-7.0	2.0-7.0	1.0-7.0

9-03.8(7) HMA Tolerances, Specification Limits and Adjustments

1. **Job Mix Formula Tolerances** and Specification Limits – The constituents of the HMA mixture at the time of acceptance shall conform to the following tolerances and specification limits:

Job Mix Formula Aggregate Tolerance Limits		
Aggregate, Percent Passing	Statistical Evaluation	Visual Evaluation
1", ¾", ½" and ⅜" sieves	± 6%	± 8%
No. 4 sieve	± 5%	± 8%
No. 8 sieve	± 4%	± 8%
No. 200 sieve	± 2%	± 3%

Voids in Mineral Aggregate (VMA) Tolerance Limit from the Minimum VMA Value in Section 9-03.8(2) HMA Test Requirements			
Statistical Evaluation			
HMA Class			
⅜ inch	½ inch	¾ inch	1 inch
-0.5%	-0.5%	-0.5%	-0.5%

Specification Limits		
HMA Mix Property	**Statistical Evaluation**	**Visual Evaluation**
Asphalt Binder	- 0.4% to + 0.5%	± 0.7%
Air Voids, Va	2.5% minimum to 5.5% maximum	

These tolerance and specification limits constitute the allowable limits as described in Section 1-06.2. The tolerance limit for aggregate shall not exceed the limits of the control points, except the tolerance limits for sieves designated as 100 percent passing will be 99-100.

2. **Job Mix Formula Adjustments** – An adjustment to the aggregate gradation or asphalt binder content of the JMF requires approval of the Engineer. Adjustments to the JMF will only be considered if the change produces material of equal or better quality and may require the development of a new mix design if the adjustment exceeds the amounts listed below.

   a. **Aggregates** – The maximum adjustment from the approved mix design shall be 2 percent for the aggregate passing the 1½″, 1″, ¾″, ½″, ⅜″, and the No. 4 sieves, 1 percent for aggregate passing the No. 8 sieve, and 0.5 percent for the aggregate passing the No. 200 sieve. The adjusted JMF shall be within the range of the control points in Section 9-03.8(6).

   b. **Asphalt Binder Content** – The Engineer may order or approve changes to asphalt binder content. The maximum adjustment from the approved mix design for the asphalt binder content shall be 0.3 percent.

9-03.9 Aggregates for Ballast and Crushed Surfacing

9-03.9(1) Ballast

Ballast shall consist of crushed, partially crushed, or naturally occurring granular material from approved sources manufactured in accordance with the provisions of Section 3-01.

Aggregates for ballast shall meet the following test requirements:

Los Angeles Wear, 500 Rev	40 percent max.
Degradation Factor	15 min.

Ballast shall meet the following requirements for grading and quality when placed in hauling vehicles for delivery to the roadway or during manufacture and placement into a temporary stockpile. The exact point of acceptance will be determined by the Engineer.

The portion of ballast retained on No. 4 sieve shall not contain more than 0.2 percent wood waste.

Sieve Size	Percent Passing
2½″	99-100
2″	65-100
1″	50-85
No. 4	26-44
No. 40	16 max.
No. 200	9.0 max.
Dust Ratio:	⅔ max.
Sand Equivalent	35 min.

All percentages are by weight.

9-03.9(2) Permeable Ballast

Permeable ballast shall meet the requirements of Section 9-03.9(1) for ballast except for the following special requirements.

The grading and quality requirements are:

Sieve Size	Percent Passing
2½″	99-100
2″	65-100
¾″	40-80
No. 4	5 max.
No. 100	0-2
% Fracture	75 min.

All percentages are by weight.

The sand equivalent value and dust ratio requirements do not apply.

The fracture requirement shall be at least one fractured face and will apply the combined aggregate retained on the No. 4 sieve in accordance with FOP for AASHTO T 335.

9-03.9(3) Crushed Surfacing

Crushed surfacing shall be manufactured from ledge rock, talus, or gravel in accordance with the provisions of Section 3-01. The materials shall be uniform in quality and substantially free from wood, roots, bark, and other extraneous material and shall meet the following quality test requirements:

Los Angeles Wear, 500 Rev.	35 percent max.
Degradation Factor – Top Course	25 min.
Degradation Factor – Base Course	15 min.

Crushed surfacing of the various classes shall meet the following requirements for grading and quality when placed in hauling vehicles for delivery to the roadway, or during manufacture and placement into a temporary stockpile. The exact point of acceptance will be determined by the Engineer.

Sieve Size	Base Course	Top Course and Keystone
	Percent Passing	
1¼″	99-100	
1″	80-100	
¾″		99-100
⅝″	50-80	
½″		80-100
No. 4	25-45	46-66
No. 40	3-18	8-24
No. 200	7.5 max.	10.0 max.
% Fracture	75 min.	75 min.
Sand Equivalent	40 min.	40 min.

All percentages are by weight.

The fracture requirement shall be at least one fractured face and will apply to the combined aggregate retained on the No. 4 sieve in accordance with FOP for AASHTO T 335.

The portion of crushed surfacing retained on a No. 4 sieve shall not contain more than 0.15 percent wood waste.

9-03.9(4) Maintenance Rock

Maintenance rock shall meet all requirements of Section 9-03.9(3) for crushed surfacing top course except that it shall meet the following Specifications for grading:

Sieve Size	Percent Passing
⅝″	99-100
½″	90-100
No. 4	45-66
No. 40	10-25
No. 200	7 max.

All percentages are by weight.

9-03.10 Aggregate for Gravel Base

Gravel base shall consist of granular material, either naturally occurring or processed. It shall be essentially free from various types of wood waste or other extraneous or objectionable materials. It shall have such characteristics of size and shape that it will compact readily, and the maximum particle size shall not exceed ⅔ of the depth of the layer being placed.

Gravel base shall meet the following requirements for grading and quality when placed in hauling vehicles for delivery to the roadway or during manufacture and placement into a temporary stockpile. The exact point of acceptance will be determined by the Engineer.

Sieve Size	Percent Passing
2″	75-100
No. 4	22-100
No. 200	0-10
Dust Ratio:	⅔ max.
Sand Equivalent	30 min.

All percentages are by weight.

Gravel base material retained on a No. 4 sieve shall contain not more than 0.20 percent by weight of wood waste.

9-03.11 Streambed Aggregates

Streambed aggregates shall be naturally occurring water rounded aggregates. Aggregates from quarries, ledge rock, and talus slopes are not acceptable for these applications. Streambed aggregates shall meet the following test requirements for quality:

Aggregate Property	Test Method	Requirement
Degradation Factor	WSDOT T 113	15 min.
Los Angeles Wear, 500 Rev.	AASHTO T 96	50% max.
Bulk Specific Gravity	AASHTO T 85	2.55 min.

9-03.11(1) Streambed Sediment

Streambed sediment shall meet the following requirements for grading when placed in hauling vehicles for delivery to the project or during manufacture and placement into temporary stockpile. Alternate gradations may be used if proposed by the Contractor and accepted by the Engineer. The Contractor shall submit a Type 2 Working Drawing consisting of 0.45 power maximum density curve of the proposed gradation. The alternate gradation shall closely follow the maximum density line and have Nominal Aggregate Size of no less than 1½ inches or no greater than 3 inches. The exact point of acceptance will be determined by the Engineer.

Sieve Size	Percent Passing
2½″	99-100
2″	65-95
1″	50-85
No. 4	26-44
No. 40	16 max.
No. 200	5.0-9.0

All percentages are by weight.

The portion of sediment retained on No. 4 sieve shall not contain more than 0.2 percent wood waste.

9-03.11(2) Streambed Cobbles

Streambed cobbles shall be clean, naturally occurring water rounded gravel material. Streambed cobbles shall have a well-graded distribution of cobble sizes and conform to one or more of the following gradings as shown in the Plans:

Percent Passing					
Approximate Size[1]	4″ Cobbles	6″ Cobbles	8″ Cobbles	10″ Cobbles	12″ Cobbles
12″					99-100
10″				99-100	70-90
8″			99-100	70-90	
6″		99-100	70-90		
5″		70-90			30-60
4″	99-100			30-60	
3″	70-90		30-60		
2″		30-60			
1½″	20-50				
¾″	10 max.	10 max.	10 max.	10 max.	10 max.

[1]Approximate Size can be determined by taking the average dimension of the three axes of the rock, Length, Width, and Thickness, by use of the following calculation:

$$\frac{\text{Length + Width + Thickness}}{3} = \text{Approximate Size}$$

Length is the longest axis, width is the second longest axis, and thickness is the shortest axis.

The grading of the cobbles shall be determined by the Engineer by visual inspection of the load before it is dumped into place, or, if so ordered by the Engineer, by dumping individual loads on a flat surface and sorting and measuring the individual rocks contained in the load.

9-03.11(3) Streambed Boulders

Streambed boulders shall be hard, sound and durable material, free from seams, cracks, and other defects tending to destroy its resistance to weather. Streambed Boulders shall be rounded to sub-angular in shape and the thickness axis shall be greater than 60 percent of the length axis. Streambed boulders sizes are approximately as follows, see Plans for sizes specified:

Rock Size[1]	Approximate Size
One Man	12″ – 18″
Two Man	18″ – 28″
Three Man	28″ – 36″
Four Man	36″ – 48″
Five Man	48″ – 54″
Six Man	54″ – 60″

[1]Approximate Size can be determined by taking the average dimension of the three axes of the rock, Length, Width, and Thickness, by use of the following calculation:

$$\frac{\text{Length + Width + Thickness}}{3} = \text{Approximate Size}$$

Length is the longest axis, width is the second longest axis, and thickness is the shortest axis.

9-03.11(4) Habitat Boulders

Habitat boulders shall be hard, sound and durable material, free from seams, cracks, and other defects tending to destroy its resistance to weather. Habitat Boulders shall be rounded to sub-angular in shape and the thickness axis shall be greater than 60 percent of the width axis and the length shall be 1.5 to 3 times the width axis. Habitat boulders sizes are approximately as follows, see Plans for sizes specified:

Rock Size[1]	Approximate Size
Three Man	28″ - 36″
Four Man	36″ - 48″
Five Man	48″ - 54″
Six Man	54″ - 60″

[1]Approximate Size can be determined by taking the average dimension of the three axes of the rock, Length, Width, and Thickness, by use of the following calculation:

$$\frac{\text{Length + Width + Thickness}}{3} = \text{Approximate Size}$$

Length is the longest axis, width is the second longest axis, and thickness is the shortest axis.

9-03.12 Gravel Backfill

Gravel backfill shall consist of crushed, partially crushed, or naturally occurring granular material produced in accordance with the provisions of Section 3-01.

9-03.12(1) Gravel Backfill for Foundations

9-03.12(1)A Class A

Gravel backfill for foundations, Class A, shall conform to the requirements of Section 9-03.9(1) for ballast or Section 9-03.9(3) for crushed surfacing base course.

9-03.12(1)B Class B

Gravel backfill for foundations, Class B, shall conform to the requirements of Section 9-03.10.

9-03.12(2) Gravel Backfill for Walls

Gravel backfill for walls shall consist of free draining granular material, essentially free from various types of wood waste or other extraneous or objectionable materials. It shall meet the following requirements for grading and quality when placed in hauling vehicles for delivery to the roadway or during manufacture and placement into a temporary stockpile. The exact point of acceptance will be determined by the Engineer.

Sieve Size	Percent Passing
4″	99-100
2″	75-100
No. 4	22-66
No. 200	5.0 max.
Dust Ratio: $\frac{\text{\% Passing No. 200}}{\text{\% Passing No. 40}}$	⅔ max.
Sand Equivalent	60 min.

All percentages are by weight.

That portion of the material retained on a No. 4 sieve shall contain not more than 0.20 percent by weight of wood waste.

9-03.12(3) Gravel Backfill for Pipe Zone Bedding

Gravel backfill for pipe zone bedding shall consist of crushed, processed, or naturally occurring granular material. It shall be free from various types of wood waste or other extraneous or objectionable materials. It shall have such characteristics of size and shape that it will compact and shall meet the following Specifications for grading and quality:

Sieve Size	Percent Passing
1½″	99-100
1″	75-100
⅝″	50-100
No. 4	20-80
No. 40	3-24
No. 200	10.0 max.
Sand Equivalent	35 min.

All percentages are by weight.

If, in the opinion of the Engineer, the native granular material is free from wood waste, organic material, and other extraneous or objectionable materials, but otherwise does not conform to the Specifications for grading and Sand Equivalent, it may be used for pipe bedding for rigid pipes, provided the native granular material has a maximum dimension of 1½ inches.

9-03.12(4) Gravel Backfill for Drains

Gravel backfill for drains shall conform to the following gradings:

Sieve Size	Percent Passing
1″	99-100
¾″	80-100
⅜″	0-40
No. 4	0-4
No. 200	0-2

As an alternative, AASHTO grading No. 57 may be used in accordance with Section 9-03.1(4)C. Alkali silica reactivity testing is not required.

9-03.12(5) Gravel Backfill for Drywells

Gravel backfill for drywells shall conform to the following gradings:

Sieve Size	Percent Passing
1½″	99-100
1″	50-100
¾″	0-20
⅜″	0-2
No. 200	0-1.5

As an alternative, AASHTO grading No. 4 may be used in accordance with Section 9-03.1(4)C. Alkali silica reactivity testing is not required.

9-03.13 Backfill for Sand Drains

Backfill for sand drains shall conform to the following grading:

Sieve Size	Percent Passing
½″	90-100
No. 4	57-100
No. 10	40-100
No. 50	3-30
No. 100	0-4
No. 200	0-3.0

All percentages are by weight.

That portion of backfill retained on a No. 4 sieve shall contain not more than 0.05 percent by weight of wood waste.

9-03.13(1) Sand Drainage Blanket

Aggregate for the sand drainage blanket shall consist of granular material, free from wood, bark, or other extraneous material and shall meet the following requirements for grading:

Sieve Size	Percent Passing
2½″	90-100
No. 4	24-100
No. 10	14-100
No. 50	0-30
No. 100	0-7.0
No. 200	0-3.0

All percentages are by weight.

That portion of backfill retained on a No. 4 sieve shall contain not more than 0.05 percent by weight of wood waste.

9-03.14 Borrow

9-03.14(1) Gravel Borrow

Aggregate for gravel borrow shall consist of granular material, either naturally occurring or processed, and shall meet the following requirements for grading and quality:

Sieve Size	Percent Passing
4″	99-100
2″	75-100
No. 4	50-80
No. 40	30 max.
No. 200	7.0 max.
Sand Equivalent	50 min.

All percentages are by weight.

Ballast may be substituted for gravel borrow for embankment construction.

9-03.14(2) Select Borrow

Material for select borrow shall consist of granular material, either naturally occurring or processed, and shall meet the following requirements for grading and quality:

Sieve Size	Percent Passing
6″[1]	99-100
3″	75-100
No. 40	50 max.
No. 200	10.0 max.
Sand Equivalent	30 min.

All percentages are by weight.
[1]99 to 100 percent shall pass 4-inch-square sieve and 75 to 100 percent shall pass 2-inch sieve when select borrow is used in the top 2 feet of embankments or where Method C compaction is required.

9-03.14(3) Common Borrow

Material for common borrow shall consist of granular or nongranular soil and/or aggregate which is free of deleterious material. Deleterious material includes wood, organic waste, coal, charcoal, or any other extraneous or objectionable material. The material shall not contain more than 3 percent organic material by weight. The plasticity index shall be determined using test method AASHTO T 89 and AASHTO T 90.

The material shall meet one of the options in the soil plasticity table below.

Soil Plasticity Table			
Option	**Sieve**	**Percent Passing**	**Plasticity Index**
1	No. 200	0 - 12	N/A
2	No. 200	12.1 - 35	6 or Less
3	No. 200	Above 35	0

All percentages are by weight.

If requested by the Contractor, the plasticity index may be increased with the approval of the Engineer.

9-03.14(4) Gravel Borrow for Structural Earth Wall

All backfill material within the reinforced zone for structural earth walls shall consist of granular material, either naturally occurring or processed, and shall be free draining, free from organic or otherwise deleterious material. The material shall be substantially free of shale or other soft, poor durability particles, and shall not contain recycled materials, such as glass, shredded tires, concrete rubble, or asphaltic concrete rubble. The backfill material shall meet the following requirements for grading and quality:

Sieve Size	Geosynthetic Reinforcement percent Passing	Metallic Reinforcement percent Passing
4		99-100
2		75-100
1¼″	99-100	
1″	90-100	
No. 4	50-80	50-80
No. 40	30 max.	30 max.
No. 200	7.0 max.	7.0 max.
Sand Equivalent	50 min.	50 min.

All percentages are by weight

Property	Test Method	Geosynthetic Reinforcement Requirements	Metallic Reinforcement Requirements
Los Angeles Wear 500 rev.	AASHTO T 96	35 percent max.	35 percent max.
Degradation Factor	WSDOT T 113	15 min.	15 min.
Resistivity	WSDOT T 417		3,000 ohm-cm, min.
pH	WSDOT T 417	4.5 - 9	5 - 10
Chlorides	AASHTO T 291		100 ppm max.
Sulfates	AASHTO T 290		200 ppm max.

If the resistivity of the gravel borrow equals or exceeds 5,000 ohm-cm, the specified chloride and sulfate limits may be waived.

Wall backfill material satisfying these grading and property requirements shall be classified as nonaggressive.

9-03.15 Native Material for Trench Backfill

Trench backfill outside the roadway prism shall be excavated material free of wood waste, debris, clods or rocks greater than 6 inches in any dimension.

9-03.16 Vacant

9-03.17 Foundation Material Class A and Class B

Foundation material Class A and Class B shall conform to the following gradations:

Sieve Size	Percent Passing	
	Class A	Class B
2½″	98-100	95-100
2″	92-100	75-100
1½″	72-87	30-60
¾″	27-47	0-5
⅜″	3-14	
No. 4	0-5	

All percentages are by weight.

9-03.18 Foundation Material Class C

Foundation material Class C shall consist of clean bank run sand and gravel, free from dirt, roots, topsoil, and debris and contain not less than 35 percent retained on a No. 4 sieve and with all stones larger than 2 inches in the longest dimension removed.

9-03.19 Bank Run Gravel for Trench Backfill

Trench backfill material shall consist of aggregate for gravel base, as specified in Section 9-03.10, excepting however, that 100 percent of the material shall pass a 2½-inch screen.

9-03.20 Test Methods for Aggregates

The properties enumerated in these Specifications shall be determined in accordance with the following methods of test:

Title	Test Method
FOP for AASHTO R 90 for Standard Practice for Sampling Aggregates	FOP for AASHTO R 90
Organic Impurities in Fine Aggregates for Concrete	AASHTO T 21
Clay Lumps and Friable Particles in Aggregates	AASHTO T 112
Resistance to Degradation of Small Size Coarse Aggregate by Abrasion and Impact in the Los Angeles Machine	AASHTO T 96
Material Finer than 0.075mm (No. 200) Sieve in Mineral Aggregates by Washing	AASHTO T 11
FOP for AASHTO for Determining the percentage of Fracture in Coarse Aggregates	FOP for AASHTO T 335
FOP for WAQTC/AASHTO for Sieve Analysis of Fine and Coarse Aggregates	FOP for WAQTC T 27/T 11
FOP for AASHTO T 176 for Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test	FOP for AASHTO T 176
Method of Test for Determination of Degradation Value	WSDOT T 113
Particle Size Analysis of Soils	AASHTO T 88

9-03.21 Recycled Material

9-03.21(1) General Requirements

Hot Mix Asphalt (HMA), Concrete Rubble, Recycled Glass (glass cullet), and Steel Furnace Slag may be used as, or blended uniformly with, naturally occurring materials for aggregates. The final blended product and the recycled material component included in a blended product shall meet the specification requirements for the specified type of aggregate. The Contracting Agency may collect verification samples at any time. Blending of more than one type of recycled material into the naturally occurring materials requires approval of the Engineer prior to use.

Prior to incorporating recycled materials into the work or storage on the job site, the Contractor shall provide a certification on the source of the all recycled materials. Recycled materials obtained from the Contracting Agency's roadways will not require toxicity testing or certification for toxicity characteristics unless requested by the Engineer.

Recycled materials that are not from the Contracting Agency's roadways shall not be incorporated into the work or imported to the job site until the Contractor provides testing and certification for toxicity characteristics to the Engineer. The Contractor shall provide the following:

1. Identification of the recycled materials proposed for use.
2. Sampling documentation no older than 90 days from the date the recycled material is placed on the project. Documentation shall include a minimum of five samples tested for total lead content by EPA Method 6010. Total lead test results shall not exceed 250 ppm. Samples that exceed 100 ppm must then be prepared by EPA Method 1311, the Toxicity Characteristic Leaching Procedure (TCLP), where liquid extract is analyzed by EPA Method 6010B. The TCLP test must be below 5.0 ppm.
3. Certification that the recycled materials are not Washington State Dangerous Wastes per the Dangerous Waste Regulations, WAC 173-303.
4. Certification that the recycled materials are in conformance with the requirements of the *Standard Specifications* prior to delivery. The certification shall include the percent by weight of each recycled material.

9-03.21(1)A Reclaimed Asphalt Shingles

Reclaimed asphalt shingles shall be non-asbestos containing material (ACM) as defined in 40 CFR 61 Subpart M and tested in accordance with 40 CFR part 763, subpart E, appendix E, Section 1. The Contractor shall keep all ACM test results on file and provide copies to the Engineer when submitting a HMA mix design for approval in accordance with Section 5-04. The Contractor shall provide the testing and certification for toxicity characteristics in accordance with Section 9-03.21(1) prior to delivery and placement of the recycled asphalt shingles and use of the RAS in HMA.

9-03.21(1)B Recycled Asphalt Pavement

For recycled materials incorporating hot mix asphalt, the product supplier shall certify that the blended material does not exceed the Maximum Allowable percentage of hot mix asphalt shown in Section 9-03.21(1)E. For RAP that is not from the Contracting Agency's roadway, the Contractor shall provide the testing and certification for toxicity characteristics in accordance with Section 9-03.21(1) prior to delivery and placement of the RAP and use of the RAP in HMA.

9-03.21(1)C Recycled Concrete Aggregate

Recycled concrete aggregates are coarse and fine aggregates manufactured from hardened concrete mixtures.

Recycled concrete aggregate may be used as coarse aggregate or blended with coarse aggregate for Commercial Concrete, Class 3000 concrete, or Cement Concrete Pavement. Recycled concrete aggregate shall meet all of the requirements for coarse aggregate contained in Section 9-03.1(4) or 9-03.1(5). In addition to the requirements of Section 9-03.1(4) or 9-03.1(5), recycled concrete shall:

1. Contain an aggregated weight of less than 1 percent of adherent fines, vegetable matter, plastics, plaster, paper, gypsum board, metals, fabrics, wood, tile, glass, asphalt (bituminous) materials, brick, porcelain or other deleterious substance(s) not otherwise noted;
2. Be free of components such as chlorides and reactive materials that are detrimental to the concrete, unless mitigation measures are taken to prevent recurrence in the new concrete;
3. Have an absorption of less than 10 percent when tested in accordance with AASHTO T 85.
4. For Cement Concrete Pavement mix designs using recycled concrete aggregates, the Contractor shall submit evidence that ASR mitigating measures control expansion in accordance with Section 9-03.1(1).

Recycled concrete aggregate shall be in a saturated condition prior to mixing.

Recycled concrete, in any form, shall not be placed below the ordinary high water mark of any surface water of the State.

9-03.21(1)C1 Recycled Concrete Aggregate Approval and Acceptance

Recycled concrete aggregate shall be from either a Tier 1, Tier 2 or Tier 3 Reclamation Facility meeting the requirements below:

Tier 1	
Approval Requirements	Approval of the Reclamation Facility is not required nor is it required to be on the WSDOT Qualified Products List.
Acceptance Requirements	Certification of toxicity characteristics in accordance with Section 9-03.21(1). Field acceptance testing in accordance with Section 3-04.
Approved to provide the following Aggregate Materials:	
9-03.10 Aggregate for Gravel Base	
9-03.12(1)B Gravel Backfill for Foundations Class B	
9-03.12(2) Gravel Backfill for Walls	
9-03.12(3) Gravel Backfill for Pipe Zone Bedding	
9-03.14(1) Gravel Borrow	
9-03.14(2) Select Borrow	
9-03.14(2) Select Borrow (greater than 3 feet below subgrade and side slope)	
9-03.14(3) Common Borrow	
9-03.14(3) Common Borrow (greater than 3 feet below subgrade and side slope)	
9-03.17 Foundation Material Class A and Class B	
9-03.18 Foundation Material Class C	
9-03.19 Bank Run Gravel for Trench Backfill	

Tier 2: For WSDOT Recycled Concrete and WSDOT Return Concrete	
Approval Requirements	The Reclamation Facility shall be listed on the WSDOT Qualified Products List. The Reclamation Facility shall have a Quality Control Plan (QCP) in accordance with WSDOT QC 9 "Standard Practice for Approval of Reclamation Facilities of WSDOT Recycled Concrete and WSDOT Returned Concrete". The Reclamation Facility's QCP shall be submitted through the QPL Engineer and approved by the WSDOT State Materials Laboratory. Once accepted, any changes to the QCP will require a new QCP to be submitted for acceptance. Evaluation of aggregate source properties (LA Wear and Degradation) for the recycled concrete aggregate is not required.
Acceptance Requirements	Certification of toxicity characteristics in accordance with Section 9-03.21(1), required if requested. Field acceptance testing in accordance with Section 3-04 is required. Provide certification in accordance with WSDOT QC 9 for every lot. A lot shall be no larger than 10,000 tons.
Approved to provide the following Aggregate Materials:	
Tier 1 aggregate materials 9-03.1 Coarse Aggregate for Commercial Concrete, Concrete class 3000, or Cement Concrete Pavement 9-03.9(1) Ballast 9-03.9(2) Permeable Ballast 9-03.9(3) Crushed Surfacing 9-03.12(1)A Gravel Backfill for Foundations Class A	

Tier 3: For Recycled Concrete Aggregates from Stockpiles of Unknown Sources	
Approval Requirements	The Reclamation Facility shall be listed on the WSDOT Qualified Products List. The Reclamation Facility shall have a Quality Control Plan (QCP) in accordance with WSDOT QC 10 "Standard Practice for Approval of Reclamation Facilities of Recycled Concrete Aggregates from Stockpiles of Unknown Sources". The Reclamation Facility's QCP shall be submitted through the QPL Engineer and approved by the WSDOT State Materials Laboratory. Once accepted, any changes to the QCP will require a new QCP to be submitted for acceptance. Evaluation of aggregate source properties (LA Wear and Degradation) for the recycled concrete aggregate is required.
Acceptance Requirements	Certification of toxicity characteristics in accordance with Section 9-03.21(1) is required. Field acceptance testing in accordance with Section 3-04 is required. Provide certification in accordance with WSDOT QC 10 for every lot. A lot shall be no larger than 10,000 tons.
Approved to provide the following Aggregate Materials:	
Tier 1 aggregate materials 9-03.1 Coarse Aggregate for Commercial Concrete, Concrete class 3000, or Cement Concrete Pavement 9-03.9(1) Ballast 9-03.9(2) Permeable Ballast 9-03.9(3) Crushed Surfacing 9-03.12(1)A Gravel Backfill for Foundations Class A	

9-03.21(1)D Recycled Glass (glass cullet)

Glass Cullet shall meet the requirements of AASHTO M318 with the additional requirement that the glass cullet is limited to the maximum amounts set in Section 9-03.21(1)E for recycled glass. Prior to use the Contractor shall provide certification to the Engineer that the recycled glass meets the physical properties and deleterious substances requirements in AASHTO M318. The Contractor shall provide the testing and certification for toxicity characteristics in accordance with Section 9-03.21(1) prior to delivery and placement of the recycled glass and use of the recycled glass in other materials.

9-03.21(1)E Steel Slag

The Contractor shall provide to the Engineer the steel furnace slag blends that will be used in the final product prior to use. Recycled steel furnace slag shall not be placed below the ordinary high water mark of any water of the State. The Contractor shall provide the testing and certification for toxicity characteristics in accordance with Section 9-03.21(1) prior to delivery and placement of the steel slag and use of the steel slag in other materials.

9-03.21(1)F Table on Maximum Allowable percent (By Weight) of Recycled Material

Maximum Allowable percent (by weight) of Recycled Material					
		Recycled Asphalt Pavement	Recycled Concrete Aggregate	Recycled Glass (glass cullet)	Steel Slag
Fine Aggregate for Concrete	9-03.1(2)	0	0	0	0
Coarse Aggregates for Concrete	9-03.1(4)	0	0	0	0
Coarse Aggregate for Concrete Pavement	9-03.1(4)	0	100	0	0
Coarse Aggregate for Commercial Concrete and Class 3000 Concrete	9-03.1(4)	0	100	0	0
Aggregates for Hot Mix Asphalt	9-03.8	See 5-04.2	0	0	20
Ballast	9-03.9(1)	25	100	20	20
Permeable Ballast	9-03.9(2)	25	100	20	20
Crushed Surfacing	9-03.9(3)	25	100	20	20
Aggregate for Gravel Base	9-03.10	25	100	20	20
Gravel Backfill for Foundations – Class A	9-03.12(1)A	25	100	20	20
Gravel Backfill for Foundations – Class B	9-03.12(1)B	25	100	20	20
Gravel Backfill for Walls	9-03.12(2)	0	100	20	20
Gravel Backfill for Pipe Zone Bedding	9-03.12(3)	0	100	20	20
Gravel Backfill for Drains	9-03.12(4)	0	0	20	0
Gravel Backfill for Drywells	9-03.12(5)	0	0	20	0
Backfill for Sand Drains	9-03.13	0	0	20	0
Sand Drainage Blanket	9-03.13(1)	0	0	20	0
Gravel Borrow	9-03.14(1)	25	100	20	20
Select Borrow	9-03.14(2)	25	100	20	20
Select Borrow (greater than 3 feet below Subgrade and side slopes)	9-03.14(2)	100	100	20	20
Common Borrow	9-03.14(3)	25	100	20	20
Common Borrow (greater than 3 feet below Subgrade and side slopes)	9-03.14(3)	100	100	20	20
Foundation Material Class A and Class B	9-03.17	0	100	20	20
Foundation Material Class C	9-03.18	0	100	20	20
Bank Run Gravel for Trench Backfill	9-03.19	25	100	20	20

9-04 Joint Sealing Materials

9-04.1 Premolded Joint Fillers

9-04.1(1) Asphalt Filler for Contraction and Longitudinal Joints in Concrete Pavements

Premolded joint filler for use in contraction and longitudinal joints shall be ⅛ inch in thickness and shall consist of a suitable asphalt mastic encased in asphalt saturated paper or asphalt saturated felt. It shall be sufficiently rigid for easy installation in summer months and not too brittle for handling in cool weather. It shall meet the following test requirements:

> When a strip 2 inches wide and 24 inches long is freely supported 2 inches from each end and maintained at a temperature of 70°F, it shall support a weight of 100 grams placed at the center of the strip without deflecting downward from a horizontal position more than 2 inches within a period of 5 minutes.

9-04.1(2) Premolded Joint Filler for Expansion Joints

Premolded joint filler for use in expansion (through) joints shall conform to either AASHTO M213 Specifications for "Preformed Expansion Joint Fillers for Concrete Paving and Structural Construction", except that the requirement for water absorption is deleted, or ASTM D7174 Specifications for "Preformed Closed-Cell Polyolefin Expansion Joint Fillers for Concrete Paving and Structural Construction".

As an alternative to the above, a semi-rigid, non-extruding, resilient type, closed-cell polypropylene foam, preformed joint filler with the following physical properties as tested to ASTM D545 Standard Test Methods may be used.

Closed-Cell Polypropylene Foam Preformed Joint Filler		
Physical Property	**Requirement**	**Test Method**
Water Absorption	< 1.0%	ASTM D545
Compression Recovery	> 80%	ASTM D545
Extrusion	< 0.1 in.	ASTM D545
Density	> 3.5 lbs./cu.ft.	ASTM D545
Water Boil (1 hr.)	No expansion	ASTM D545
Hydrochloric Acid Boil (1 hr.)	No disintegration	ASTM D545
Heat Resistance °F	392˚F± 5˚F	ASTM D545

9-04.1(3) Vacant

9-04.1(4) Elastomeric Expansion Joint Seals

Premolded elastomeric expansion joint seals shall conform to the requirements of ASTM D2628 and shall be formed by an extrusion process with uniform dimensions and smooth exterior surfaces. The cross-section of the seal shall be shaped to allow adequate compressed width of the seal, as approved by the Engineer.

9-04.2 Joint Sealants

9-04.2(1) Hot Poured Joint Sealants

9-04.2(1)A Hot Poured Sealant

Hot poured sealant shall be sampled in accordance with ASTM D5167 and tested in accordance with ASTM D5329.

9-04.2(1)A1 Hot Poured Sealant for Cement Concrete Pavement

Hot poured sealant for cement concrete pavement shall meet the requirements of ASTM D6690 Type IV, except for the following:

1. The Cone Penetration at 25°C shall be 130 maximum.
2. The extension for the Bond, non-immersed, shall be 100 percent.

Hot poured sealant for cement concrete pavement is acceptable for installations in joints where cement concrete pavement abuts a bituminous pavement.

9-04.2(1)A2 Hot Poured Sealant for Bituminous Pavement

Hot poured sealant for bituminous pavement shall meet the requirements of ASTM D6690 Type I or Type II.

Hot poured sealant for bituminous pavement is acceptable for installations in joints where cement concrete pavement abuts a bituminous pavement.

9-04.2(1)B Sand Slurry for Bituminous Pavement

Sand slurry is mixture consisting of the following components measured by total weight:

1. Twenty percent CSS-1 emulsified asphalt,
2. Two percent portland cement or blended hydraulic cement, and
3. Seventy-eight percent fine aggregate meeting the requirements of Section 9-03.1(2)B Class 2. Fine aggregate may be damp (no free water).

9-04.2(1)C Polymer Modified Asphalt Mastic

Polymer modified asphalt mastic shall be prepackaged polymer modified asphalt binder and aggregate meeting the requirements of ASTM D8260.

9-04.2(2) Poured Rubber Joint Sealer

The physical properties of the joint sealer, when mixed in accordance with the manufacturer's recommendations, shall be as follows:

1. Color: Gray or black.

2.[1] Viscosity: Must be pourable and self-leveling at 50°F.

3.[1] Application Life: Not less than 3 hours at 72°F and 50 percent relative humidity.

4. Set to Touch: Not more than 24 hours at 72°F and 50 percent relative humidity.
5. Curing Time: Not more than 96 hours at 72°F and 50 percent relative humidity.
6. Non-Volatile Content: Not less than 92 percent.
7. Hardness Rating (Durometer "Shore A"): 5-35.
8. Resiliency: Not less than 80 percent.
9. Bond test methods shall be in accordance with ASTM D5329.

[1]Viscosity and application life may be waived providing the material is mixed and placed by a pump and mixer approved by the Engineer.

Suitable primer, if required by the manufacturer, shall be furnished with each joint sealer. The primer shall be suitable for brush or spray application at 50°F or higher and shall cure sufficiently at 50°F to pour the joint within 24 hours. It shall be considered as an integral part of the sealer system. Any failure of the sealer in the test described herein, attributable to the primer, shall be grounds for rejection or re-testing of the sealer.

9-04.2(3) Single-Component Polyurethane Sealant

Single-Component Polyurethane sealant shall conform to ASTM C920 Type S Grade NS Class 25 Use M or ASTM C920 Type S Grade NS Class 35 Use M.

Single-Component Polyurethane sealant shall be compatible with the closed cell foam backer rod. When required, compatibility characteristics of sealants in contact with backer rods shall be determined by Test Method ASTM C1087.

9-04.2(3)A Closed Cell Foam Backer Rod

Closed cell foam backer rod for use with polyurethane sealant shall conform to ASTM C1330 Type C.

9-04.3 Joint Mortar

Mortar for hand mortared joints shall conform to Section 9-20.4(3) and consist of one part portland cement or blended hydraulic cement, three parts fine sand, and sufficient water to allow proper workability.

Cement shall conform to the requirements of AASHTO M 85, Type I or Type II.

Sand shall conform to the requirements of AASHTO M 45.

Water shall conform to the requirements of Section 9-25.1.

9-04.4 Pipe Joint Gaskets

9-04.4(1) Rubber Gaskets for Concrete Pipes and Precast Manholes

Rubber gaskets for use in joints of concrete culvert or storm sewer pipe and precast manhole sections shall conform to the requirements of ASTM C443. Standard gaskets meeting the dimensions, tolerances, and physical requirements of ASTM C1619, Class C shall be used unless the plans require oil resistant gaskets meeting the dimensions, tolerances, and physical requirements of ASTM C1619, Class D.

9-04.4(2) Vacant

9-04.4(3) Gaskets for Aluminum or Steel Culvert or Storm Sewer Pipe

Rubber gaskets for use with metal culvert or storm sewer pipe shall be continuous closed cell, synthetic expanded rubber gaskets conforming to the requirements of ASTM D1056, Grade 2B3. Butyl rubber gaskets for use with metal culvert or storm sewer pipe shall conform to the applicable requirements of ASTM C990.

9-04.4(4) Rubber Gaskets for Aluminum or Steel Drain Pipe

Gaskets for metal drain pipe shall be self-adhering, butyl-based, scrim-supported type. The gaskets shall be as described in the Standard Plan when specified.

9-04.4(5) Protection and Storage

Rubber gasket material shall be stored in a clean, cool place, protected from sunlight and contaminants. They shall be protected from direct sunlight at all times except during actual installation. Pipes with gaskets affixed shall be installed in the line within 28 days.

9-04.5 Flexible Plastic Gaskets

The gasket material shall be produced from blends of refined hydrocarbon resins and plasticizing materials reinforced with inert mineral filler and shall contain no solvents. It shall not depend on oxidizing, evaporating, or chemical action for adhesive or cohesive strength. It shall be supplied in extruded rope form of such cross section and size as to adequately fill spaces between the precast sections.

The gasket material shall be protected by a suitable removable two-piece wrapper so designed as to permit removing one half, longitudinally, without disturbing the other. Its composition and properties shall conform to those set forth below.

	Test Method	Minimum	Maximum
Bitumen (Petroleum plastic content)	ASTM D4	50	70
Ash-inert Mineral Matter	AASHTO T 11	30	50
Penetration	ASTM D217		
32°F (300gm) 60 sec		75	
77°F (150gm) 5 sec		50	120
115°F (150gm) 5 sec			150
Softening Point	AASHTO T 53	320°F	
Specific Gravity at 77°F	ASTM D71	1.20	1.35
Weight per gallon, lb		10.0	11.3
Ductility at 77°F (cm)	ASTM D113	5.0	
Flash Point COC, F	ASTM D93 REV A	600	
Fire Point COC, F	AASHTO T 48	625	
Volatile Matter	ASTM D6		2.0

9-04.6 Expanded Polystyrene

Expanded polystyrene shall be of a cellular molded type with a density of 1.5 plus or minus 0.25 pounds per cubic foot.

9-04.7 Expanded Rubber

Closed cell expanded rubber joint filler shall conform to ASTM D1056, Grade No. 2B3.

9-04.8 Flexible Elastomeric Seals

Flexible elastomeric seals for PVC drain pipe and underdrain pipe shall conform to the requirements of ASTM D3212.

9-04.9 Solvent Cements

Solvent cements for PVC underdrain pipe shall conform to the requirements of ASTM D2564.

9-04.10 Butyl Rubber and Nitrile Rubber

Butyl rubber shall conform to ASTM D2000, M1 BA 610. If the Engineer determines that the area will be exposed to petroleum products, Nitrile rubber shall be used and shall conform to ASTM D2000, M1 BG 610.

9-04.11 Butyl Rubber Sealant

Butyl rubber sealant shall conform to ASTM C990.

9-04.12 External Sealing Band

External sealing band shall be Type III B conforming to ASTM C877.

9-05 Drainage Structures and Culverts

9-05.0 Acceptance and Approval of Drainage Structures, and Culverts

The Drainage Structure or Culvert may be selected from the Qualified Products List, or submitted using a Request for Approval of Materials (RAM) in accordance with Section 1-06.

Certain drainage materials may be accepted by the Engineer based on a modified acceptance criteria when materials are selected from the Qualified Products List (QPL). The modified acceptance criteria are defined in the QPL for each material.

9-05.1 Drain Pipe

9-05.1(1) Concrete Drain Pipe

Concrete drain pipe shall meet the requirements of ASTM C118, heavy-duty drainage pipe.

9-05.1(2) Zinc Coated (Galvanized) or Aluminum Coated (Aluminized) Corrugated Iron or Steel Drain Pipe

Zinc coated (galvanized) or aluminum coated (aluminized Type 2) corrugated iron or steel drain pipe shall meet the requirements of AASHTO M36. The steel sheet thickness shall be 0.064 inch for 6-inch diameter and larger drain pipe. Zinc coated steel shall meet the material requirements of AASHTO M218 (ASTM A929). Aluminum coated steel shall meet the material requirements of AASHTO M274 (ASTM A929).

9-05.1(2)A Coupling Bands

Coupling bands for zinc coated (galvanized) or aluminum coated (aluminized) corrugated iron or steel drain pipe shall meet the requirements of coupling bands for Type I pipe of AASHTO M36, except that bands using projections (dimples) shall not be permitted. The bands shall be fabricated of the same material as the pipe, and with the same metallic protective treatment as the pipe.

Acceptable coupling bands are the two piece helically corrugated band with nonreformed ends and integrally formed flanges and those bands meeting the requirements of Section 9-05.4(7).

9-05.1(3) Corrugated Aluminum Alloy Drain Pipe

Corrugated aluminum alloy drain pipe shall meet the requirements of AASHTO M 196, without perforations.

9-05.1(3)A Coupling Bands

Coupling bands for corrugated aluminum alloy drain pipe shall meet the requirements of coupling bands for Type I pipe of AASHTO M196, except that bands using projections (dimples) shall not be permitted. The bands shall be fabricated of the same material as the pipe.

Acceptable coupling bands are the two piece helically corrugated band with nonreformed ends and integrally formed flanges and those bands meeting the requirements of Section 9-05.5(5).

9-05.1(4) Vacant

9-05.1(5) PVC Drain Pipe, Couplings, and Fittings

PVC drain pipe, couplings, and fittings shall meet the requirements of AASHTO M 278. The maximum size pipe shall be 8 inches in diameter.

9-05.1(6) Corrugated Polyethylene Drain Pipe, Couplings, and Fittings (Up to 10 inch)

Corrugated polyethylene drain pipe, couplings, and fittings shall meet the requirements of AASHTO M252 type C (corrugated both inside and outside) or type S (corrugated outer wall and smooth inner liner). The maximum size pipe shall be 10 inches in diameter.

Corrugated polyethylene drain pipe manufacturers shall participate in the National Transportation Product Evaluation Program (NTPEP) work plan for HDPE (High Density Polyethylene) Thermoplastic Pipe and be listed on the NTPEP audit website displaying they are NTPEP compliant.

9-05.1(7) Corrugated Polyethylene Drain Pipe, Couplings, and Fittings (12 inch Through 60 inch)

Corrugated polyethylene drain pipe, couplings, and fittings 12 inch through 60 inch diameter maximum, shall meet the minimum requirements of AASHTO M 294 Type S or 12-inch through 24-inch diameter maximum shall meet the minimum requirements of AASHTO M294 Type C.

Corrugated polyethylene drain pipe manufacturers shall participate in the National Transportation Product Evaluation Program (NTPEP) work plan for HDPE (High Density Polyethylene) Thermoplastic Pipe and be listed on the NTPEP audit website displaying they are NTPEP compliant.

9-05.2 Underdrain Pipe

9-05.2(1) Vacant

9-05.2(2) Perforated Concrete Underdrain Pipe

Perforated concrete underdrain pipe shall meet the requirements of AASHTO M175, Type I, except the perforations shall be approximately ½ inch in diameter. Strength requirements shall be as shown in Table I of AASHTO M86.

9-05.2(3) Vacant

9-05.2(4) Zinc Coated (Galvanized) or Aluminum Coated (Aluminized) Corrugated Iron or Steel Underdrain Pipe

Zinc coated (galvanized) or aluminum coated (aluminized type 2) corrugated iron or steel underdrain pipe shall meet the fabrication requirements of AASHTO M36, except that perforations required in Class I, II, and III pipe may be located anywhere on the tangent of the corrugations provided the other perforation spacing requirements remain as specified. Zinc coated steel shall meet the material requirements of AASHTO M 218 (ASTM A929). Aluminum coated steel shall meet the material requirements of AASHTO M274 (ASTM A929).

The pipe may conform to any one of the Type III pipes specified in AASHTO M 36, and perforations in Class I, II, and III pipe may be drilled or punched. The sheet thickness shall be 0.064 inch for 6 inch and larger diameter underdrain pipe.

9-05.2(4)A Coupling Bands

Coupling bands for zinc coated (galvanized) or aluminum coated (aluminized) corrugated iron or steel underdrain pipe shall meet the requirements of coupling bands for Type III pipe of AASHTO M36. The bands shall be fabricated of the same material as the pipe and with the same metallic protective treatment as the pipe, if metallic bands are used.

Acceptable coupling bands are the two piece helically corrugated band with nonreformed ends and integrally formed flanges, universal bands (dimple bands), a smooth sleeve type coupler, and those bands meeting the requirements of Section 9-05.4(7). Smooth sleeve type couplers may be either plastic or steel suitable for holding the pipe firmly in alignment without the use of sealing compound or gaskets.

9-05.2(5) Perforated Corrugated Aluminum Alloy Underdrain Pipe

Perforated corrugated aluminum alloy underdrain pipe shall meet the requirements of AASHTO M196, except that the perforations may be located anywhere on the tangent of the corrugations providing the other perforation spacing requirements remain as specified.

9-05.2(5)A Coupling Bands

Coupling bands for corrugated aluminum alloy underdrain pipe shall meet the requirements of coupling bands for Type III pipe of AASHTO M196. The bands shall be fabricated of the same material of the pipe, if metallic bands are used.

Acceptable coupling bands are the two piece helically corrugated band with nonreformed ends and integrally formed flanges, universal bands (dimple bands), a smooth sleeve type coupler, and those bands meeting the requirements of Section 9-05.5(5). Smooth sleeve type couplers may be either plastic or aluminum alloy suitable for holding the pipe firmly in alignment without the use of sealing compound or gaskets.

9-05.2(6) Perforated PVC Underdrain Pipe

Perforated PVC underdrain pipe shall meet the requirements of AASHTO M278. The maximum size pipe shall be 8 inches in diameter.

9-05.2(7) Perforated Corrugated Polyethylene Underdrain Pipe (Up to 10 inch)

Perforated corrugated polyethylene underdrain pipe shall meet the requirements of AASHTO M252, Type CP or Type SP. Type CP shall be Type C pipe with Class 2 perforations and Type SP shall be Type S pipe with either Class 1 or Class 2 perforations. Additionally, Class 2 perforations shall be uniformly spaced along the length and circumference of the pipe. The maximum size pipe shall be 10-inch diameter.

Perforated corrugated polyethylene underdrain pipe manufacturers shall participate in the National Transportation Product Evaluation Program (NTPEP) work plan for HDPE (High Density Polyethylene) Thermoplastic Pipe and be listed on the NTPEP audit website displaying they are NTPEP compliant.

9-05.2(8) Perforated Corrugated Polyethylene Underdrain Pipe (12-Inch Through 60-Inch Diameter Maximum), Couplings, and Fittings

Perforated corrugated polyethylene underdrain pipe (12-inch through 60-inch diameter maximum), couplings, and fittings shall meet the requirements of AASHTO M294 Type CP or Type SP. Type CP shall be Type C pipe with Class 2 perforations and Type SP shall be Type S pipe with either Class 1 or Class 2 perforations. Additionally, Class 2 perforations shall be uniformly spaced along the length and circumference of the pipe.

Perforated corrugated polyethylene underdrain pipe manufacturers shall participate in the National Transportation Product Evaluation Program (NTPEP) work plan for HDPE (High Density Polyethylene) Thermoplastic Pipe and be listed on the NTPEP audit website displaying they are NTPEP compliant.

9-05.3 Concrete Culvert Pipe

9-05.3(1) Plain Concrete Culvert Pipe

Plain concrete culvert pipe shall be round and shall conform to the requirements of AASHTO M86, Class 2.

9-05.3(1)A End Design and Joints

All bell and spigot concrete culvert pipe shall be joined with rubber gaskets. The joints and gasket material shall meet the requirements of ASTM C990. Gasket material shall be handled and stored in accordance with Section 9-04.4(5).

The plane of the ends of the pipes shall be perpendicular to their longitudinal axes.

9-05.3(1)B Basis for Acceptance

The basis for acceptance of plain concrete culvert or drain pipe shall be on the results of three edge bearing tests performed at the manufacturer's plant within the 90 day period immediately preceding shipment of the pipe.

9-05.3(1)C Age at Shipment

Plain concrete culvert pipe may be shipped when it meets all test requirements. Unless it is tested and accepted at an earlier age, it shall not be considered ready for shipment sooner than 28 days after manufacture when made with Type II portland cement or blended hydraulic cement, nor sooner than 7 days when made with Type III portland cement.

9-05.3(2) Reinforced Concrete Culvert Pipe

Reinforced concrete culvert pipe shall be round and conform to the requirements of AASHTO M170 except as herein provided.

The wall thickness and steel area for all classes of pipe which are of a diameter not set forth in AASHTO M170, but within the maximum and minimum diameter limits set forth therein, shall be determined by interpolation from data given in the tables for pipes of diameters next smaller and next larger, respectively.

For all classes of pipe, except Class I, which are of a diameter less than the minimum for the particular class set forth in AASHTO M170, the minimum wall thickness shall be 1¾ inch and the steel area shall not be less than 0.06 square inch per linear foot of pipe barrel length.

9-05.3(2)A End Design and Joints

Section 9-05.3(1)A will apply to reinforced concrete culvert pipe.

9-05.3(2)B Basis for Acceptance

The basis for acceptance of reinforced concrete pipe 60 inches in diameter and smaller shall be determined by the results of the three edge bearing test for the load to produce a 0.01-inch crack, and testing to the ultimate load will ordinarily not be required, except as necessary to obtain samples for making the absorption test. In lieu of broken pieces of pipe obtained as above provided, 4-inch diameter cores from pipe sections selected by the Engineer may be furnished for performing the absorption test. Sections of pipe which have been tested to the actual 0.01-inch crack will ordinarily not be further load tested; and such sections which meet or exceed the required strength and workmanship standards may be accepted for use on the project.

Acceptance of reinforced concrete pipe larger than 60 inches in diameter shall be based on inspection of the size and placement of the reinforcing steel, and, at the option of the Engineer, on compressive strength tests of 4-inch diameter cores cut from the pipe, or on compressive strength of representative test cylinders cast with and cured with the pipe.

9-05.3(2)C Age at Shipment

Reinforced concrete culvert pipe may be shipped when it meets the requirements of Section 9-05.3(1)C.

9-05.3(2)D Elliptical Reinforcement

In lieu of marking circular pipe with elliptical reinforcement in accordance with AASHTO M170, the location of the top of the pipe shall be indicated by 3-inch, waterproof, painted stripes on the inside and outside of the pipe for a distance of 2 feet from each end of the section. At the option of the Contractor, a lift hole or lift holes may be provided at the top of the pipe in lieu of the painted stripes. If one lift hole is provided, it shall be at the balance point of the pipe; and if two lift holes are provided, they shall be spaced equidistant each side of the balance point. Such holes shall not interfere with the reinforcement. After placing, open lift holes shall be filled with mortar conforming to Section 9-20.4(3) or concrete plugs before backfilling.

In addition to the requirements as set forth in AASHTO M170, it will be required on all pipe 30 inches and over in diameter with elliptical steel reinforcement that the manufacturer expose the reinforcement in not less than one of three lengths of pipe manufactured. A hole exposing the steel shall be cut on the inside of the pipe at top or bottom and a second hole on the outside, 90 degrees from the top or bottom position. After placing, holes exposing the reinforcement shall be filled with mortar conforming to Section 9-20.4(3) or concrete plugs before backfilling.

9-05.3(3) Beveled Concrete End Sections

Beveled concrete end sections shall be plain concrete conforming to AASHTO M 86 or reinforced concrete conforming to the applicable sections of AASHTO M170 with the design requirements as listed in Table 2, Wall B, Circular Reinforcement in circular pipe, and the *Standard Plans*.

9-05.4 Steel Culvert Pipe and Pipe Arch

Steel culvert pipe and pipe arch shall meet the fabrication requirements of AASHTO M36, Type I and Type II. Zinc coated steel shall meet the material requirements of AASHTO M218 (ASTM A929). Aluminum coated steel shall meet the material requirements of AASHTO M274 (ASTM A929).

9-05.4(1) Elliptical Fabrication

When elongated pipes are specified, circular pipes shall be fabricated 5 percent out of round to form an elliptical section. The vertical or longer axis of the elliptical section shall be clearly marked before shipping.

9-05.4(2) Mitered Ends

The ends of steel culvert pipe or pipe arch shall not be beveled unless called for in the Plans. If beveled ends are specified, the ends of culvert pipe over 30 inches in diameter shall be mitered to conform to the slope of the embankment in which the culvert is to be placed whether the culvert is constructed normal to or at an angle with the centerline of the roadway.

Beveled steel pipe end sections 12 inches through 30 inches in diameter shall be of the same material and thickness and have the same protective coating as the pipe to which they are attached. Beveled pipe ends of these dimensions shall be constructed in conformance with the *Standard Plans*.

9-05.4(3) Protective Treatment

Steel pipe and pipe arch culverts shall be coated by one of the following protective treatments, when such treatment is specified:

Treatment 1	Coated uniformly inside and out with asphalt as per Section 9-05.4(4) (AASHTO M190 Type A) or with polymer as per Section 9-05.4(5).
Treatment 2	Coated uniformly inside and out with asphalt and with an asphalt paved invert (AASHTO M190 Type C) or with polymer as per Section 9-05.4(5).
Treatment 3	This treatment is no longer available.
Treatment 4	This treatment is no longer available.
Treatment 5	Coated inside and out with asphalt and a 100 percent periphery inside spun asphalt lining (AASHTO M 190 Type D).
Treatment 6	This treatment is no longer available.

9-05.4(4) Asphalt Coatings and Paved Inverts

Asphalt for asphalt coatings and paved inverts shall meet the requirements of AASHTO M190, Section 4. The coatings for Treatments 1, 2, and 5 shall be uniform, inside and out, and applied in accordance with the following requirements:

The metal shall be free from grease, dirt, dust, moisture, or other deleterious contaminants. Either process described below may be used for application.

1. **Pipe Not Preheated** – The temperature of the asphalt at the time of pipe immersion shall be 400°F (plus or minus 3 degrees), and the duration of the immersion shall conform to the following schedule:

Thickness in inches Steel	Minimum Immersion Time Minutes
0.064	2.5
0.079	3.0
0.109	5.0
0.138	6.5
0.168	8.0

2. **Pipe Preheated** – The asphalt shall have a temperature of 380°F (plus or minus 3 degrees), and the pipe shall be brought to a temperature of 300°F to 350°F before immersion.

   The paved invert for Treatment 2 shall consist of bituminous material applied in such a manner that one or more smooth pavements will be formed in the invert filling the corrugations for at least 40 percent of the circumference. The pavement shall have a minimum thickness of ⅛ inch above the crest of the corrugations except where the upper edges intercept the corrugation. The pavements shall be applied following the coating with asphalt. Treatment 5 may be substituted for Treatment 2, at the option of the Contractor.

9-05.4(5) Polymer Protective Coating

Polymer coated steel pipe and pipe-arch shall meet the fabrication requirements of AASHTO M36 (ASTM A760). Polymer protective coatings shall meet the material requirements of AASHTO M246 (ASTM A742). Polymer coating shall be mill applied to galvanized steel coils before fabrication and shall measure 10 mils thick on each side.

9-05.4(6) Spun Asphalt Lining

Asphalt for spun linings over 100 percent periphery shall conform to AASHTO M 190, Section 4. Asphalt spun linings shall provide a smooth surface for the full interior of the pipe by completely filling the corrugations to a minimum thickness of ⅛ inch above the crests. The interior lining shall be applied by centrifugal or other approved methods. The interior shall be free from sags or runs, but slight residual corrugations due to cooling shrinkage of the lining will not be cause for rejection. At the three sheet laps, an interior nonuniformity equal to the thickness of the sheet is allowable. The thickness of the lining shall be maintained to the ends of the pipe.

The thickness of the lining over the crest of the corrugation shall not vary by an amount in excess of ½ inch over the entire area of the spun lining.

In the case of helical corrugated pipe manufactured with a continuous lock seam, an interior nonuniformity over the lock seam equal to the thickness of two culvert sheets is allowable.

9-05.4(7) Coupling Bands

Coupling bands for steel pipe shall be as shown in the *Standard Plans* and shall be fabricated of the same material as the pipe. Bands may be up to three nominal thicknesses thinner than used for the pipe, but not thinner than 0.064 inches or thicker than 0.109 inches. Bands shall be coated with the same metallic protective treatment as the pipe but shall not be coated with any asphalt protective treatment. Bands shall be made by the same manufacturer as the steel pipe selected for installation.

Corrugations on the bands shall be the same size and shape as those on the pipes to be connected. Steel bolts and nuts for coupling bands shall meet the requirements of ASTM A307 and shall be galvanized in accordance with AASHTO M232. Steel angles, when required for coupling bands, shall meet the requirements of AASHTO M 36. When annular corrugated bands are used to connect helically corrugated lock-seam pipe, the seam shall be welded at the pipe ends prior to recorrugating to prevent unraveling of the seam. All welds shall develop the full strength of the parent metal.

Bands shall conform to the corrugations of the pipe and shall meet all applicable requirements of AASHTO M36, with the following exceptions:

Coupling bands for all sizes of steel pipe arch with 3 by 1-inch corrugations shall be 24 inches wide.

Type K coupling bands shall only be used on circular culvert pipe when extending an existing culvert. Rubber gaskets shall be used and shall conform to the requirements of Section 9-04.4(3), match the width of the band, and have a minimum thickness of 1 inch.

Type K coupling bands are allowed for use on all sizes of steel pipe arch with 3 by 1-inch corrugations. Type K bands for this application shall be 24 inches wide. Rubber gaskets shall be used and shall conform to the requirements of Section

9-04.4(3), match the width of the band, and have a minimum thickness of 1 inch. When Type K bands are used, pipe arch ends are not required to be recorrugated.

Gaskets are required for all culvert installations and shall meet the requirements of Section 9-05.10(1).

9-05.4(8) Steel Nestable Pipe

Steel nestable pipe shall meet the requirements for steel pipe of these Specifications except in the method of fabrication. Circular pipe shall be fabricated in two semicircles.

Nestable pipe may be either the stitch-type as hereinafter described or the flange-type in accordance with Military Designation MIL-P-236. One longitudinal edge of each half of the stitch-type nestable circular pipe shall be notched to provide interlocking seams which will form the two segments into the full section when it is erected in the field. Hook and eye bolts, or other approved means, shall be provided to hold the segments firmly together.

Individual plates shall be a minimum of 2 feet in length except for short or half sections required to complete the end section of the culvert.

When protective treatment is specified in the Plans, nestable pipe shall be coated with one of the treatments as provided in Section 9-05.4(3).

9-05.4(9) Steel End Sections

The applicable provisions of AASHTO M36 shall apply to the construction of steel end sections, except that the end sections shall be fabricated of the same material with the same metallic protective treatment as the pipe.

Asphalt coating shall not be used on steel end sections.

9-05.4(9)A Fabrication

The shape, thickness, dimensions, and number of pieces shall conform to the *Standard Plans* for the size and shape of pipe shown in the Plans. They shall be manufactured as integral units or so formed that they can be readily assembled and erected in place. When bolts are used for assembly, they shall be ⅜-inch diameter or larger and shall be galvanized. No field welding or riveting will be permitted.

9-05.4(9)B Galvanized Hardware

Bolts, nuts, and miscellaneous hardware shall be galvanized in accordance with the provisions of AASHTO M232.

9-05.4(9)C Toe Plate Extensions

Toe plate extensions shall be furnished only when so designated in the Plans. When required, the toe plate extensions shall be punched with holes to match those in the lip of the skirt and fastened with ⅜ inch or larger galvanized nuts and bolts. Toe plate extensions shall be the same material and thickness as the end section and shall be fabricated of the same material with the same metallic protective treatment as the end section.

9-05.5 Aluminum Culvert Pipe

Aluminum culvert pipe shall conform to the applicable requirements of AASHTO M 196M.

9-05.5(1) Elliptical Fabrication

Section 9-05.4(1) shall apply to aluminum pipes.

9-05.5(2) Mitered Ends

Section 9-05.4(2) shall apply to aluminum pipes.

9-05.5(3) Vacant

9-05.5(4) Vacant

9-05.5(5) Coupling Bands

Bands shall be fabricated of the same material as the pipe and shall meet all applicable requirements of AASHTO M196, except the band thickness shall not be more than 0.105 inches or less than 0.060 inches. All other requirements of Section 9-05.4(7) shall apply.

9-05.5(6) Aluminum End Sections

The applicable provisions of AASHTO M196 shall apply to the construction of end sections and toe plate extensions for aluminum pipes. In addition, they shall conform to the requirements of Section 9-05.4(9).

Asphalt coating shall not be used on aluminum end sections.

9-05.6 Structural Plate Pipes, Arches and Boxes

9-05.6(1) Steel Structural Plate Structures

Plates, metal bearings, flanges, members for structural reinforcement and fasteners for constructing steel structural plate pipes, arches and boxes shall conform to the requirements of AASHTO M167 (ASTM A761) or ASTM A1113.

9-05.6(2) Aluminum Structural Plate Structures

Plates, extrusions and fasteners for constructing aluminum structural plate pipes, arches and boxes shall conform to the requirements of AASHTO M219 (ASTM B746).

9-05.7 Concrete Storm Sewer Pipe

9-05.7(1) Plain Concrete Storm Sewer Pipe

Plain concrete storm sewer pipe shall conform to the requirements of AASHTO M 86, Class 2.

9-05.7(1)A Basis for Acceptance

The basis for acceptance of plain concrete storm sewer pipe shall be the same as specified in Section 9-05.3(1)B.

9-05.7(2) Reinforced Concrete Storm Sewer Pipe

Reinforced concrete storm sewer pipe shall conform to the requirements of AASHTO M170 and shall be of the class noted in the Plans or in the Special Provisions. Section 7.3.1 of AASHTO M170 shall be amended to require that both bells and spigots shall be reinforced in pipe 30 inches in diameter and greater.

The identification of the minor axis of elliptical reinforcement shall be in accordance with Section 9-05.3(2)D.

9-05.7(2)A Basis for Acceptance

The basis for acceptance of reinforced concrete storm sewer pipe shall be the same as specified in Section 9-05.3(2)B.

9-05.7(3) Concrete Storm Sewer Pipe Joints

All concrete storm sewer pipe shall be joined with rubber gaskets. The joints and gasket material shall meet the requirements of ASTM C990. Gasket material shall be handled and stored in accordance with Section 9-04.4(5).

9-05.7(4) Testing Concrete Storm Sewer Pipe Joints

When a particular type of pipe joint design, material or joining method has not previously been tested and approved, the following test shall be made on one test length of the assembled storm sewer pipe to qualify the design, material or method of joining the pipe. At the option of the Engineer, additional testing may be requested if subsequent field testing of installed pipe indicates difficulty in obtaining properly joined pipe. The tests will be conducted at the manufacturer's yard, and the manufacturer will be required to make such space and facilities available as required to conduct the tests in an efficient and workmanlike manner.

9-05.7(4)A Hydrostatic Pressure on Pipes in Straight Alignment

Hydrostatic pressure tests on pipes in straight alignment shall be made in accordance with the procedure outlined in Section 10 of ASTM C990, except that they shall be performed on an assembly consisting of not less than three nor more than five pipe sections selected from stock by the Engineer and assembled in accordance with standard installation instructions issued by the manufacturer. The end sections shall be bulkheaded and restrained against internal pressure.

9-05.7(4)B Hydrostatic Pressure Tests on Pipes in Maximum Deflected Position

Upon completion of the test for pipe in straight alignment, the test section shall be deflected until at least two of the joints have been deflected to the maximum amount shown in the manufacturer's standard installation instructions. When thus deflected, there shall be no leakage at the joints from an applied internal hydrostatic pressure of 5 psi.

9-05.7(4)C Hydrostatic Pressure Test on 15-Inch Diameter and Larger Pipe Under Differential Load

The test sections shall be suitably supported so that one of the pipes of the test assembly is suspended freely between adjacent pipes, bearing only on the joints. The suspended pipe shall then be loaded, at its midpoint, in addition to the mass of the pipe, in accordance with the following schedule:

Diameter	Load
15 inches	7,400 lbs.
18 inches	8,800 lbs.
21 inches	10,000 lbs.
24 inches and over	11,000 lbs.

While under this load, the stressed joints shall show no leakage when subjected to an internal hydrostatic pressure of 5 psi. At the option of the manufacturer, ½ of the load may be applied on the bell end of the suspended pipe in lieu of the full load on the center of the suspended pipe.

9-05.8 Vitrified Clay Sewer Pipe

This material shall not be used in Washington State Department of Transportation projects unless specified in the Special Provisions.

Vitrified clay sewer pipe shall conform to ASTM C700, and all joints shall be factory manufactured in accordance with ASTM C425.

9-05.9 Steel Spiral Rib Storm Sewer Pipe

Steel spiral rib storm sewer pipe shall meet the fabrication requirements of AASHTO M36 and these Specifications. Zinc coated steel shall meet the material requirements of AASHTO M218 (ASTM A929). Aluminum coated steel shall meet the material requirements of AASHTO M274 (ASTM A929). The size, coating, metal, and protective treatment, if any, shall be as shown in the Plans or in the Specifications.

The manufacturer of spiral rib storm sewer pipe shall furnish the Engineer a Manufacturer's Certificate of Compliance stating that the materials furnished comply in all respects with these Specifications. The Engineer may require additional information or tests to be performed by the Contractor at no expense to the Contracting Agency.

Unless otherwise specified, spiral rib storm sewer pipe shall be furnished with pipe ends cut perpendicular to the longitudinal axis of the pipe. Pipe ends shall be cut evenly. Spiral rib pipe shall be fabricated by using a continuous helical lock seam.

Spiral rib storm sewer pipe shall have helical ribs that project outwardly, be formed from a single thickness of material, and conform to one of the following configurations:

1. ¾-inch-wide by ¾-inch-deep ribs at 7½ inches on center.
2. ¾-inch-wide by 1-inch-deep ribs at 11½ inches on center.
3. ¾-inch-wide by ⅝-inch-deep ribs at 12 inches on center.

Pipe shall be fabricated with ends that can be effectively jointed with coupling bands. When it is required, spiral rib pipe shall be furnished with bituminous or polymer protective treatment 1 or 2 treated or paved. The bituminous treatment for spiral rib pipe shall conform to the requirements of Sections 9-05.4(3) and 9-05.4(4). Polymer coating shall conform to Section 9-05.4(5).

9-05.9(1) Continuous Lock Seam Pipe

Pipes fabricated with a continuous helical seam parallel to the rib may be used for full circle pipe. The seam shall be formed in the flat between ribs and shall conform to Sections 7.5.1 through 7.5.3 of AASHTO M36.

9-05.9(1)A Basis for Acceptance

The basis for acceptance will be a qualification test, conducted by the State Materials Laboratory, for each manufacturer of spiral rib lock seam steel pipe. Only those specific pipe sizes and gasket materials, if any, approved under the qualification test will be accepted.

Continuous lock seam pipe shall be sampled and tested in accordance with AASHTO T 249.

9-05.9(2) Vacant

9-05.9(3) Coupling Bands

Coupling bands shall be of the same material as the pipe. Coupling bands and gaskets shall conform to Section 9-05.10(1).

9-05.10 Steel Storm Sewer Pipe

Steel storm sewer pipe shall conform to the requirements of Section 9-05.4 for steel culvert pipe, except that protective coating shall be Treatment 1 or 5, and be constructed of helically corrugated lock seam pipe. When gasketed helically corrugated lock seam steel pipe is called for, and the pipe is properly sized to meet hydraulic requirements, Treatment 5 is not required.

9-05.10(1) Coupling Bands

Coupling bands shall be as shown in the *Standard Plans*. Bands shall be fabricated of the same material as the pipe and shall meet all applicable requirements of AASHTO M 36. Bands may be up to three nominal thicknesses thinner than used for the pipe, but not thinner than 0.064 inches or thicker than 0.109 inches. Bands shall be coated with the same metallic protective treatment as the pipe but shall not be coated with any asphalt treatment. Bands shall be made by the same manufacturer as the steel pipe selected for installation.

Corrugations on the bands shall be the same size and shape as those on the pipe to be connected. Steel bolts and nuts for coupling bands shall meet the requirements of ASTM A307 and shall be galvanized in accordance with AASHTO M232. Steel angles, when required for coupling bands, shall meet the requirements of AASHTO M36. When annular corrugated bands are used to connect helically corrugated lock-seam pipe, the seam shall be welded at the pipe ends prior to recorrugating to prevent unraveling of the seam. All welds shall develop the full strength of the parent metal.

Gaskets are required for all storm sewer installations. Gasket material for coupling bands shall meet the requirements of Section 9-04.4(3). Gaskets for Type D bands shall match the width of the band and have a minimum thickness of ⅜ inch. O-ring gaskets for Type F bands shall have a cross-sectional diameter of 13⁄16 inch for pipe diameters of 36 inches or smaller and ⅞ inch for larger pipe diameters.

Type K coupling bands are not allowed for storm sewer applications.

9-05.10(2) Basis for Acceptance

The basis for acceptance of steel storm sewer pipe will be the same as specified in Section 9-05.4, except when gasketed helically corrugated lock seam steel pipe is called for. A qualification test conducted by the State Materials Laboratory will be required for each manufacturer of gasketed helically corrugated lock seam steel pipe. Only those specific pipe sizes and gasket materials approved under the qualification test will be accepted.

9-05.11 Aluminum Storm Sewer Pipe

Aluminum storm sewer pipe shall conform to the requirements of Section 9-05.5 for aluminum culvert pipe, and the pipe shall be constructed of helically corrugated lock seam aluminum pipe.

9-05.11(1) Coupling Bands

Coupling bands for aluminum pipe shall be as shown in the *Standard Plans*. Bands shall be fabricated of the same material as the pipe and shall meet all applicable requirements of AASHTO M196, except the band thickness shall not be more than 0.105 inches or less than 0.060 inches. All other requirements of Section 9-05.10(1) shall apply.

9-05.11(2) Basis for Acceptance

The basis for acceptance of aluminum storm sewer pipe will be the same as specified in Section 9-05.0, except when gasketed helically corrugated lock seam aluminum pipe is called for. A qualification test, conducted by the State Materials Laboratory, will be required for each manufacturer of gasketed helically corrugated lock seam aluminum pipe. Only those specific pipe sizes and gasket materials approved under the qualification test will be accepted.

9-05.12 Polyvinyl Chloride (PVC) Pipe

9-05.12(1) Solid Wall PVC Culvert Pipe, Solid Wall PVC Storm Sewer Pipe, and Solid Wall PVC Sanitary Sewer Pipe

Solid wall PVC culvert pipe, solid wall PVC storm sewer pipe, and solid wall PVC sanitary sewer pipe and fittings shall be solid wall construction and shall conform to the following requirements:

For pipe sizes up to 15 inches: ASTM D3034 SDR 35

For pipe sizes from 18 to 48 inches: ASTM F679 using a minimum pipe stiffness of 46 psi in accordance with Table 1.

Joints for solid wall PVC pipe shall conform to ASTM D3212 using elastomeric gaskets conforming to ASTM F477.

Fittings for solid wall PVC pipe shall be injection molded, factory welded, or factory solvent cemented.

9-05.12(2) Profile Wall PVC Culvert Pipe, Profile Wall PVC Storm Sewer Pipe, and Profile Wall PVC Sanitary Sewer Pipe

Profile wall PVC culvert pipe and profile wall PVC storm sewer pipe shall meet the requirements of ASTM F794 Series 46, or ASTM F1803. Profile wall PVC sanitary sewer pipe shall meet the requirements of ASTM F794 Series 46, or ASTM F1803. The maximum pipe diameter shall be as specified in the Qualified Products List.

Joints for profile wall PVC culvert pipe shall conform to ASTM D3212 using elastomeric gaskets conforming to ASTM F477, or as approved through the State Materials Laboratory.

Qualified manufacturers are identified in the Qualified Products List. Qualification for each manufacturers requires joint system conformation to ASTM D3212 using elastomeric gaskets conforming to ASTM F477 and a formal quality control plan for each plant proposed for consideration.

A Manufacturer's Certificate of Compliance shall be required and shall accompany the materials delivered to the project. The certificate shall clearly identify production lots for all materials represented. The Contracting Agency may conduct verification tests of pipe stiffness or other properties as it deems appropriate.

Fittings for profile wall PVC pipe shall meet the requirements of ASTM F794 Series 46, or ASTM F1803.

9-05.13 Ductile Iron Sewer Pipe

Ductile iron pipe shall conform to ANSI A 21.51 or AWWA C151 and shall be cement mortar lined and have a 1-mil seal coat per AWWA C104 or a ceramic-filled, amine-cured Novalac Epoxy lining as indicated on the Plans or in the Special Provisions. The ductile iron pipe shall be Special Thickness Class 50, Minimum Pressure Class 350, or the Class indicated on the Plans or in the Special Provisions.

Nonrestrained joints shall be rubber gasket type, push on type, or mechanical type, and shall meet the requirements of AWWA C111.

Cast iron fittings may be used with ductile iron pipe. Saddles fastened to pipe with external bands shall not be acceptable on any new system. Normally, all fittings shall be the same material as the pipe being connected, except that fittings using other materials or constructed with more than one material may be used subject to the approval of the Engineer. Fittings shall have sufficient strength to withstand handling and load stresses normally encountered.

9-05.14 ABS Composite Sewer Pipe

This material shall not be used in Washington Department of Transportation projects unless specified in the Special Provisions.

ABS composite pipe shall meet the requirements of AASHTO M264.

ABS composite pipe shall be provided with Type OR (flexible gasketed) joints. Rubber gasketed joints shall conform to applicable provisions of ASTM C443.

Fittings for ABS composite pipe shall be specifically designed for connection to ABS composite pipe with solvent cement. Normally, all fittings shall be the same material as the pipe being connected, except that fittings using other materials or constructed with more than one material may be used subject to the approval of the Engineer. Fittings shall have sufficient strength to withstand handling and load stresses normally encountered.

9-05.15 Metal Castings

For all metal castings the producing foundry shall provide certification stating the country of origin, the material meets the required ASTM or AASHTO Specification noted in the Subsections below. The producing foundry shall detail all test results from physical testing to determine compliance to the Specifications. The test reports shall include physical properties of the material from each heat and shall include tensile, yield, and elongation as specified in the appropriate ASTM or AASHTO Specification. For AASHTO 1 M 306, Section 8, Certification is deleted and replaced with the above certification and testing requirements.

Metal castings for drainage structures shall not be dipped, painted, welded, plugged, or repaired. Porosity in metal castings for drainage structures shall be considered a workmanship defect subject to rejection by the Engineer. Metal castings made from gray iron or ductile iron shall conform to the requirements of AASHTO M306, and metal castings made from cast steel shall conform to the requirements of Section 9-06.8. All metal castings shall meet the proof load testing requirements of AASHTO M306.

9-05.15(1) Manhole Ring and Cover

Castings for manhole rings shall be gray iron or ductile iron and covers shall be ductile iron.

All covers shall be interchangeable within the dimensions shown in the *Standard Plans*. All mating surfaces shall be machine finished to ensure a nonrocking fit.

The inside vertical recessed face of the ring and the vertical outside edge of the cover shall be machined or manufactured to the following tolerances:

Ring	± 3⁄32 inch
Cover	± 3⁄32 inch

All manhole rings and covers shall be identified by the name or symbol of the producing foundry and country of casting origin. This identification shall be in a plainly visible location when the ring and cover are installed. Ductile iron shall be identified by the following, “DUC” or “DI”. The producing foundry and material identification shall be adjacent to each other and shall be minimum ½-inch to maximum 1-inch high letters, recessed to be flush with the adjacent surfaces.

9-05.15(2) Metal Frame, Grate, and Solid Metal Cover for Catch Basins or Inlets

Castings for metal frames for catch basins and inlets shall be cast steel, gray iron, or ductile iron, and as shown in the *Standard Plans*.

Castings for grates and solid metal covers for catch basins and inlets shall be cast steel or ductile iron and as shown in the *Standard Plans*. Additionally, leveling pads are allowed on grates and solid metal covers with a height not to exceed ⅛ inch. The producing foundry’s name and material designation shall be embossed on the top of the grate. The material shall be identified by the following: “CS” for cast steel or “DUC” or “DI” for ductile iron and shall be located near the producing foundry’s name.

Grates and covers shall be seated properly to prevent rocking, including the replacement of existing covers with solid metal covers. After seating, the frame and grate or frame and cover shall be maintained as a unit. Alternate designs are acceptable provided they conform to the manufacturer's shop drawings approved prior to Award of the Contract.

9-05.15(3) Cast Metal Inlets

The castings for cast metal inlets shall be cast steel or ductile iron, and as shown in the *Standard Plans*. Alternate plans are acceptable provided they conform to the fabricator's shop drawings approved prior to Award of Contract.

9-05.16 Grate Inlets and Drop Inlets

Steel in grates, angles, and anchors for grate inlets shall conform to ASTM A36, except structural tube shall conform to ASTM A500, Grade B, and structural shapes may conform to ASTM A992. After fabrication, the steel shall be galvanized in accordance with AASHTO M111, or galvanized with a hot-sprayed (plasma flame applied) 6 mil minimum thickness plasma coating.

Steel grating shall be fabricated by weld connections. Welds, welding procedures, and welding materials shall conform with the AWS D1.1/D1.1M, latest edition, Structural Welding Code.

Alternate grate designs will be permitted, with the approval of the Engineer, providing the hydraulic capacity is not decreased, the overall dimensions are the same allowing the grate to be interchangeable, and the strength is essentially equal to the grate shown in the *Standard Plans* or the Plans.

The Contractor has the option of furnishing either cast-in-place or precast inlets unless otherwise shown in the Plans. Alternate designs are acceptable provided they conform to the fabricator's shop drawings approved prior to Award of the Contract.

9-05.17 Aluminum Spiral Rib Storm Sewer Pipe

Aluminum spiral storm sewer pipe shall meet the fabrication requirements of AASHTO M196 and these Specifications. Aluminum alloy shall meet the material requirements of AASHTO M97 (ASTM B744). The size and corrugation shall be as shown in the Plans or in the Specifications. The size, metal, and protective treatment shall be as shown in the Plans or in the Specifications.

The manufacturer of spiral rib storm sewer pipe shall furnish to the Engineer a Manufacturer's Certificate of Compliance stating that the materials furnished comply in all respects with these Specifications. The Engineer may require additional information or tests to be performed by the Contractor at no expense to the Contracting Agency.

Unless otherwise specified, spiral rib storm sewer pipe shall be furnished with pipe ends cut perpendicular to the longitudinal axis of the pipe. Pipe ends shall be cut evenly. Spiral rib pipe shall be fabricated by using a continuous helical lock seam.

Spiral rib storm sewer pipe shall have helical ribs that project outwardly, be formed from a single thickness of material, and conform to one of the following configurations:

1. ¾-inch-wide by ¾-inch-deep ribs at 7½ inches on center.
2. ¾-inch-wide by 1-inch-deep ribs at 11½ inches on center.
3. ¾-inch-wide by ⅝-inch-deep ribs at 12 inches on center.

9-05.17(1) Continuous Lock Seam Pipe

Pipes fabricated with a continuous helical lock seam parallel to the rib may be used for full circle pipe. The lock seam shall be formed in the flat between ribs and shall conform to Sections 13.2.1 through 13.2.5 of AASHTO M196.

9-05.17(1)A Basis for Acceptance

The basis for acceptance will be a qualification test, conducted by the State Materials Laboratory, for each manufacturer of spiral rib lock seam pipe. Only those specific pipe sizes and gasket materials, if any, approved under the qualification test, will be accepted.

Continuous lock seam pipe shall be sampled and tested in accordance with AASHTO T 249.

9-05.17(2) Coupling Bands

Coupling bands shall be of the same material as the pipe. Coupling bands and gaskets shall conform to Section 9-05.10(1).

9-05.18 Safety Bars for Culvert Pipe

Steel pipe used as safety bars and steel pipe used as sockets shall conform to ASTM A53, Grade B. Steel tubing used as safety bars shall conform to ASTM A500, Grade B. Steel plate shall conform to ASTM A36. All parts shall be galvanized after fabrication in accordance with AASHTO M111.

9-05.19 Corrugated Polyethylene Culvert Pipe, Couplings, and Fittings

Corrugated polyethylene culvert pipe, couplings, and fittings shall meet the requirements of AASHTO M 294 Type S or D for pipe 12- to 60-inch diameter with silt-tight joints.

Corrugated polyethylene culvert pipe manufacturers shall participate in the National Transportation Product Evaluation Program (NTPEP) work plan for HDPE (High Density Polyethylene) Thermoplastic Pipe and be listed on the NTPEP audit website displaying they are NTPEP compliant.

Joints for corrugated polyethylene culvert pipe shall be made with either a bell/bell or bell and spigot coupling and shall incorporate the use of a gasket conforming to the requirements of ASTM D1056 Type 2 Class B Grade 3 or ASTM F477. All gaskets shall be factory installed on the coupling or on the pipe by the qualified manufacturer.

Qualification for each manufacturer of corrugated polyethylene culvert pipe requires an approved joint system and a formal quality control plan for each plant proposed for consideration.

A Manufacturer's Certificate of Compliance shall be required and shall accompany the materials delivered to the project. The certificate shall clearly identify production lots for all materials represented. The Contracting Agency may conduct verification tests of pipe stiffness or other properties as it deems appropriate.

9-05.20 Corrugated Polyethylene Storm Sewer Pipe, Couplings, and Fittings

Corrugated polyethylene storm sewer pipe, couplings, and fittings shall meet the requirements of AASHTO M294 Type S or D. The maximum pipe diameter for corrugated polyethylene storm sewer pipe shall be the diameter for which a manufacturer has submitted. Fittings shall be blow molded, rotational molded, or factory welded.

Corrugated polyethylene storm sewer pipe manufacturers shall participate in the National Transportation Product Evaluation Program (NTPEP) work plan for HDPE (High Density Polyethylene) Thermoplastic Pipe and be listed on the NTPEP audit website displaying they are NTPEP compliant.

All joints for corrugated polyethylene storm sewer pipe shall be made with a bell/bell or bell and spigot coupling and shall conform to ASTM D3212 using elastomeric gaskets conforming to ASTM F477. All gaskets shall be factory installed on the pipe in accordance with the manufacturer's recommendations.

Qualification for each manufacturer or corrugated polyethylene storm sewer pipe requires joint system conformance to ASTM D3212 using elastomeric gaskets conforming to ASTM F477 and a formal quality control plan for each plant proposed for consideration.

A Manufacturer's Certificate of Compliance shall be required and shall accompany the materials delivered to the project. The certificate shall clearly identify production lots for all materials represented. The Contracting Agency may conduct verification tests of pipe stiffness or other properties as it deems appropriate.

9-05.21 Steel Rib Reinforced Polyethylene Culvert Pipe

Steel rib reinforced polyethylene culvert pipe shall meet the requirements of ASTM F2562 Class 1 for steel reinforced thermoplastic ribbed pipe and fittings for pipe 24 to 60 inches in diameter with silt-tight joints.

Silt-tight joints for steel reinforced polyethylene culvert pipe shall be made with a bell/bell or bell and spigot coupling and shall incorporate the use of a gasket conforming to the requirements of ASTM F477. All gaskets shall be installed on the pipe by the manufacturer.

Qualification for each manufacturer of steel reinforced polyethylene culvert pipe requires an approved joint system and a formal quality control plan for each plant proposed for consideration.

A Manufacturer's Certificate of Compliance shall be required and shall accompany the materials delivered to the project. The certificate shall clearly identify production lots for all materials represented. The Contracting Agency may conduct verification tests of pipe stiffness or other properties as it deems appropriate.

9-05.22 Steel Rib Reinforced Polyethylene Storm Sewer Pipe

Steel rib reinforced polyethylene storm sewer pipe shall meet the requirements of ASTM F2562 Class 1 for steel reinforced thermoplastic ribbed pipe and fittings. The maximum diameter for steel reinforced polyethylene storm sewer pipe shall be the diameter for which a manufacturer has submitted a qualified joint. Qualified manufacturers and approved joints are listed in the Qualified Products List. Fittings shall be rotationally molded, injection molded, or factory welded.

All joints for steel reinforced polyethylene storm sewer pipe shall be made with a bell and spigot coupling and shall conform to ASTM D3212 using elastomeric gaskets conforming to ASTM F477. All gaskets shall be installed on the pipe by the manufacturer.

Qualification for each manufacturer of steel reinforced polyethylene storm sewer pipe requires joint system conformance to ASTM D3212 using elastomeric gaskets conforming to ASTM F477 and a formal quality control plan for each plant proposed for consideration.

A Manufacturer's Certificate of Compliance shall be required and shall accompany the materials delivered to the project. The certificate shall clearly identify production lots for all materials represented. The Contracting Agency may conduct verification tests of pipe stiffness or other properties it deems appropriate.

9-05.23 High-Density Polyethylene (HDPE) Pipe

HDPE pipe shall be manufactured from resins meeting the requirements of ASTM D3350 with a cell classification of 345464C and a Plastic Pipe Institute (PPI) designation of PE 4710.

The pipes shall have a minimum standard dimension ratio (SDR) of 32.5.

HDPE pipe shall be joined into a continuous length by an approved joining method.

The joints shall not create an increase in the outside diameter of the pipe. The joints shall be fused, snap together, or threaded. The joints shall be watertight, rubber gasketed if applicable, and pressure testable to the requirements of ASTM D3212.

Joints to be welded by butt fusion shall meet the requirements of ASTM F2620 and the manufacturer's recommendations. Fusion equipment used in the joining procedure shall be capable of meeting all conditions recommended by the pipe manufacturer, including, but not limited to, fusion temperature, alignment, and fusion pressure. All field welds shall be made with fusion equipment equipped with a Data Logger. Temperature, fusion pressure, and a graphic representation of the fusion cycle shall be part of the Quality Control records. Electro fusion may be used for field closures, as necessary. Joint strength shall be equal to or greater than the tensile strength of the pipe.

Fittings shall be manufactured from the same resins and cell classification as the pipe unless specified otherwise in the Plans or Specifications. Butt fusion fittings and Flanged or Mechanical joint adapters shall have a manufacturing standard of ASTM D3261. Electro fusion fittings shall have a manufacturing standard of ASTM F1055.

HDPE pipe to be used as liner pipe shall meet the requirements of AASHTO M326 and this specification.

The supplier shall furnish a Manufacturer's Certification of Compliance stating that the materials meet the requirements of ASTM D3350 with the correct cell classification with the physical properties listed above. The supplier shall certify that the dimensions meet the requirements of ASTM F714 or as indicated in this Specification or the Plans.

At the time of manufacture, each lot of pipes, liners, and fittings shall be inspected for defects and tested for Elevated Temperature Sustained Pressure in accordance with ASTM F714. The Contractor shall not install any pipe that is more than 2 years from the date of manufacture.

At the time of delivery, the pipe shall be homogeneous throughout, uniform in color, and free of cracks, holes, foreign materials, blisters, or deleterious faults.

Pipe shall be marked at 5-foot intervals or less with a coded number that identifies the manufacturer, SDR, size, material, machine, and date on which the pipe was manufactured.

9-05.24 Polypropylene Culvert Pipe, Polypropylene Storm Sewer Pipe, and Polypropylene Sanitary Sewer Pipe

All joints for polypropylene pipe shall be made with a bell/bell or bell and spigot coupling and shall conform to ASTM D3212 using elastomeric gaskets conforming to ASTM F477. All gaskets shall be factory installed on the pipe in accordance with the manufacturer's recommendations.

Qualification for each manufacturer of polypropylene storm sewer pipe requires joint system conformance to ASTM D3212 using elastomeric gaskets conforming to ASTM F477 and a formal quality control plan for each plant proposed for consideration.

A Manufacturer's Certificate of Compliance shall be required and shall accompany the materials delivered to the project. The certificate shall clearly identify production lots for all materials represented. The Contracting Agency may conduct verification tests of pipe stiffness or other properties it deems appropriate.

9-05.24(1) Polypropylene Culvert Pipe and Storm Sewer Pipe

Polypropylene culvert and storm sewer pipe shall conform to the following requirements:

1. For dual wall pipe sizes up to 60 inches: ASTM F2881 or AASHTO M 330, Type S or Type D.
2. For double or triple wall pipe sizes up to 60 inches: ASTM F2764.
3. Fittings shall be factory welded, injection molded or PVC.

9-05.24(2) Polypropylene Sanitary Sewer Pipe

Polypropylene sanitary sewer pipe shall conform to the following requirements:

1. For pipe sizes up to 60 inches: ASTM F2764.
2. Fittings shall be factory welded, injection molded or PVC.

9-05.30 Vacant

9-05.40 Vacant

9-05.50 Precast Concrete Drainage Structures

9-05.50(1) Fabrication Tolerances and Requirements

All precast concrete items shall meet the requirements of AASHTO M199, fabricated as shown on the Plans, and shall meet the tolerances and revisions as listed below.

1. The following information shall be legibly marked on each precast product (excluding rectangular and round adjustment sections). Marking shall be indented into the concrete, painted thereon with waterproof paint, or contained within a bar-coded sticker firmly attached to the product:
   a. fabricator name or trademark.
   b. date of manufacture.
2. Catch Basins (to include Type 1, Type 1L, and Type 1P), and Concrete Inlets:
   a. knock-out wall thickness, measured at thinnest point, 1½ to 2½ inches.
   b. knock-out diameter, 5 percent plus/minus allowance.
   c. base thickness, measured at thinnest point, 4 inches with ½-inch minus tolerance.
   d. all other dimensions as shown on Plans, 5 percent plus/minus allowance.
3. Catch Basin Type 2 and Manhole Type 1, 2, 3:
   a. knock-out diameter, 5 percent plus/minus allowance.
4. Flat Slab Tops:
   a. round or rectangular opening, 5 percent plus/minus allowance.

5. Rectangular or Circular Adjustment Sections:
   a. opening size or diameter, 5 percent plus/minus allowance.
6. Conical Sections:
   a. top opening diameter, 5 percent plus/minus allowance.
7. Grate Inlets:
   a. knock-out wall thickness, measured at thinnest point, 1½ to 2½ inches.
   b. knock-out diameter, 5 percent plus/minus allowance.
   c. opening size, 2½ percent plus/minus allowance.
8. Drop Inlets:
   a. knock-out diameter, 1 inch plus/minus allowance.

9-05.50(2) Manholes

Precast concrete manholes shall meet the requirements of AASHTO M199.

The joints may be the tongue and groove type or the shiplap type, sufficiently deep to prevent lateral displacement.

When secondary synthetic fiber reinforcement is used in 48-inch diameter by 3-foot high eccentric or concentric cone sections, the synthetic fiber shall meet the requirements of Section 9-05.50(9). A minimum of two hoops of W2 wire shall be placed in the 48-inch end of each cone. No steel is required in the remainder of the cone.

Precast manhole sections 48-inch diameter, with no knock-outs, may be produced using no steel reinforcement. As an alternate to conventional steel reinforcement, manufacturers shall use synthetic structural fibers meeting the requirements of Section 9-05.50(10).

9-05.50(3) Precast Concrete Catch Basins

Precast concrete catch basins shall conform to the requirements of Section 9-05.50(1), except that the dimensions shall be as set forth in the Plans.

When secondary synthetic fiber reinforcement is used to produce Type 1, Type 1L, and Type 1P Catch Basins, the synthetic fiber shall meet the requirements of Section 9-05.50(9). A minimum amount of steel reinforcement shall be used to reinforce the area around the knockouts. Steel reinforcing shall consist of a No. 3 horizontal hoop reinforcing bar located above the knockouts and a No. 3 vertical reinforcing bar in each corner, extending a minimum of 18 inches below the top surface of the catch basin.

Catch Basin Type 1 may be produced using structural synthetic fibers meeting the requirements of Section 9-05.50(10). Catch Basin Type 1 shall contain one hoop of No. 3 reinforcing bar around the top perimeter.

Knockouts or cutouts may be placed on all four sides and may be round or D-shaped.

9-05.50(4) Precast Concrete Inlets

Precast concrete inlets shall conform to the requirements of Section 9-05.50(1), except that the dimensions shall be as set forth in the Plans.

9-05.50(5) Precast Concrete Drywells

Precast concrete drywells shall meet the requirements of Section 9-05.50(1). Seepage port size and shape may vary per manufacturer. Each seepage port shall provide a minimum of 1 square inch and a maximum of 7 square inches for round openings and 15 square inches for rectangular openings. The ports shall be uniformly spaced with at least one port per 8 inches of drywell height and 15 inches of drywell circumference.

Precast Drywells may be produced using no steel reinforcement. As an alternate to conventional steel reinforcement, manufacturers shall use synthetic structural fibers meeting the requirements of Section 9-05.50(10).

9-05.50(6) Vacant

9-05.50(7) Vacant

9-05.50(8) Vacant

9-05.50(9) Synthetic Fibers for Precast Units

The synthetic fiber, either nylon multifilament fibers or polypropylene fibrillated fibers, shall meet the requirements of ASTM C1116, Section 4.1.3 3 and ICC ES AC 32, Sections 4.1.1 and 4.1.2. Synthetic fibers shall be added at a minimum dosage rate of 1.0 pound of nylon multifilament fibers per cubic yard of concrete or 1.5 pounds of polypropylene fibrillated fibers per cubic yard of concrete and shall be thoroughly mixed with the concrete before placement in the forms. The synthetic fibers shall be a minimum of 0.75 inches and a maximum of 2 inches in length.

9-05.50(10) Synthetic Structural Fibers for Precast Units

Synthetic fibers shall be monofilament or monofilament/fibrillated blend made of polyolefin, polypropylene, or polypropylene/polyethylene blend, meeting the requirements of ASTM C1116, Section 4.1.3, and ICC ES Acceptance Criteria 32, Sections 4.1.3 and 4.1.2. Additionally, the vendor or manufacturer must furnish an Engineering Report that provides test data in accordance with ASTM C1018 and/or ASTM C1399 from an ICC-qualified commercial laboratory relating to the specification requirements. The vendor or manufacturer shall provide a letter of certification stating compliance with specifications and/or standard codes.

The fibers shall be a minimum of 2 inches in length and have an aspect ratio (length divided by the equivalent diameter of the fiber) between 70 and 100 when the fibers are in their final phase.

The fibers shall have a minimum tensile strength of 50 ksi and a minimum modulus of elasticity of 600 ksi, when tested in accordance with ASTM D3822.

Precast drainage units shall have a minimum dosage rate of 3.75-lbs/cu yd. or more in order to obtain an Average Residual Strength (ARS) of 175 psi when tested in accordance with ASTM C1018 and/or ASTM C1399. The fiber supplier shall submit independent laboratory data to support ARS results.

9-06 Structural Steel and Related Materials

9-06.1 Structural Carbon Steel

Structural carbon steel shall conform to AASHTO M270, Grade 36, except as otherwise noted.

9-06.2 Structural Low Alloy Steel

Structural low alloy steel shall conform to AASHTO M 270, Grade 50 or 50W as specified in the Plans or Special Provisions, except as otherwise noted.

9-06.3 Structural High-Strength Steel

Structural high-strength steel shall be high yield strength, quenched, and tempered structural steel conforming to AASHTO M 270, Grades 70W, 100, or 100W as specified in the Plans or Special Provisions, except as otherwise noted.

9-06.4 Vacant

9-06.5 Bolts and Rods

9-06.5(1) Unfinished Bolts

Unfinished bolts (ordinary machine bolts) shall conform to the Specification requirements of ASTM A307 Grade A or B. Nuts shall comply with ASTM A563 Grade A requirements. Washers, unless otherwise specified, shall meet ASTM F844 Specifications.

The Contractor shall submit a Manufacturer's Certificate of Compliance for the bolts, nuts, and washers prior to installing any of them.

9-06.5(2) Vacant

9-06.5(3) High-Strength Bolts

High-strength bolts for structural steel joints shall conform to either ASTM F3125 Grade A325 Type 1 or 3 or ASTM F3125 Grade A490 Type 1 or 3, as specified in the Plans or Special Provisions. Tension control bolt assemblies, meeting all requirements of ASTM F3125 Grade F1852 may be substituted where Grade A325 high-strength bolts and associated hardware are specified.

When specified in the Plans or Special Provisions to be galvanized, tension control bolt assemblies shall be galvanized after fabrication in accordance with ASTM B695 Class 55 Type I.

Bolts conforming to ASTM F3125 Grade A490 shall not be galvanized.

Bolts for unpainted and nongalvanized structures shall conform to ASTM F3125 Grade A325 Type 3, ASTM F3125 Grade A490 Type 3, or ASTM F3125 Grade F1852 Type 3, as specified in the Plans or Special Provisions.

Nuts for high-strength bolts shall meet the following requirements:

ASTM F3125 Grade A325 Bolts

Type 1 (black)	ASTM A563 Grade C, C3, D, DH, and DH3 AASHTO M 292 Grade 2H
Type 3 (black weathering)	ASTM A563 Grade C3 and DH3
Type 1 (hot-dip galvanized)	ASTM A563 Grade DH AASHTO M 292 Grade 2H

ASTM F3125 Grade A490 Bolts

Type 1 (black)	ASTM A563 Grade DH and DH3 AASHTO M 292 Grade 2H
Type 3 (black weathering)	ASTM A563 Grade DH3

Nuts that are to be galvanized shall be tapped oversized the minimum required for proper assembly. The amount of overtap shall be such that the nut will assemble freely on the bolt in the coated condition and shall meet the mechanical requirements of ASTM A563 and the rotational capacity test specified in ASTM F3125.

Galvanized nuts shall be lubricated in accordance with ASTM A563 including supplementary requirement S2. Documentation shall include the name, method of application, and dilution of the lubricant applied to the nuts.

Washers for ASTM F3125 Grade A325 and Grade A490 bolts shall meet the requirements of ASTM F436 and may be circular, beveled, or extra thick, as required. The surface condition and weathering characteristics of the washers shall be the same as for the bolts being specified.

Direct Tension Indicators shall conform to the requirements of ASTM F959 and may be used with either ASTM F3125 Grade A325 or Grade A490 bolts. Direct tension indicators shall be galvanized by mechanical deposition in accordance with ASTM B695 class 55. Hot-dip galvanizing will not be allowed.

All bolts, nuts, and direct tension indicators shall be marked and identified as required in the pertinent Specifications.

Lock-pin and collar fasteners which meet the materials, manufacturing, and chemical composition requirements of ASTM F3125 Grade A325 or Grade A490, and which meet the mechanical property requirements of the same Specification in full size tests, and which have a body diameter and bearing areas under lock-pin head and collar not less than those provided by a bolt and nut of the same nominal size may be used. The Contractor shall submit a detailed installation procedure to the Engineer for approval. Approval from the Engineer to use a lock-pin and collar fasteners shall be received by the Contractor prior to use.

The Contractor shall provide Manufacturer's Certificate of Compliance for all bolts, nuts, washers, and load indicators. The Manufacturer's Certificate of Compliance shall include certified mill test reports and test reports performed on the finished bolt confirming that all of the materials provided meet the requirements of the applicable AASHTO or ASTM Specification. The documentation shall also include the name and address of the test laboratory, the date of testing, the lot identification of the bolts and nuts, and coating thickness for galvanized bolts and nuts. Shipping containers (not lids) shall be marked with the lot identification of the item contained therein.

Bolts shall be sampled prior to incorporating into a structure. For the purposes of selecting samples, a lot of bolts shall be the quantity of bolts of the same nominal diameter and same nominal length in a consignment shipped to the project site. The minimum number of samples from each lot shall be as follows:

Lot Size	Sample Size[1]
0 to 50	*
51 to 150	4
151 to 1,200	6
1,201 to 10,000	10
10,001 to 35,000	16
35,001 and over	24

*Manufacturer's Certificate of Compliance – samples not required.
[1]Nuts, washers, and load indicator devices, and tension control bolt assemblies or devices shall be sampled at the same frequency as the bolts.

All testing of bolts, nuts, washers, and load indicating devices shall be performed on specimens as they are to be installed.

All samples shall include a Manufacturer's Certificate of Compliance for each lot of bolts provided as defined in Section 1-06.3.

9-06.5(4) Anchor Bolts and Anchor Rods

Anchor bolts and anchor rods shall meet the requirements of ASTM F1554 and, unless otherwise specified, shall be Grade 105 and shall conform to Supplemental Requirements S2, S3, and S4.

Nuts for ASTM F1554 Grade 105 black anchor bolts and anchor rods shall conform to ASTM A563, Grade D or DH. Nuts for ASTM F1554 Grade 105 galvanized anchor bolts and anchor rods shall conform to either ASTM A563, Grade DH, or AASHTO M292, Grade 2H, and shall conform to the overtapping, lubrication, and rotational testing requirements in Section 9-06.5(3). Nuts for ASTM F1554 Grade 36 or 55 black or galvanized anchor bolts and anchor rods shall conform to ASTM A563, Grade A or DH. Washers shall conform to ASTM F436.

The bolts and rods shall be tested by the manufacturer in accordance with the requirements of the pertinent Specification and as specified in these Specifications. Anchor bolts, anchor rods, nuts, and washers shall be inspected prior to shipping to the project site. The Contractor shall submit to the Engineer for acceptance a Manufacturer's Certificate of Compliance for the anchor bolts, anchor rods, nuts, and washers, as defined in Section 1-06.3. If the Engineer deems it appropriate, the Contractor shall provide a sample of the anchor bolt, anchor rod, nut, and washer for testing.

All bolts, rods, nuts, and washers shall be marked and identified as required in the pertinent Specification.

9-06.6 Vacant

9-06.7 Vacant

9-06.8 Steel Castings

Steel castings shall conform to the requirements of AASHTO M 103, Mild to Medium Strength Carbon Steel Castings for General Application, grade 70-36, unless otherwise designated in the Plans or in the Special Provisions.

9-06.9 Gray Iron Castings

Gray iron castings shall conform to the requirements of AASHTO M 306. The class of castings to be furnished shall be that designated in the Plans or in the Special Provisions.

9-06.10 Malleable Iron Castings

Malleable iron castings shall conform to the requirements of ASTM A47.

9-06.11 Steel Forgings and Steel Shafting

Steel forgings shall conform to the requirements of AASHTO M 102. The classes of forgings to be furnished shall be those specified in the Plans or in the Special Provisions.

Steel shafting shall conform to the requirements of AASHTO M 169, Grade Designation 1016 to 1030 inclusive, unless otherwise specified.

9-06.12 Bronze Castings

Bronze castings shall conform to the requirements of ASTM B22, Bronze Castings for Bridges and Turntables.

9-06.13 Vacant

9-06.14 Ductile Iron Castings

Ductile iron castings shall conform to the requirements of ASTM A536, Grade 80-55-06, unless otherwise specified in the Plans or in the Special Provisions.

9-06.15 Welded Shear Connectors

Welded shear studs shall be made from cold drawn bar stock conforming to the requirements of AASHTO M 169. Grades 1010 through 1020, inclusive, either semi-killed or killed deoxidation.

The material shall conform to the following mechanical properties:

Tensile Strength	60,000 psi min.
Yield Strength	50,000 psi min.
Elongation	20 percent min.
Reduction of Area	50 percent min.

Mechanical properties shall be determined in accordance with AASHTO T 244.

At the manufacturer's option, mechanical properties of the studs shall be determined by testing either the steel after cold finishing, or the full diameter finished studs.

9-06.16 Roadside Sign Structures

All bolts, nuts, washers, cap screws, and coupling bolts shall conform to ASTM F3125 Grade A325 and Section 9-06.5(3), except as noted otherwise. All connecting hardware shall be galvanized after fabrication in accordance with AASHTO M 232.

Posts for single-post sign structures shall meet the requirements of ASTM A500 Grade B or ASTM A53 Grade B, Type E or S.

Posts for perforated square steel posts shall meet the requirements of ASTM A653 Grade 50. Perforated square steel posts shall be finished in accordance with ASTM A653 G90 Structural Quality Grade 50 or ASTM A653 G140.

Slip bases (SB1, SB2, and SB3) for perforated square steel posts shall conform to the following:

Plates	ASTM A572
Casting (SB3)	ASTM A536 Grade 65-45-12 and ASTM A153
Tubing	ASTM A500 Grade B
Angle Iron (SB1)	ASTM A36

Except as noted otherwise, the slip bases (SB1, SB2, and SB3) for perforated square steel posts shall be hot-dipped galvanized.

The heavy-duty anchor (lower sign post support) used for perforated square steel posts (ST-4) shall meet the requirements of ASTM A500 Grade B and shall be hot-dipped galvanized.

The bolts for connecting square steel posts to the upper slip plate SB-1, SB-2, or SB-3 shall be corner bolts and conform to ASTM F568 Class 4.6, zinc coated, shoulder flange bolts and conform to ASTM A29, zinc coated; or commercial bolts stock and conform to ASTM A307, zinc coated.

The bolts connecting perforated square steel posts to the lower sign post support (ST-2 or ST-4) shall conform to ASTM A307, Grade A and galvanized. The bolts connecting the lower slip plate (SB-1, SB-2, or SB-3) to the heavy-duty anchor (lower sign post support ST-4) shall conform to ASTM A307 and galvanized. The bolt stop for ST-2 and ST-4 shall conform to ASTM A307, Grade A and galvanized.

Wide flange steel or solid square steel posts for multiple-post sign structures shall conform to either ASTM A36 or ASTM A992. Posts conforming to either ASTM A588 or ASTM A572 Grade 50 may be used as an acceptable alternate to the ASTM A36 and ASTM A992 posts. All steel not otherwise specified shall conform to either ASTM A36 or ASTM A992.

Except as noted otherwise, all steel, including posts, base plates, and base stiffeners, shall be galvanized after fabrication in accordance with AASHTO M 111.

Base connectors for multiple directional steel breakaway posts shall conform to the following:

Brackets	Aluminum Alloy 6061 T-6
Bosses for Type TPB Brackets	ASTM A582
Anchor Ferrules	Type 304 stainless steel for threaded portion. AISI 1045 steel rod and AISI 1008 coil for cage portion

Anchor couplings for multiple directional steel breakaway posts shall conform to AMS 6378D with a tensile breaking strength range as follows:

Type TPA	17,000 to 21,000 lb
Type TPB	47,000 to 57,000 lb

For multi-directional breakaway base connectors, shims shall conform to ASTM A653, SS Grade 33, Coating Designation G 165.

9-06.17 Noise Barrier Wall Access Door

Access door frames shall be formed of 14-gauge steel to the size and dimensions shown in the Plans. The access door frame head and jamb members shall be mitered, securely welded, and ground smooth. Each head shall have two anchors and each jamb shall have three anchors. The hinges shall be reinforced with ¼-inch by 12-inch plate, width equal to the full inside width of the frame.

Access doors shall be full flush 1-¾-inch thick seamless doors with a polystyrene core. Door faces shall be constructed with smooth seamless 14-gauge roller-levered, cold-rolled steel sheet conforming to ASTM A 792 Type SS, Grade 33 minimum, Coating Designation AZ55 minimum. The vertical edges shall be neat interlocked hemmed edge seam. The top and bottom of the door shall be enclosed with 14-gauge channels. Mortise and reinforcement for locks and hinges shall be 10-gauge steel. Welded top cap shall be ground and filled for exterior applications. The bottom channel shall have weep holes.

Each access door shall have three hinges. Access door hinges shall be ASTM A 276 Type 316 stainless steel, 4-½-inches square, with stainless steel ball bearing and non-removable pins.

Each access door shall have two pull plates. The pull plates shall be ASTM A 240 Type 316 stainless steel, with a grip handle of one-inch diameter and 8 to 10-inches in length.

The door assembly shall be fabricated and assembled as a complete unit including all hardware specified prior to shipment.

9-06.18 Metal Bridge Railing

Metal bridge railing shall conform to the type and material Specifications set forth in the Plans and Special Provisions. Steel used for metal railings, when galvanized after fabrication in accordance with AASHTO M 111, shall have a controlled silicon content of either 0.00 to 0.06 percent or 0.15 to 0.25 percent. Mill test certificates verifying the silicon content of the steel shall be submitted to both the galvanizer and the Engineer prior to beginning galvanizing operations.

Section 8, part (b) of the Aluminum Association Standard Specifications for Aluminum Railing Posts Alloy A 344-T4 is hereby revised to provide that no X-ray inspection will be required after a foundry technique has been established for each mold which will ensure production of castings which are free from harmful defects. Inspection for approval of castings will be made by the Engineer after the finished castings have been anodized as noted in the Plans.

Welding of aluminum shall be in accordance with Section 9-28.14(3).

9-06.19 Strip Seal and Modular Expansion Joint System Components

9-06.19(1) Strip Seal Expansion Joint System Components

Metal components shall conform to ASTM A36, ASTM A992, ASTM A572 or ASTM A588.

Elastomeric joint seals shall conform to the following:

Property	Test Method	Range of Values
Hardness Durometer A	ASTM D2240	50 - 70
Tensile Strength	ASTM D412	2000 psi minimum
Elongation at break	ASTM D412	250% minimum
Compression set	ASTM D395	40% max at 70 hr at 212F
Oven Aging 70 hours	ASTM D573	
Tensile loss		20% maximum
Elongation loss		20% maximum
Change in hardness		10-points maximum
Oil Swell weight change	ASTM D471	45% max at 70 hr at 212F
Ozone Resistance	ASTM D1149	No cracks at 70 hr at 104F
Low Temperature Stiffening	ASTM D2240	0 to +15 points at 7 days at 14F

9-06.19(2) Modular Expansion Joint System Components

Structural steel shall conform to ASTM A36, ASTM A572 Grade 50, or ASTM A588. Aluminum components shall not be used.

Stainless steel shall conform to ASTM A240 Type 304.

Bolts and other hardware shall conform to the requirements of ASTM F3125 Grade A325 Type 1 or 2 and shall be galvanized in accordance with ASTM F2329 and Section 9-06.5(3).

PTFE shall conform to Section 9-31.8(2).

Expansion joint seals shall conform to the following:

Property	Test Method	Range of Values
Hardness Durometer A	ASTM D2240	50 - 70
Tensile Strength	ASTM D412	2000 psi minimum
Elongation at break	ASTM D412	250% minimum
Compression set	ASTM D395	40% max at 70 hr at 212F
Oven Aging 70 hours	ASTM D573	
Tensile loss		20% maximum
Elongation loss		20% maximum
Change in hardness		10-points maximum
Oil Swell weight change	ASTM D471	45% max at 70 hr at 212F
Ozone Resistance	ASTM D1149	No cracks at 70 hr at 104F
Low Temperature Stiffening	ASTM D2240	0 to +15 points at 7 days at 14F

The maximum size of each expansion joint strip seal shall be 3 inches. Box-type seals or seals utilizing double webs will not be acceptable. Seals shall be continuous without splices.

9-06.20 Vacant

9-06.21 Vacant

9-06.22 Bolts, Washers, and Other Hardware

Ordinary machine bolts and flat head bolts shall be made from commercial bolt stock meeting the Specifications of ASTM A307, and shall be grade A. Drift bolts and dowels may be either wrought iron or medium steel. Washers may be cast iron or malleable iron or may be cut from medium steel or wrought iron plate.

All bolts and other hardware which are to be galvanized and which require bending or shaping shall be hot forged to the required shape before galvanizing. Cold bending of such material will not be permitted because of the tendency toward embrittlement during the galvanizing process. Galvanizing shall be in accordance with AASHTO M 232.

Split rings for log cribbing of 4 inches inside diameter shall be manufactured from hot rolled, low carbon steel conforming to ASTM A711 AISI, Grade 1015. Each ring shall form a true circle with the principle axis of the cross section of the ring metal parallel to the geometric axis of the ring. The thickness of the metal section shall be 0.195 inch plus or minus 0.010 inch and the section shall be beveled from the central portion toward the edges to a thickness of 0.145 inch plus or minus 0.010 inch. It shall be cut through in one place in its circumference to form a tongue and slot. Split ring connectors shall be galvanized in accordance with AASHTO M 232.

Spike-grid timber connectors shall be manufactured according to ASTM A47 for malleable iron castings. They shall consist of four rows of opposing spikes forming a 4⅛-inch square grid with 16 teeth which are held in place by fillets which are diamond shaped in cross section.

Nails shall be round wire of standard form. Spikes shall be wire spikes or boat spikes, as specified in the Plans. Bolts, dowels, washers, and other hardware, including nails, shall be black or galvanized as specified in the Plans, but if not so specified shall be galvanized when used in treated timber structures.

9-07 Reinforcing Steel

9-07.1 General

9-07.1(1) Acceptance by Manufacturer's Certification

Reinforcing steel may be accepted by the Engineer based on the Manufacturer's Certificate of Compliance.

9-07.1(1)A Acceptance of Materials

Reinforcing steel rebar manufacturers shall comply with the National Transportation Product Evaluation Program (NTPEP) Work Plan for Reinforcing Steel (rebar) Manufacturers. Reinforcing steel rebar manufacturers shall participate in the NTPEP Audit Program for Reinforcing Steel (rebar) Manufacturers and be listed on the NTPEP audit program website displaying that they are NTPEP compliant.

Steel reinforcing bar manufacturers use either English or a Metric size designation while stamping rebar. The actual size of the bar, whether stamped with an English or a Metric size designation is acceptable. The Contract Plans and the *Standard Plans* will continue to use an English size designation. The table below shows the comparable reinforcing steel bar size designations in the both units of measure:

English Designation	Bar Diameter	Metric Designation
#3	(0.375 inches)	#10
#4	(0.500 inches)	#13
#5	(0.625 inches)	#16
#6	(0.750 inches)	#19
#7	(0.875 inches)	#22
#8	(1.000 inches)	#25
#9	(1.128 inches)	#29
#10	(1.270 inches)	#32
#11	(1.410 inches)	#36
#14	(1.690 inches)	#43
#18	(2.260 inches)	#57

9-07.1(2) Bending

Steel reinforcing bars shall be cut and bent cold to the shapes shown on the Plans. Fabrication tolerances shall be in accordance with ACI 315. The dimensions shown in the Plans are out-to-out unless shown otherwise. Hooks and bends of steel reinforcing bars shall be bent to the following inside diameters unless shown otherwise in the Plans:

Bar Size	Stirrups and Ties (in)	All Other Bars
No. 3	1½	6 bar diameters
No. 4	2	6 bar diameters
No. 5	2½	6 bar diameters
No. 6	4½	6 bar diameters
No. 7	5¼	6 bar diameters
No. 8	6	6 bar diameters
No. 9 through No. 11		8 bar diameters
No. 14 through No. 18		10 bar diameters

The supplementary requirements of AASHTO M31 for bend tests shall apply to size No. 14 and No. 18 steel reinforcing bars which have hooks or bends.

Hooked ends of steel reinforcing bars shall be standard hooks unless shown otherwise in the Plans. Standard hooks shall consist of a 90-, 135-, or 180-degree bend as shown in the Plans plus a minimum bar extension at the free end of the bar shown in the table below. Seismic hooks shall consist of a 135-degree bend plus a minimum bar extension at the free end of the bar shown in the table below.

Minimum Bar Extensions for Standard and Seismic Hooks					
	180° Hook	135° Hook		90° Hook	
Bar Size	All Bars	Seismic Hook	All Other Bars	Stirrups and Ties	All Other Bars
No. 3	2 ½″	3″	2¼″	2¼″	4½″
No. 4	2 ½″	3″	3″	3″	6″
No. 5	2 ½″	3¾″	3¾″	3¾″	7½″
No. 6	3″	4½″	4½″	9″	9″
No. 7	3½″	5¼″	5¼″	10½″	10½″
No. 8	4″	6″	6″	12″	12″
No. 9	4¾″				13¾″
No. 10	5¼″				15¼″
No. 11	5¾″				17″
No. 14	7″				20½″
No. 18	9¼″				27¼″

9-07.1(3) Lengths

Net length is the length of bar along the bar centerline from end to end. Net lengths of bent bars shown in the "LENGTH" column of the bar list in the Plans are rounded to the nearest inch.

9-07.1(4) Vacant

9-07.2 Deformed Steel Bars

Deformed steel bars for concrete reinforcement shall conform to either AASHTO M31 Grade 60 or ASTM A706 Grade 60, except as otherwise noted in this section or as shown in the Plans. Steel reinforcing bars for the cast-in-place components of bridge structures, and for precast substructure components of bridge structures, shall conform to ASTM A706 Grade 60 only.

Deformed steel bars are referred to in the Plans and Specifications by number: for example, No. 3, No. 4, No. 5, etc.

9-07.2(1) Headed Steel Reinforcing Bar

Headed steel reinforcing bars shall conform to Section 9-07.2 and ASTM A970, including Annex A1 requirements for Class HA head dimensions. Headed steel reinforcing bars shall be cold-swaged headed bars, forged headed bars or threaded headed bars.

9-07.3 Epoxy-Coated Steel Reinforcing Bars

Epoxy-coated rebar shall be coated according to ASTM A775 with the additional following modifications:

1. The list of steel reinforcing bars acceptable for coating shall include ASTM A706.
2. The Contractor shall furnish a written certification that properly identifies the material, the number of each batch of coating material used, quantity represented, date of manufacture, name and address of manufacturer, and a statement that the supplied coating material meets the requirements of ASTM A775.
3. Prior to coating the bars, the Contractor shall submit to the Engineer for review, the coating material manufacturer's recommendation on the proper use and application requirements of the coating material. For Pre-approved Epoxy Coating Facilities, this information will be available to the Fabrication Inspector upon request.
4. A certification stating that all bars have been coated in accordance with the coating material manufacturer's recommendations and these Specifications shall be furnished with each shipment. This certification shall include for each bar size the preheat temperatures, cure times, thickness checks, holidays detected, and test results. Two copies of these certifications shall be furnished to the Engineer.

5. The Contractor shall give advance notice to the Engineer of the coating schedule in the coating plant so that Contracting Agency inspection may be provided. The Engineer may inspect the coated bars at the coating plant for approval.
6. The patching material, compatible with the coating material and inert in concrete, shall be supplied with each shipment.
7. For projects where epoxy-coated steel reinforcing bars are used in the top mat of bridge decks only, the maximum amount of damage to the coating shall not exceed 0.25 percent of the surface area of each bar.
8. The thickness of epoxy coating shall be 10 mils plus or minus 2 mils.
9. Samples, when required, shall be shipped to the Washington State Department of Transportation, Materials Laboratory, 1655 South 2nd Avenue, Tumwater, WA 98504.

9-07.4 Plain Steel Bars

Where plain steel bars are specified, they shall conform to the chemical and physical properties of AASHTO M31, Grade 60, unless specifically noted otherwise. Plain steel bars are indicated in the Plans and Specifications by fractions of an inch; for example, ⅜ inch Ø, ½ inch Ø, ⅝ inch Ø, etc.

9-07.5 Dowel Bars (for Cement Concrete Pavement)

9-07.5(1) Dowel Bars for Cement Concrete Pavement Rehabilitation

Dowel bars for Cement Concrete Pavement Rehabilitation shall be 1½ inch outside diameter plain round steel bars or tubular bars 18 inches in length and meet the requirements of one of the following: dowel bar types:

1. Epoxy-coated dowel bars shall be round plain steel bars of the dimensions shown in the Standard Plans. They shall conform to AASHTO M31, Grade 60 or ASTM A615, Grade 60 and shall be coated in accordance with ASTM A1078 Type 2 coating, except that the bars may be cut to length after being coated. Cut ends shall be coated in accordance with ASTM A1078 with a patching material that is compatible with the coating, inert in concrete and recommended by the coating manufacturer. The thickness of the epoxy coating shall be 10 mils plus or minus 2 mils. The Contractor shall furnish a written certification that properly identifies the coating material, the number of each batch of coating material used, quantity represented, date of manufacture, name and address of manufacturer, and a statement that the supplied coating material meets the requirements of ASTM A1078 Type 2 coating. Patching material, compatible with the coating material and inert in concrete and recommended by the manufacturer shall be supplied with each shipment for field repairs by the Contractor.

2. ASTM A513 steel tubes made from Grade 60 Carbon Steel Tube with a 1.625 inch outside diameter and a 0.120 inch wall thickness. Both the inside and outside of the tube shall be zinc coated with G40 galvanizing in accordance with ASTM A653. Following zinc coating the tubes shall be coated in accordance with Section 9-07.5(1) item 1. The ends of the tube shall be capped to prevent intrusion of concrete or other materials.

9-07.5(2) Corrosion Resistant Dowel Bars (for Cement Concrete Pavement and Cement Concrete Pavement Rehabilitation)

Corrosion resistant dowel bars shall be 1½ inch outside diameter plain round steel bars or tubular bars 18 inches in length and meet the requirements of one of the following:

1. Stainless Steel Clad dowel bars shall have a minimum 0.06 inches clad to a plain steel inner bar meeting the chemical and physical properties of AASHTO M31, Grade 60, or AASHTO M255, Grade 60. Stainless Steel Clad shall meet the chemical properties of ASTM A276, Type 316L.
2. Stainless Steel Tube dowel bars shall have a minimum 0.06-inch-thick tube press-fitted onto a plain steel inner bar meeting the chemical and physical properties of AASHTO M31, Grade 60, or AASHTO M255, Grade 60. A lubricant/adhesive shall be used between the tube and the plain steel bar to fill any voids. Stainless Steel Tube material shall meet the chemical properties of ASTM A276, Type 316L.
3. Stainless Steel Solid dowel bars shall be ASTM A276, Type 316L.
4. Corrosion-resistant, low-carbon, chromium plain steel bars for concrete reinforcement meeting all the requirements of ASTM A 1035 Alloy Type CS Grade 100 or Alloy Type CS Grade 120.
5. Zinc Clad dowel bars shall be 1½ inch solid bars meeting the chemical and physical properties of AASHTO M 31, Grade 60 or AASHTO M 255, Grade 60 or ASTM A513 steel tubes made from Grade 60 carbon steel tube with a 1.625 inch outside diameter by 0.120 inch wall thickness. The bars shall have a minimum 0.035 inches A710 Zinc alloy clad to the plain steel inner bar or tube. A710 Zinc shall be composed of: zinc: 99.5 percent, by weight, minimum; copper: 0.1 – 0.25 percent, by weight; and iron: 0.0020 percent, by weight, maximum. Each end of tubular bars shall be plugged using a snug-fitting insert to prohibit any intrusion of concrete or other materials.
6. Multicoated fusion bonded epoxy bars shall consist of an ASTM A615 bar with alternating layers of ASTM A934 coating and an abrasion resistant overcoat (ARO). The ASTM A934 coating shall form the base and there shall be two layers of each coating material. The minimum thickness of the combined layers of the ASTM A934 coating and ARO coating shall be 20 mils. The ARO shall meet the following requirements:

Test	Method	Specification
Gouge Resistance	NACE TM0215, 30 kg wt., LS-1 bit @ 25°C	< 0.22 mm
Gouge Resistance	NACE TM0215, 50 kg wt., LS-1 bit @ 25°C	< 0.44 mm

7. ASTM A513 steel tubes made from Grade 60 Carbon Steel Tube with a 1.625 inch outside diameter and a 0.120 inch wall thickness. Both the inside and outside of the tube shall be zinc coated with G90 galvanizing in accordance with ASTM A653. Following zinc coating the tubes shall be coated in accordance with Section 9-07.5(1) item 1. The ends of the tube shall be capped to prevent intrusion of concrete or other materials.

The surface of the finished cut-to-length corrosion-resistant, low-carbon, chromium plain steel bars for concrete reinforcement meeting all the requirements of ASTM A1035 dowels shall be provided with a hot-rolled, as-rolled finish, including mill scale. The surface of all other finished cut-to-length dowels shall be provided with a smooth "ground" or "cold drawn" finish.

Stainless Steel Clad and Stainless Steel Tube Dowel bar ends shall be sealed with a patching material (primer and finish coat) used for patching epoxy-coated reinforcing steel as required in Section 9-07.3, item 6.

9-07.6 Tie Bars (for Cement Concrete Pavement)

Tie bars shall conform to the requirements of the *Standard Specifications* for Deformed Billet Steel Bars for Concrete Reinforcement, AASHTO M31, Grade 60 and shall be coated in accordance with ASTM A775 or corrosion-resistant, uncoated, low-carbon, chromium deformed steel bars for concrete reinforcement meeting all the requirements of ASTM A1035.

The form of the deformed bar shall be subject to approval by the Engineer.

Tie bars shall be free from dirt, grease, or other defects affecting the strength or bond with the concrete.

9-07.7 Welded Wire Reinforcement

Welded wire for concrete reinforcement shall meet the requirements of ASTM A1064, Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete. Welded wire reinforcement manufacturers shall participate in the NTPEP Audit Program for Reinforcing Steel (rebar) Manufacturers and shall be listed on the NTPEP audit program website displaying that they are NTPEP compliant.

9-07.8 Deformed Wire

Deformed wire shall conform to the requirements of AASHTO M336, Deformed Steel Wire for Concrete Reinforcement.

Deformed wire is noted in the Plans and Specifications by the letter D, followed by a number indicating the cross sectional area of the wire; for example, D2, D5, D20, etc.

9-07.9 Cold Drawn Wire

Cold drawn wire shall conform to the requirements of AASHTO M336, Cold Drawn Steel Wire for Concrete Reinforcement.

Cold drawn wire is noted in the Plans and Specifications by the letter W followed by a number indicating the cross sectional area of the wire; for example, W2, W5, W20, etc.

9-07.10 Prestressing Reinforcement Strand

Prestressing reinforcement shall be ½-inch diameter for precast-prestressed concrete piles and ½- or 0.6-inch diameter for pretensioned concrete girders, post-tensioned segmental precast concrete girders, or cast-in-place prestressed concrete.

Prestressing reinforcement shall be mill bright high tensile strength seven wire low relaxation strand conforming to the requirements of AASHTO M 203 (ASTM A416), Grade 270.

Each reel of prestressing reinforcement shall be accompanied by a Manufacturer's Certificate of Compliance, a mill certificate, and a test report. The mill certificate and test report shall include the yield and ultimate strengths, elongation at rupture, modulus of elasticity, and the stress strain curve for the actual prestress reinforcing intended for use. All values certified shall be based on test values and actual sectional areas of the material being certified.

For every five reels furnished, one sample, not less than 5½ feet long, shall be sent to the Engineer for testing. Samples of the furnished reels with Manufacturer's Certificate of Compliance, a mill certificate, and test report may be shipped directly by the manufacturer to the Engineer. An independent inspector, approved by the Contracting Agency, shall be present during sampling and shall provide a written certification to the Engineer.

9-07.11 Prestressing Reinforcement Bar

High-strength steel bars shall conform to AASHTO M275, Type II.

Nuts shall conform to either ASTM A29 Grade C1045, or ASTM A536 Grade 100-70-03, and shall be capable of developing the larger of either 100 percent of the minimum ultimate tensile strength (MUTS), or 95 percent of the actual ultimate tensile strength (AUTS), of the bar. The anchor nuts shall conform to the specified strength requirement while permitting a maximum 5 degree misalignment between the nut and the bearing plate. A minimum of three tests, each from a different heat, are required.

Couplers, if required, shall be AASHTO M169 Grade 1144, or equivalent steel, developing the larger of either 100 percent of the MUTS, or 95 percent of the AUTS, of the bar. The test shall be performed with the coupler having a one inch unengaged segment between the two coupled bars. A minimum of three tests, each from a different heat, are required.

For unbonded bars under dynamic loading, the connections shall withstand at least 500,000 cycles from 60 percent to 66 percent MUTS followed by at least 50 cycles between 40 percent MUTS and 80 percent MUTS. A minimum of three tests, each from a different heat, are required.

The Contractor shall supply a Manufacturer's Certificate of Compliance in accordance with Section 1-06.3 for each bar. The Contractor shall supply a Manufacturer's Certificate of Compliance in accordance with Section 1-06.3 for all nuts and couplers, confirming compliance with the specified strength requirement.

For each heat of steel for high-strength steel bar, the Contractor shall submit two samples, each not less than 5½ feet long, to the Engineer for testing.

9-08 Paints and Related Materials

9-08.1 Paint

9-08.1(1) Description

Paints used for highway and bridge structure applications shall be made from materials meeting the requirements of the applicable Federal and State Paint Specifications, Department of Defense (DOD), American Society on Testing of Materials (ASTM), and The Society for Protective Coatings specifications in effect at the time of manufacture. The colors, where designated, shall conform to Section 9-08.1(8).

9-08.1(2) Paint Types

9-08.1(2)A Vinyl Pretreatment

Vinyl pretreatment shall be a two-component basic zinc chromate-vinyl butyral wash primer conforming to DOD-P-15328 (Formula 117 for Metals) and SSPC Paint 27. Zinc chromate shall be the insoluble type. The paint shall be supplied as two components that are mixed together just prior to use.

9-08.1(2)B Galvanizing Repair Paint, High Zinc Dust Content

Galvanizing repair paint shall conform to Federal Specification MIL-P-21035B.

9-08.1(2)C Inorganic Zinc-Rich Primer, Shop Applied

Inorganic zinc-rich primer shall be a two-component, self-curing, inorganic zinc-rich paint, conforming to either AASHTO M300 or SSPC Paint 20 Type I.

9-08.1(2)D Vacant

9-08.1(2)E Epoxy Polyamide

Epoxy polyamide primer shall be a two-component system conforming to MIL-DTL-24441 or SSPC Coating Standard No. 42.

9-08.1(2)F Primer, Zinc-Rich, Single-Component, Moisture-Cured Polyurethane, Field Applied

Zinc-rich primer shall meet the following requirements:

Vehicle Type: Moisture-cured polyurethane.

Pigment Content: 80 percent minimum zinc by weight in dry film.

Volume Solids: 60 percent minimum.

Minimum wt./gal. 22.0 pounds.

9-08.1(2)G Intermediate and Stripe Coat, Single Component, Moisture-Cured Polyurethane

Vehicle Type: Moisture-cured polyurethane.

Pigment: A minimum of 3.0 lbs. of micaceous iron oxide per gallon.

Intermediate and any stripe coat shall meet the following requirements:

Minimum volume solids 50 percent.

A minimum of 3.0 lbs/gal. of micaceous iron oxide.

The intermediate coating shall be certified by the manufacturer to be able to be recoated by the top coat in a minimum of 4 days.

9-08.1(2)H Top Coat, Single-Component, Moisture-Cured Polyurethane

Vehicle Type: Moisture-cured aliphatic polyurethane.

Color and Gloss: Meet the SAE AMS Standard 595 Color as specified in the table below.

The Top Coat shall meet the following requirements

The resin shall be an aliphatic urethane.

Minimum-volume solids 50 percent.

The top coat shall be a gloss or semi-gloss.

Color	Semi-Gloss
Washington Gray	26357
Mt. Baker Gray	26134
Mt. St. Helens Gray	26306
Cascade Green	24158

9-08.1(2)I Rust-Penetrating Sealer

Rust-penetrating sealer shall be a two-component, chemically-cured, 100 percent solids epoxy.

9-08.1(2)J Black Enamel

The enamel shall conform to Federal Specification MIL PRF 24635E Type II Class 2.

9-08.1(2)K Orange Equipment Enamel

The enamel shall be an alkyd gloss enamel conforming to Federal Specification MIL-PRF-24635E Type II Class 1. The color, when dry, shall match that of SAE AMS Standard 595, color number 12246.

For factory application to individual items of new equipment, samples and testing of the enamel shall not be required; however, the equipment manufacturer shall match the color specified and shall certify the quality of enamel used.

9-08.1(2)L Exterior Acrylic Latex Paint-White

This paint shall conform to Federal Specification MIL-PRF-24635E Type II Class 1, 2 or 3.

This paint may be used self-primed in multiple coats over salts-treated wood and on interior and exterior masonry surfaces.

9-08.1(2)M NEPCOAT Qualified Products List A

Qualified products used shall be part of a NEPCOAT system supplied by the same manufacturer.

9-08.1(2)N NEPCOAT Qualified Products List B

Qualified products used shall be part of a NEPCOAT system supplied by the same manufacturer.

9-08.1(3) Working Properties

The paint shall contain no caked material that cannot be broken up readily by stirring. When applied to a clean vertical surface, the paint shall dry without running, streaking, or sagging.

9-08.1(4) Storage Properties

Paints manufactured under these Specifications shall show no skin over the surface after 48 hours in a partially filled container, when tested as outlined in Federal Test Method Standard No. 141. A slight amount of skin or gel formation where the surface of the paint meets the side of the container may be disregarded. Variable percentages of anti-skinning agents are shown in those formulas set forth above that are susceptible to undesirable skin formation. The manufacturer will be allowed to vary the amount of anti-skinning agent given in the formulas provided the above results are accomplished and provided the paint does not dry to a nonuniform or nonelastic film.

9-08.1(5) Fineness of Grinding

The paint shall be ground so that all particles of pigment will be dispersed and be coated with vehicle, and the residue on a 325 sieve will not exceed 1 percent by weight of the pigment. Paint shall be homogeneous, free of contaminant, and of a consistency suitable for use under intended application. Finished paint shall be well ground, and the pigment shall be properly dispersed in the vehicle, conforming to the requirements of the paint. Dispersion in the vehicle shall be such that the pigment does not settle excessively, does not cake or thicken in the container, and does not become granular or curdled.

9-08.1(6) Test Methods

Except as otherwise specified, all paints shall be sampled and tested in the ready-mixed form. The test methods shall be as specified in the WSDOT *Materials Manual* M 46-01 or the corresponding test method covered by Federal Test Method Standard No. 141 or as specified under AASHTO R 31.

9-08.1(7) Acceptance

For projects with moisture-cured polyurethane quantities less than 20 gallons, acceptance will be by the Manufacturer's Certificate of Compliance.

For projects with moisture-cured polyurethane quantities greater than 20 gallons, the product shall be listed in the current WSDOT Qualified Products List (QPL). If the lot number is listed on the QPL, it may be accepted without additional testing. If the lot number is not listed on the QPL, a 1 quart sample shall be submitted to the State Materials Laboratory for testing and acceptance.

For all other paint types, acceptance will be based on visual inspection.

9-08.1(8) Standard Colors

When paint is required to match a SAE AMS Standard 595 color, the paint manufacturer or the Contractor may obtain a sample of the required color through the following internet link: www.colorserver.net.

Unless otherwise specified, all top or finish coats shall be semi-gloss, with the paint falling within the range of 35 to 70 on the 60-degree gloss meter.

9-08.2 Powder Coating Materials for Coating Galvanized Surfaces

The powder coating system shall consist of two components: an epoxy primer coat and a polyester finish coat. The epoxy primer coat and the polyester finish coat materials shall be from the same manufacturer.

The epoxy primer coat shall be an epoxy powder primer conforming to the following requirements:

Property	Specification	Performance Requirement
Adhesion	ASTM D3359 Method B	5B (no failure)
Flexibility	ASTM D522 Method B	Pass ⅛″ mandrel bend
Pencil Hardness	ASTM D3363	H Plus
Specific Gravity	ASTM D792	1.25 minimum

The polyester finish coat shall conform to American Architectural Manufacturers Association (AAMA) Specification 2604.

Degassing additives may be added as necessary to prevent pin holes in the finish coat. The degassing additives shall be added in accordance with manufacturer's recommendations.

The color of the powder coating system polyester finish coat shall be as specified in the Plans or Special Provisions.

Repair materials shall be as recommended by the powder coating manufacturer and as specified in the Contractor's powder coating plan as accepted by the Engineer.

9-08.3 Concrete Surface Treatments

9-08.3(1) Pigmented Sealer Materials

The pigmented sealer shall be a semi-opaque, colored toner containing only methyl methacrylate-ethyl acrylate copolymer resins, toning pigments suspended in solution at all times by a chemical suspension agent, and solvent. Toning pigments shall be laminar silicates, titanium dioxide, and inorganic oxides only. There shall be no settling or color variation. Tinting shall occur at the factory at the time of manufacture and placement in containers, prior to initial shipment. Use of vegetable or marine oils, paraffin materials, stearates, or organic pigments in any part of coating formulation will not be permitted. The color of pigmented sealer shall be as specified by the Contracting Agency. The Contractor shall submit a 1-quart wet sample, a drawdown color sample, and spectrophotometer or colorimeter readings taken in accordance with ASTM D2244, for each batch and corresponding standard color card. The calculated Delta E shall not exceed 1.5 deviation from the Commission Internationale de l'Eclairage (CIELAB) when measured at 10 degrees Standard Observer and Illuminant D 65.

The 1-quart wet sample shall be submitted in the manufacturer's labeled container with product number, batch number, and size of batch. The companion drawdown color sample shall be labeled with the product number, batch number, and size of batch. The Contractor shall submit the specified samples and readings to the Engineer at least 14 calendar days prior to the scheduled application of the sealer. The Contractor shall not begin applying pigmented sealer until receiving the Engineer's written approval of the pigmented sealer color samples.

9-08.3(2) Exposed Aggregate Concrete Coatings and Sealers

9-08.3(2)A Retardant Coating

Retardant coating shall exhibit the following properties:

1. Retards the set of the surface mortar of the concrete without preventing the concrete to reach the specified 28 day compressive strength.
2. Leaves the aggregate with its original color and luster, and firmly embedded in the concrete matrix.
3. Allows the removal of the surface mortar in accordance with the methods specified in Section 6-02.3(14)E without the use of acidic washing compounds.
4. Allows for uniform removal of the surface mortar.

If the Contractor proposes use of a retardant coating that is not listed in the current WSDOT QPL, the Contractor shall submit a Type 2 Working Drawing consisting of a one quart product sample from a current lot along with supporting product information, Safety Data Sheet, and a Manufacturer's Certificate of Compliance stating that the product conforms to the above performance requirements.

9-08.3(2)B Clear Sealer

The sealer for concrete surfaces with exposed aggregate finish shall be a clear, non-gloss, penetrating sealer of either a silane, siloxane, or silicone based formulation.

9-08.3(3) Permeon Treatment

Permeon treatment shall be a product of known consistent performance in producing the SAE AMS Standard 595 Color No. 30219 target color hue established by WSDOT, either selected from the WSDOT Qualified Products List (QPL), or an equivalent product accepted by the Engineer. For acceptance of products not listed in the current WSDOT QPL, the Contractor shall submit Type 3 Working Drawings consisting of a one quart product sample from a current lot, supporting product information and a Safety Data Sheet.

9-08.4 Abrasive Blast Materials

9-08.4(1) Abrasive Blast Media

Material used for field abrasive blasting shall conform to Military Specification MIL-A-22262B(SH) as listed on QPL-22262-28 as maintained by the Department of the Navy. The Contractor shall provide the Engineer with certified test results from the abrasive blast media manufacturer showing that the abrasive blast material meets the Military Specification. The Contractor shall select the type and size of abrasive blast media to produce a roughened, sharp, angular surface profile conforming to the surface requirements specified by the manufacturer of the selected paint system.

9-08.4(2) Lead Abatement Additive

Lead abatement additive shall be a granular chemical abrasive additive consisting of a complex calcium silicate designed to stabilize lead through multiple mechanisms, including, but not limited to, pH adjustment, chemical reactions, and encapsulation. The additive shall be specifically designed and manufactured for lead paint abatement.

9-08.5 Surface Cleaning Materials

9-08.5(1) Bird Guano Treatment

Bird guano treatment shall consist of a 5.25 percent sodium hypochlorite solution.

9-08.5(2) Fungicide Treatment

Fungicide treatment shall consist of a 5.25 percent sodium hypochlorite solution.

9-08.5(3) Water

Water used for water jetting steel surface cleaning operations shall be clean, fresh water only, without any detergents, bleach, or any other cleaning agents or additives. Recycling of rinse water for water jetting operations is not allowed.

9-08.6 Filter Fabric

Filter fabric for water jetting operations shall be a polypropylene, nonwoven, needle-punched geosynthetic or equivalent material conforming to the following requirements:

Property	Specification	Performance Requirement
Grab Tensile Strength	ASTM D4632	100 pounds minimum
Apparent Opening Size	ASTM D4751	#70 sieve
Permittivity	ASTM D4491	1.0 sec-1 or better

9-08.7 Single-Component Polyurethane Sealant

Single-component polyurethane sealant shall conform to ASTM C920 Grade NS Class 25 or higher.

9-08.8 Foam Backer Rod

Foam backer rod shall be closed-cell expanded polyethylene or polyurethane foam.

9-09 Timber and Lumber

9-09.1 General Requirements

All timber and lumber shall be sized as indicated in the Plans.

All timber and lumber to be painted shall be surfaced on all sides. All timber and lumber to be painted shall be thoroughly air or kiln dried to an equilibrium moisture content and shall be stored in such a manner as to remain in a thoroughly dry condition until placed into the Work.

9-09.2 Grade Requirements

Timber and lumber shall conform to the grades and usage listed below.

Timber and lumber shall be marked with a certified lumber grade stamp provided by one of the following agencies:

West Coast Lumber Inspection Bureau (WCLIB),

Western Wood Products Association (WWPA),

Pacific Lumber Inspection Bureau (PLIB), or

Any lumber grading bureau certified by the American Lumber Standards Committee.

For structures, all material delivered to the project shall bear a grade stamp and have a grading certificate. The grade stamp and grading certificate shall not constitute final acceptance of the material. The Engineer may reject any or all of the timber or lumber that does not comply with the Specifications or has been damaged during shipping or upon delivery. The grading certificate shall be issued by either the grading bureau whose stamp is shown on the material, or by the lumber mill, which shall be under the supervision of one of the grading bureaus listed above. The certificate shall include the following:

Name of the mill performing the grading;

The grading rules being used;

Name of the person doing the grading, with current certification;

Signature of a responsible mill official;

Date the lumber was graded at the mill; and,

Grade, dimensions, and quantity of the timber or lumber

For Guardrail Posts and Blocks, Signposts, Mileposts, Sawed Fence Posts, and Mailbox Posts, the material delivered to the project shall either bear a grade stamp on each piece or have a grading certificate as defined above. The grade stamp or grading certificate shall not constitute final acceptance of the material. The Engineer may reject any or all of the timber or lumber that does not comply with the specifications or has been damaged during shipping or upon delivery.

9-09.2(1) Structures

All timber and lumber for structures shall be Douglas Fir-Larch unless specified otherwise in the contract, and shall conform to the following:

Materials 2″ to 4″ nominal thick, 5″ nominal and wider (Structural Joists and Planks)	No. 1 and better, grade (Section 123-b of WCLIB) or (Section 62.11 of WWPA)
Materials 5″ nominal and thicker (Beams and Stringers)	No. 1 and better, grade (Section 130-b of WCLIB) or (Section 70.11 of WWPA)

Timber lagging for soldier pile walls shall be Douglas Fir-Larch, grade No. 2 or better, or Hem-Fir No. 1.

When the material is delivered to the project, the Engineer will check the order for the appropriate grade stamp. The invoice and grading certificate accompanying the order must be accurate and complete with the information listed above. The grading certificate and grade markings shall not constitute final acceptance of the material. The Engineer may reject any or all of the timber or lumber that does not comply with the Specifications or has been damaged during shipping or upon delivery.

9-09.2(2) Guardrail Posts and Blocks.

Timber and lumber for guardrail posts and blocks (classified as Posts and Timbers) shall conform to the species and grades listed below:

Douglas Fir No. 1 and better, grade (Section 131-b WCLIB) or (Section 80.11 WWPA)

Hem Fir Select Structural, grade (Section 131-a WCLIB) or (Section 80.10 WWPA)

Southern Yellow Pine No. 1 and better, grade (Southern Pine Inspection Bureau)

When the material is delivered to the project, the Engineer will check the order for the appropriate grade stamp. The grade markings shall not constitute final acceptance of the material. The Engineer may reject any or all of the timber or lumber that does not comply with the Specifications or has been damaged during shipping or upon delivery.

9-09.2(3) Signposts, Mileposts, Sawed Fence Posts, and Mailbox Posts

The allowable species of timber and lumber for signposts and mileposts shall be Douglas Fir-Larch or Hem Fir. Timber and lumber for sawed fence posts and mailbox posts shall be Western Red Cedar, Douglas Fir-Larch, or Hem Fir.

Signposts, mileposts, sawed fence posts, and mailbox posts shall conform to the grades shown below:

4″ × 4″	Construction grade (Light Framing, Section 122-b WCLIB) or (Section 40.11 WWPA)
4″ × 6″	No. 1 and better, grade (Structural Joists and Planks, Section 123-b WCLIB) or (Section 62.11 WWPA)
6″ × 6″, 6″ × 8″, 8″ × 10″	No. 1 and better, grade (Posts and Timbers, Section 131-b WCLIB) or (Section 80.11 WWPA)
6″ × 10″, 6″ × 12″	No. 1 and better, grade (Beams and Stringers, Section 130-b WCLIB) or (Section 70.11 WWPA)

9-09.3 Preservative Treatment

9-09.3(1) General Requirements

All timber and lumber requiring preservative treatment shall be treated in accordance with AASHTO M133. As specified by AASHTO M133, the American Wood Protection Association (AWPA) standards shall govern the Specifications. These Specifications include: storing and curing the timber and lumber, the wood preservatives, the preservative treatment process, documenting the results of the treatment, inspection, testing, and the identification of properly treated timber. Unless otherwise specified in the Contract, all timber and lumber shall be treated in accordance with Sections U1 and T1 of the latest edition of the AWPA standards.

All cutting, boring, chamfering, routing, surfacing, and trimming shall be done prior to treating. Any field drilling or cutoffs shall be treated by two liberal applications of a compatible preservative. The applications shall be in accordance with the requirements of AWPA Standard M-4 entitled, “Standard for the Care of Pressured Treated Wood Products”.

All charges shall consist of pieces of the same species that are similar in form, size, moisture content, and receptivity to treatment. The pieces in the charge shall be separated to ensure contact of treating medium with all surfaces. The method of determining the retention of the preservatives shall be by assay.

All orders of treated timber and lumber shall be accompanied by a Certificate of Treatment showing conformance to this specification and AWPA standards record. The Certificate of Treatment shall include the following information:

Name and location of the wood preserving company,

Customer identification,

Date of treatment and charge number,

Type of chemical used and amount of retention,

Treating process and identification of the Specification used,

Boring records verifying treatment penetration for timber and lumber with a nominal dimension of 6" by 6" or larger,

Description of material that was treated, and

Signature of a responsible plant official.

All timber and lumber to be used in aquatic environments, unless specified otherwise in the Contract, shall be chemically treated using Western Wood Preservers Institute Best Management Practices (BMPs). The producer of the chemically treated products shall supply a written certification that the BMPs were utilized, including a description and appropriate documentation of the BMPs used. This information may be included on the Certificate of Treatment record.

9-10 Piling

9-10.1 Timber Piling

Timber piling shall be untreated or treated with the preservatives specified in the Plans and completely described in Section 9-09.3.

Timber piles shall have the following limiting diameters:

Length in Feet	Min. Butt Dia. 3 feet Above Butt in inches	Max. Butt Dia. 3 feet Above Butt in inches	Min. Tip Dia. in inches
Under 40	12	20	7
40 to 54	12	20	7
55 to 74	13	20	7
Over 74	14	20	7

Timber piles shall be strapped with at least three straps: one approximately 18 inches from the butt, one approximately 24 inches from the butt, and one approximately 12 inches from the tip. Additional straps shall be provided at approximately 15-foot centers between the butt and tip. Strapping shall encircle the pile once and be tensioned as tightly as possible. Straps shall be 1¼ inches wide, 0.31 inch thick, cold rolled, fully heat treated, high tensile strapping, painted, and waxed, with an ultimate tensile strength of 5,100 pounds. The seal shall be 2¼ inches long, 20 gage, crimped with a notch type sealer to furnish a joint yielding 80 percent of the strap tensile strength. Treated timber piles shall be strapped after treatment.

9-10.1(1) Untreated Piling

Except where specifically provided otherwise, untreated timber piling shall be Douglas Fir, Western Red Cedar, or Larch. Piling for foundations shall be Douglas Fir. Piling shall be cut from sound, live trees and shall contain no unsound knots. Sound knots will be permitted, provided the diameter of the knot does not exceed 4 inches, or ⅓ of the small diameter of the pile at the point where they occur, whichever is smaller. Any defect or combination of defects which will impair the strength of the pile more than the maximum allowable knot will not be permitted.

Piling shall be cut above the butt swell and shall have a uniform taper from butt to tip. A line drawn from the center of the tip to the center of the butt shall not fall outside the center of the pile at any point more than 1 percent of the length of the pile. A spiral grain or twist in excess of ¼ turn in 10 feet of length will be cause for rejection.

Untreated timber trestle piling shall have an average of at least five annual rings per inch measured radially over a distance of 3 inches at the butt, beginning at a point 3½ inches from the heart. At least 9 inches of heartwood shall show at the butt.

Ring count requirements for untreated timber foundation piling and detour trestle piling will be waived.

9-10.1(2) Creosote Treated Piling

For creosote treated piling, Douglas Fir timber shall be used. All other requirements shall be the same as for untreated piling, except that the ring count requirement will be waived.

9-10.1(3) Timber Composite Piling

Timber composite piling shall consist of a pile made up of two timber sections. The lower section shall be untreated, and the upper section shall be creosote treated.

The treated and untreated sections of timber composite pile shall meet the respective requirements specified above for full length of treated and untreated timber piling.

9-10.1(4) Peeling

Untreated and creosote treated piles shall be peeled by removing all of the rough bark and at least 80 percent of the inner bark. No strip of inner bark remaining on the pile shall be over ¾ inch wide or over 8 inches long, and there shall be at least 1 inch of clean wood surface between any two such strips. Not less than 80 percent of the surface on any circumference shall be clean wood. All knots shall be trimmed close to the body of the pile.

9-10.2 Concrete Piling

9-10.2(1) Concrete

The concrete for prestressed piles shall have a minimum compressive strength of 6,000 psi at the age of 28 days. The minimum compressive strength of concrete at the transfer of prestress shall be 3,300 psi.

The concrete for other precast piles shall be Class 4000. Mixing, transporting, and placing concrete shall be in accordance with the provisions of Section 6-02.3.

The Contractor shall mold and test a sufficient number of concrete test cylinders to determine the strength of the concrete as required by the Specifications. Under the surveillance of the Engineer, the test cylinders shall be molded, cured, and tested in accordance with the procedures established by the State Materials Laboratory.

In the event that a sufficient number of concrete test cylinders are not molded to satisfy all testing required on any one pile, cores measuring 4 inches in diameter by 5 inches in height shall be taken and tested by the Contractor. If the strength of the core meets the required compressive strength of the concrete, the pile may be accepted. The coring and testing of the core shall be done under the surveillance of the Engineer.

9-10.2(2) Reinforcement

Reinforcement shall meet the requirements of Section 9-07.

9-10.3 Cast-In-Place Concrete Piling

Reinforcement for cast-in-place concrete piles shall conform to Section 9-07.2.

9-10.4 Steel Pile Tips and Shoes

Steel pile tips and shoes shall be fabricated of cast steel conforming to ASTM A148 Grade 90-60 [620-415] or ASTM A27 Grade 65-35 [450-240] and be free from any obvious defects. Pile tips shall be accompanied by a mill test report stating the chemical and physical properties (tensile and yield) of the steel.

9-10.5 Steel Piling

The material for rolled steel piling H-piling and pile splices shall conform to ASTM A36, ASTM A572 or ASTM A992. The material for steel pipe piling and splices shall conform to one of the following requirements except as specifically noted in the plans:

1. API 5L Grade X42 or X52 material may be used for longitudinal seam welded or helical (spiral) seam submerged-arc welded pipe piles of any diameter.
2. ASTM A252, Grade 2 or 3 material may be used for longitudinal seam welded or helical (spiral) seam submerged-arc welded pipe piles of any diameter. For the purposes of welding and prequalification of base metal, steel pipe pile designated as ASTM A252 may be treated as prequalified provided the chemical composition conforms to a prequalified base metal classification listed in Table 3.1 of the AWS D1.1/D1.1M, latest edition, Structural Welding Code, the grade of pipe piling meets or exceeds the grade specified in the Plans, and the carbon equivalent (CE) is a maximum of 0.45-percent.
3. ASTM A572 or ASTM A588 material may be used for longitudinal seam welded piles of any diameter.

For helical (spiral) seam submerged-arc welded pipe piles, the maximum radial offset of strip/plate edges shall be ⅛ inch. The offset shall be transitioned with a taper weld and the slope shall not be less than a 1 in 2.5 taper. The weld reinforcement shall not be greater than 3⁄16 inches and misalignment of weld beads shall not exceed ⅛ inch.

Steel soldier piles, and associated steel bars and plates, shall conform to ASTM A36, ASTM A572 or ASTM A992, except as otherwise noted in the Plans.

All steel piling may be accepted by the Engineer based on the Manufacturer's Certification of Compliance submitted in accordance with Section 1-06.3. The manufacturer's certificate of compliance submittal for steel pipe piles shall be accompanied by certified mill test reports, including chemical analysis and carbon equivalence, for each heat of steel used to fabricate the steel pipe piling.

9-11 Waterproof Membrane

9-11.1 Asphalt for Waterproofing

Waterproof membrane shall be a sheet membrane conforming to ASTM D 6153 Type III, the puncture capacity specified below, and either the thin polymer sheet tensile stress or the geotextile and fabric grab tensile strength specified below:

Performance Properties	Test Method	Specification Requirements
Tensile Stress (for Thin Polymer Sheets)	ASTM D 882	75 pounds per inch min.
Grab Tensile Strength (for Geotextiles and Fabrics)	ASTM D 4632 (Woven or Nonwoven)	200 pounds min.
Puncture Capacity (For Thin Polymer Sheets, Geotextiles and Fabrics)	ASTM E 154	200 pounds min.

Waterproofing membrane will be accepted based on a Manufacturer's Certificate of Compliance with each lot of waterproof membrane.

9-11.2 Primer for Waterproof Membrane

The primer for the waterproof membrane shall be appropriate for bonding the sheet membrane to the bridge deck surface and shall be compatible with the membrane in accordance with the waterproof membrane manufacturer's recommendations.

9-12 Masonry Units

9-12.1 Concrete Blocks

Concrete blocks for manholes and catch basins shall conform to the requirements of ASTM C139.

Concrete blocks for building construction shall conform to the requirements of ASTM C90.

9-12.2 Concrete Brick

Concrete brick shall conform to the requirements of ASTM C55.

9-13 Riprap, Quarry Spalls, Slope Protection, and Rock for Erosion and Scour Protection and Rock Walls

9-13.1 Riprap and Quarry Spalls

9-13.1(1) General

Riprap and quarry spalls shall consist of broken stone or broken concrete rubble and shall be free of rock fines, soil, or other extraneous material. Concrete rubble shall not be contaminated by foreign materials such as fibers, wood, steel, asphalt, sealant, soil, plastic and other contaminants or deleterious material. Concrete rubble that is imported to the job site will require testing and certification for toxicity characteristics per Section 9-03.21(1).

The grading of the riprap shall be determined by the Engineer by visual inspection of the load before it is dumped into place, or, if so ordered by the Engineer, by dumping individual loads on a flat surface and sorting and measuring the individual rocks contained in the load. Should the riprap contain insufficient spalls, as defined in Section 9-13.1(5), the Contractor shall furnish and place supplementary spall material.

Riprap and quarry spalls shall be free from segregation, seams, cracks, and other defects tending to destroy its resistance to weather and shall meet the following test requirements:

Aggregate Property	Test method	Requirement
Degradation Factor	WSDOT Test Method T 113	15 minimum
Los Angeles Wear, 500 Rev.	AASHTO T 96	50% maximum
Specific Gravity, SSD	AASHTO T 85	2.55 minimum

9-13.1(2) Heavy Loose Riprap

Heavy loose riprap shall meet the following requirements for grading:

	Minimum Size	Maximum Size
40% to 90%	1 ton (½ cubic yd.)	
70% to 90%	300 lbs. (2 cu. ft.)	
10% to 30%	3 inch	50 lbs. (spalls)

9-13.1(3) Light Loose Riprap

Light loose riprap shall meet the following requirements for grading:

	Size Range	Maximum Size
20% to 90%	300 lbs. to 1 ton (2 cu. ft. to ½ cu. yd.)	
15% to 80%	50 lbs. to 1 ton (⅓ cu. ft. to ½ cu. yd.)	
10% to 20%	3 inch	50 lbs. (spalls)

9-13.1(4) Hand Placed Riprap

Hand placed riprap shall be as nearly rectangular as possible, 60 percent shall have a volume of not less than 1 cubic foot. No stone shall be used which is less than 6 inches thick, nor which does not extend through the wall.

9-13.1(5) Quarry Spalls

Quarry spalls shall meet the following requirements for grading:

Sieve Size	Percent Passing
8″	100
3″	40 max.
¾″	10 max.

9-13.2 Vacant

9-13.3 Vacant

9-13.4 Rock for Erosion and Scour Protection

Rock for Erosion and Scour Protection shall be hard, sound, and durable material, free from seams, cracks, and other defects that tend to destroy its resistance to weather, and it shall consist of broken and/or processed rock. Rock for Erosion and Scour Protection shall meet the quality requirements in Section 9-13 and the grading requirements in Section 9-13.4(2). The use of recycled materials and concrete rubble is not permitted for this application.

9-13.4(1) Suitable Shape of Rock for Erosion and Scour Protection

The Suitable Shape of these rocks shall be “Angular” (having sharply defined edges) to “Subangular” (having a shape in between Rounded and Angular) for a higher degree of interlocking to provide stability to the protected area. The use of round, thin, flat, or long and needle-like shapes is not allowed. Suitable Shape can be determined by the ratio of the Length/Thickness, where the Length is the longest axis, Width is the second longest axis, and Thickness is the shortest. The Suitable Shape shall be the maximum of 3.0 using the following calculation:

$$= \leq 3.0 \text{ Suitable Shape}$$

9-13.4(2) Grading Requirements of Rock for Erosion and Scour Protection

Rock for Erosion and Scour Protection will be classified as Class A, Class B, and Class C, and it shall have a "Well-Graded" structure that meets the requirements for Suitable Shape and conforms to one or more of the following gradings as shown in the Plans.

Class A	
Approximate Size (in.)[1]	Percent Passing (Smaller)
18	100
16	80-95
12	50-80
8	15-50
4	15 max.

Class C	
Approximate Size (in.)[1]	Percent Passing (Smaller)
42	100
36	80-95
28	50-80
22	15-50
14	15 max.

Class B	
Approximate Size (in.)[1]	Percent Passing (Smaller)
30	100
28	80-95
22	50-80
16	15-50
10	15 max.

[1]Approximate Size can be determined by taking the average dimension of the three axes of the rock, Length, Width, and Thickness, by use of the following calculation:

$$\frac{\text{Length + Width + Thickness}}{3} = \text{Approximate Size}$$

Rock for Erosion and Scour Protection shall be visually accepted by the Engineer. The Engineer shall determine the Suitable Shape, Approximate Size, and Grading of the load before it is placed. If so ordered by the Engineer, the loads shall be dumped on a flat surface for sorting and measuring the individual rocks contained in the load.

9-13.5 Concrete Slope Protection

Concrete slope protection shall consist of reinforced portland cement or blended hydraulic cement concrete poured or pneumatically placed upon the slope with a rustication joint pattern or semi-open concrete masonry units placed upon the slope closely adjoining each other.

9-13.5(1) Semi-Open Concrete Masonry Units Slope Protection

Precast cement concrete blocks shall conform to the requirements of ASTM C1319.

9-13.5(2) Poured Portland Cement or Blended Hydraulic Cement Concrete Slope Protection

Cement concrete for poured concrete slope protection shall be commercial concrete in conformance with Section 6-02.3(2)B.

9-13.5(3) Pneumatically Placed Portland Cement or Blended Hydraulic Cement Concrete Slope Protection

Cement – This material shall be portland cement or blended hydraulic cement as specified in Section 9-01.

Aggregate – This material shall meet the requirements for fine aggregate as specified in Section 9-03.1. The moisture content of the fine aggregate at the time of use shall be between 3 and 6 percent by weight.

Reinforcement – Wire mesh reinforcement shall conform to the provisions of Section 9-07.7.

Water – Water shall conform to the provisions of Section 9-25.1.

9-13.6 Vacant

9-13.7 Rock for Rock Wall

9-13.7(1) Rock for Rock Walls and Chinking Material

Rock for rock walls and chinking material shall be hard, sound and durable material, free from seams, cracks, and other defects tending to destroy its resistance to weather, and shall meet the following test requirements:

Test	Test Method	Requirements
Specific Gravity, SSD	AASHTO T 85	2.55 min.
LA Wear	AASHTO T 96	50% max.
Degradation	WSDOT T 113	15 min.
Absorption	AASHTO T 85	3% max.

Rock for rock wall sizes are approximately as follows:

Rock Size	Rock Weight (lbs)	Average Dimension (in.)
One Man	50 to 200	12 to 18
Two Man	200 to 700	18 to 28
Three Man	700 to 2,000	28 to 36
Four Man	2,000 to 4,000	36 to 48
Five Man	4,000 to 6,000	48 to 54
Six Man	6,000 to 8,000	54 to 60

Chinking material shall be a minimum of 4 inches average dimension.

9-13.7(2) Backfill for Rock Wall

Backfill for rock walls shall be shot rock ranging in size from a minimum of 2 inches to a maximum of 6 inches.

Acceptance shall be based on visual inspection by the Engineer.

9-14 Erosion Control and Roadside Planting

9-14.1 Materials Submittals and Acceptance

Standard Specification Section	Material	For each material used the Contractor shall submit a materials certificate of compliance in accordance with Section 1-06.2 along with the following information to the Engineer
9-14.2(1)	Topsoil Type A	Compliance with the applicable section.
9-14.2(2)	Topsoil Type B	
9-14.2(3)	Topsoil Type C	
9-14.3	Seed	
9-14.4	Fertilizer	
9-14.5	Mulch and Amendments	
9-14.5(1)	Straw	
9-14.5(2)	Hydraulically Applied Erosion Control Products	Test results, dated within 3 years prior to the date of application, from an independent, accredited laboratory, as approved by the Engineer, that show the product meets requirements of this section.
9-14.5(2)A	Long-Term Mulch in Section	Test results reported on WSDOT Form 220-042 documenting that the mulch meets the requirements in Section 9-14.5(2) Table 1 and this section.
9-14.5(2)B	Moderate-Term Mulch	Test results reported on WSDOT form 220-043 documenting that the mulch meets the requirements in Section 9-14.5(2) Table 1 and the applicable requirements of these sections.
9-14.5(2)C	Short-Term Mulch	
9-14.5(3)	Bark and Wood Chip Mulch	Compliance with the applicable section.
9-14.5(4)	Wood Strand Mulch	A satisfactory test report, performed in accordance with WSDOT T 125 and compliance with this section.
9-14.5(6)	Agriculture Grade Gypsum	Compliance with the applicable section.
9-14.5(7)	Tackifier	Test results that show the tackifier meets requirements of Section 9-14.5(2) Table 1 and compliance with this section.

Standard Specification Section	Material	For each material used the Contractor shall submit a materials certificate of compliance in accordance with Section 1-06.2 along with the following information to the Engineer
9-14.5(8)	Compost	Fourteen days prior to application. a) A copy of the Solid Waste Handling Permit issued to the manufacturer by the Jurisdictional Health Department in accordance with https://apps.leg.wa.gov/WAC/default.aspx?cite=173-350 (Minimum Functional Standards for Solid Waste Handling). b) Test results that show the compost complies with the processes, testing, and standards specified in WAC 173-350 and this section. An independent Seal of Testing Assurance (STA) Program certified laboratory shall perform the testing. c) A copy of the manufacturer's Seal of Testing Assurance STA certification as issued by the U.S. Composting Council dated within 90 calendar days of the application. d) Compost test data submitted on WSDOT Form 220-038. e) A sample of the compost approved for use. f) A list of feed stocks by volume for each compost type. g) Physical contaminants shall not exceed 0.5 percent by weight of total sampled compost. h) Compliance with the applicable section.
9-14.5(9)	Horticultural Grade Perlite	Test results reported on WSDOT Form 220-037 documenting that the horticultural grade perlite meets the requirements of this section.
9-14.6(2)	Biodegradable Erosion Control Blanket	Test results reported on WSDOT Form 220-039 documenting that the biodegradable erosion control blanket meets the requirements of this section. Independent laboratory test results from the National Transportation Product Evaluation Program (NTPEP) meeting the requirements of Sections 9-14.5(2)A, 9-14.5(2)B or 9-14.5(2)C.
9-14.6(5)	Wattles	Compliance with the applicable section.
9-14.6(6)	Compost Socks	
9-14.7	Plant Materials	If cuttings are taken from private property the contractor shall submit a copy of the written permission to the Engineer prior to cuttings being collected.

9-14.2 Topsoil

Topsoil shall not contain any recycled material, foreign materials, or any listed Noxious and Nuisance weeds of any Class designated by authorized State or County officials. Aggregate shall not comprise more than 10 percent by volume of Topsoil and shall not be greater than two inches in diameter.

9-14.2(1) Topsoil Type A

Topsoil Type A shall be as specified in the Special Provisions.

9-14.2(2) Topsoil Type B

Topsoil Type B shall be native topsoil taken from within the project limits either from the area where roadway excavation is to be performed or from strippings from borrow, pit, or quarry sites, or from other designated sources. In the production of Topsoil Type B, all vegetative matter, less than 4 feet in height, shall become a part of the topsoil.

9-14.2(3) Topsoil Type C

Topsoil Type C shall be native topsoil meeting the requirements of Topsoil Type B but obtained from a source provided by the Contractor outside of the Contracting Agency owned right of way.

9-14.3 Seed

Seed of the type specified shall be certified in accordance with WAC 16-302. Seed mixes shall be commercially prepared and supplied in sealed containers. The labels shall show:

(1) Common and botanical names of seed,

(2) Lot number,

(3) Net weight,

(4) Pounds of Pure live seed (PLS) in the mix,

(5) Origin of seed.

All seed vendors must have a business license issued by supplier's state or provincial Department of Licensing with a "seed dealer" endorsement.

9-14.4 Fertilizer

Fertilizer shall be a standard commercial grade of organic or inorganic fertilizer of the kind and quality specified. It may be separate or in a mixture containing the percentage of total nitrogen, available phosphoric acid, and water-soluble potash or sulfur in the amounts specified. All fertilizers shall be furnished in standard unopened containers with weight, name of plant nutrients, and manufacturer's guaranteed statement of analysis clearly marked, all in accordance with State and Federal laws.

Fertilizer shall be supplied in one of the following forms:

(1) A dry free-flowing granular fertilizer, suitable for application by agricultural fertilizer spreader.

(2) A soluble form that will permit complete suspension of insoluble particles in water, suitable for application by power sprayer.

(3) A homogeneous pellet, suitable for application through a ferti-blast gun.

(4) A tablet or other form of controlled release with a minimum of a 6 month release period.

(5) A liquid suitable for application by a power sprayer or hydroseeder.

9-14.5 Mulch and Amendments

All amendments shall be delivered to the site in the original, unopened containers bearing the manufacturer's guaranteed chemical analysis and name. In lieu of containers, amendments may be furnished in bulk. A Manufacturer's Certificate of Compliance shall accompany each delivery. Compost and other organic amendments shall be accompanied with all applicable health certificates and permits.

9-14.5(1) Straw

Straw shall be in an air-dried condition, free of noxious weeds, seeds, and other materials detrimental to plant life. Hay is not acceptable.

All straw material shall be Certified Weed-Free Straw using North American Weed Management Association (NAWMA) standards or the Washington Wilderness Hay and Mulch (WWHAM) program run by the Washington State Noxious Weed Control Board. Information can be found at www.nwcb.wa.gov.

In lieu of Certified Weed-Free Straw, the Contractor shall submit documentation that the material is steam or heat treated to kill seeds, or shall submit U.S., Washington State, or other states' Department of Agriculture laboratory test reports, dated within 90 days prior to the date of application, showing that there are no viable seeds in the straw.

9-14.5(2) Hydraulically Applied Erosion Control Products (HECPs)

All HECPs shall be made of natural plant fibers unaltered by synthetic materials, and in a dry condition, free of noxious weeds, seeds, chemical printing ink, germination inhibitors, herbicide residue, chlorine bleach, rock, metal, plastic, and other materials detrimental to plant life.

The HECP shall be suitable for spreading with a hydroseeder.

All HECPs shall be furnished premixed by the manufacturer with Organic or Synthetic Tackifier as specified in Section 9-14.5(7). The product shall be hydrated in accordance with the manufacturer's recommendations.

The Contractor shall submit test results, dated within 3 years prior to the date of application, from an independent, accredited laboratory, as approved by the Engineer, showing that the product meets the following requirements:

Table 1 HECP Requirements

These test requirements apply to the fully mixed product, including tackifiers, dyes, or other additives that may be included in the HECP final product in its sprayable form.

Properties	Test Method	Requirements
Acute Toxicity	EPA-821-R-02-012 Methods for Measuring Acute Toxicity of Effluents. Test leachate from recommended application rate receiving 2 inches of rainfall per hour using static test for No-Observed-Adverse-Effect-Concentration (NOEC).	Four replicates are required with no statistically significant reduction in survival in 100 percent leachate for a Daphnid at 48 hours and Oncorhynchus mykiss (rainbow trout) at 96 hours.
Solvents	EPA 8260 (SW846)	Benzene – < 0.03 mg/kg Methylene chloride – < 0.02 mg/kg Naphthalene – < 5 mg/kg Tetrachloroethylene – < 0.05 mg/kg Toluene – < 7 mg/kg Trichloroethylene – < 0.03 mg/kg Xylenes – < 9 mg/kg
Heavy Metals	EPA 6010 or 6020 (SW856)	Antimony – < 4 mg/kg Arsenic – < 6 mg/kg Barium – < 80 mg/kg Boron – < 160 mg/kg Cadmium – < 2 mg/kg Total Chromium – < 4 mg/kg Copper – < 10 mg/kg Lead – < 5 mg/kg Nickel – < 2 mg/kg Selenium – < 10 mg/kg Strontium – < 40 mg/kg Zinc – < 30 mg/kg
Heavy Metals	EPA 6010 or 6020 (SW856) or EPA 7470 or 7471 (SW856)	Mercury – < 2 mg/kg

If the HECP contains cotton or straw, the Contractor shall submit documentation that the material has been steam or heat treated to kill seeds, or shall submit U.S., Washington State, or other states' Department of Agriculture laboratory test reports, dated within 90 days prior to the date of application, showing that there are no viable seeds in the mulch.

The HECP shall be manufactured in such a manner that, when agitated in slurry tanks with water, the fibers will become uniformly suspended, without clumping, to form a homogeneous slurry. When hydraulically applied, the material shall form a strong moisture-holding mat that allows the continuous absorption and infiltration of water.

If the HECP contains a dye to facilitate placement and inspection of the material, it shall be nontoxic to plants, animals, and aquatic life and shall not stain concrete or painted surfaces.

The HECP shall not be harmful to plants, animals, and aquatic life.

9-14.5(2)A Long-Term Mulch

Long-Term Mulch shall adhere to the soil, create a blanket-like mass and bond with the soil surface to create a continuous, porous, absorbent, and flexible erosion-resistant blanket that allows for seed germination and plant growth. Long-Term Mulch shall meet the requirements in Table 2, Long-Term Mulch Test Requirements. Products containing cellulose fiber produced from paper or paper components will not be approved or accepted. With the exception of seed and water, field mixing of additives or components is not acceptable.

Table 2 Long-Term Mulch Test Requirements

The Contractor shall supply independent test results from the National Transportation Product Evaluation Program (NTPEP) on 5-year intervals generated on or after November 1, 2015 showing that the product meets the Cover-Factor (C Factor) in accordance with ASTM D6459.		
Properties	**Test Method**	**Requirements**
Performance in Protecting Slopes from Rainfall-Induced Erosion	ASTM D6459. Test in one soil type. Soil tested shall be sandy loam as defined by the NRCS Soil Texture Triangle.	C Factor = 0.01 maximum using Revised Universal Soil Loss Equation (RUSLE)
The Contractor shall submit test results from an independent, accredited laboratory, on 5-year intervals generated on or after July 15 of 2017 showing that the product meets the follow-ing requirements.		
Properties	**Test Method**	**Requirements**
Water Holding Capacity	ASTM D7367	800 percent minimum
Organic Matter Content	AASHTO T 267	90 percent minimum
Seed Germination Enhancement	ASTM D7322	Long Term 420 percent minimum

9-14.5(2)B Moderate-Term Mulch

Within 48 hours of application, the Moderate-Term Mulch shall bond with the soil surface to create a continuous, absorbent, flexible, erosion-resistant blanket. Moderate-Term Mulch shall effectively perform the intended erosion control function in accordance with Section 8-01.3(1) for a minimum of 3 months, or until temporary vegetation has been established, whichever comes first.

9-14.5(2)C Short-Term Mulch

Short-Term Mulch shall effectively perform the intended erosion control function in accordance with Section 8-01.3(1) for a minimum of 2 months, or until temporary vegetation has been established, whichever comes first. Short-Term Mulch shall not be used in conjunction with permanent seeding.

9-14.5(3) Bark or Wood Chip Mulch

Bark or wood chip mulch shall be derived from fir, pine, or hemlock species. It shall not contain resin, tannin, or other compounds in quantities that would be detrimental to plant life. Sawdust shall not be used as mulch. Mulch produced from finished wood products or construction debris will not be allowed.

Bark or wood chips when tested shall be in accordance with WSDOT T 123 and shall meet the following loose volume gradation:

Sieve Size	Percent Passing	
	Minimum	Maximum
2″	95	100
No. 4	0	30

9-14.5(4) Wood Strand Mulch

Wood strand mulch shall be a blend of angular, loose, long, thin wood pieces that are frayed, with a high length-to-width ratio, and it shall be derived from native conifer or deciduous trees. A minimum of 95 percent of the wood strand shall have lengths between 2 and 10 inches. At least 50 percent of the length of each strand shall have a width and thickness between 1/16 and ½ inch. No single strand shall have a width or thickness greater than ½ inch.

The mulch shall not contain salt, preservatives, glue, resin, tannin, or other compounds in quantities that would be detrimental to plant life. Sawdust or wood chips or shavings will not be acceptable.

This product shall not be harmful to plants, animals, and aquatic life.

9-14.5(5) Agricultural Grade Dolomite Lime

Agricultural grade dolomite lime shall be in a pelletized or granular form, meeting the grading requirements of ASTM C602 for Class E.

9-14.5(6) Agricultural Grade Gypsum

Agricultural grade gypsum shall consist of Calcium Sulfate ($CaSO_4 \cdot 2H_2O$) in a pelletized or granular form and shall meet the following grading requirements;

Sieve Size	Percent Passing
¼"	99 – 100
No. 20	20 max

All percentages are by weight.

9-14.5(7) Tackifier

Tackifiers are used as a tie-down for soil, compost, seed, and/or mulch. Tackifiers shall contain no growth or germination-inhibiting materials and shall not reduce infiltration rates. Tackifiers shall hydrate in water and readily blend with other slurry materials. Tackifiers shall include a mulch tracer added to visible aid uniform application, and shall not be harmful to plants, animals, or aquatic life.

9-14.5(7)A Organic Tackifier

Organic tackifiers shall be derived from natural plant sources and shall not be harmful to plants, animals, and aquatic life.

9-14.5(7)B Synthetic Tackifier

Synthetic tackifiers shall not be harmful to plants, animals, and aquatic life.

9-14.5(8) Compost

Compost products shall be the result of the biological degradation and transformation of organic materials under controlled conditions designed to promote aerobic decomposition. Compost shall be stable with regard to oxygen consumption and carbon dioxide generation. Compost shall be mature with regard to its suitability for serving as a soil amendment or an erosion control BMP as defined below. The compost shall have a moisture content that has no visible free water or dust produced when handling the material.

Compost production and quality shall comply with WAC 173-350.

Compost products shall meet the following physical criteria:

1. Compost material shall be tested in accordance with U.S. Composting Council Testing Methods for the Examination of Compost and Composting (TMECC) 02.02-B, "Sample Sieving for Aggregate Size Classification".

Fine compost shall meet the following gradation:

Sieve Size	Percent Passing	
	Minimum	Maximum
1″	100	
⅝″	90	100
¼″	75	100

Note: Maximum particle length of 4 inches.

Medium compost shall meet the following gradation:

Sieve Size	Percent Passing	
	Minimum	Maximum
1″	100	
⅝″	85	100
¼″	70	85

Note: Maximum particle length of 4 inches. Medium compost shall have a carbon to nitrogen ratio (C:N) between 18:1 and 35:1. The carbon to nitrogen ratio shall be calculated using the dry weight of "Organic Carbon" using TMECC 04.01A divided by the dry weight of "Total N" using TMECC 04.02D.

Coarse compost shall meet the following gradation:

Sieve Size	Percent Passing	
	Minimum	Maximum
2″	100	
1″	90	100
¾″	70	100
¼″	40	60

Note: Maximum particle length of 6 inches. Coarse compost shall have a carbon to nitrogen ratio (C:N) between 25:1 and 35:1. The carbon to nitrogen ratio shall be calculated using the dry weight of "Organic Carbon" using TMECC 04.01A divided by the dry weight of "Total N" using TMECC 04.02D.

2. The pH shall be between 6.0 and 8.5 when tested in accordance with U.S. Composting Council TMECC 04.11-A, "1:5 Slurry pH".
3. Physical contaminants, defined in WAC 173-350 (plastic, concrete, ceramics, metal, etc.) shall be less than 0.5 percent by weight as determined by U.S. Composting Council TMECC 03.08-A "Classification of Inerts by Sieve Size".
4. Minimum organic matter shall be 40 percent by dry weight basis as determined by U.S. Composting Council TMECC 05.07A "Loss-On-Ignition Organic Matter Method (LOI)".
5. Soluble salt contents shall be less than 4.0 mmhos/cm when tested in accordance with U.S. Composting Council TMECC 04.10 "Electrical Conductivity".
6. Maturity shall be greater than 80 percent in accordance with U.S. Composting Council TMECC 05.05-A, "Germination and Root Elongation".

7. Stability shall be 7-mg CO2–C/g OM/day or below in accordance with U.S. Composting Council TMECC 05.08-B "Carbon Dioxide Evolution Rate".
8. The compost product shall originate from organic feedstocks as defined in WAC 173-350 as "Wood waste", "Yard debris", "Post-consumer food waste", "Preconsumer animal-based wastes", and/or "Preconsumer vegetative waste". The Contractor shall provide a list of feedstock sources by percentage in the final compost product.
9. The Engineer may also evaluate compost for maturity using U.S. Composting Council TMECC 05.08-E "Solvita® Maturity Index". Fine compost shall score a number 6 or above on the Solvita® Compost Maturity Test. Medium and Coarse compost shall score a 5 or above on the Solvita® Compost Maturity Test.

9-14.5(9) Horticultural Grade Perlite

Horticultural grade perlite shall be in a pelletized or granular form.

Horticultural grade perlite shall meet the following requirements for quality and grading:

Quality Requirements		
Property	**Test Method[1]**	**Requirement**
pH (of water slurry)	PI 202	6.5 – 8.0
Bulk Density, lb/ft^3	PI 200	2 – 10

[1]PI, abbreviation for the Perlite Institute

Gradation Requirements	
Sieve Size	**Percent Passing**
No. 4	99 – 100
No. 18	30 max
No. 30	10 max

All percentages are by weight.

9-14.6 Erosion Control Devices

9-14.6(1) Polyacrylamide (PAM)

PAM is used as a tie-down for soil, compost, or seed, and is also used as a flocculent. PAM products shall meet ANSI/NSF Standard 60 for drinking water treatment with an AMD content not to exceed 0.05 percent. PAM shall be anionic and shall be linear, and not cross-linked. The minimum average molecular weight shall be greater than 5-mg/mole. The charge density shall be no less than 15 percent and no greater than 30 percent. The product shall contain at least 80 percent active ingredients and have a moisture content not exceeding 10 percent by weight. PAM shall be delivered in a dry granular or powder form.

9-14.6(2) Biodegradable Erosion Control Blanket

Biodegradable erosion control blankets, including netting if present, shall be made of natural plant fibers unaltered by synthetic materials. All blanket material shall effectively perform the intended erosion control function until permanent vegetation has been established, or for a minimum of 6 months, whichever comes first.

9-14.6(2)A Biodegradable Erosion Control Blanket for Slopes Steeper than 3:1 (H:V)

Table 6

Properties	ASTM Test Method	Requirements for Slopes Steeper than 3:1
Protecting Slopes from Rainfall-Induced Erosion	ASTM D6459 Soil tested shall be sandy loam as defined by the NRCS** Soil Texture Triangle	C factor = 0.04 maximum for cumulative R-Factor<231
Mass Per Unit Area	ASTM D6475	7.6 oz./sq. yd. minimum
Light Penetration	ASTM D6567	44% maximum
Tensile Strength MD × XD*	ASTM D6818	10.0 × 6.0 pounds/inch minimum
Tensile Elongation MD × XD*	ASTM D6818	38% × 33% maximum

*MD is Machine Design and XD is Cross Direction
**Natural Resource Conservation Services

9-14.6(2)B Biodegradable Erosion Control Blanket for Slopes Flatter than 3:1 (H:V)

Table 7

Properties	ASTM Test Method	Slope Flatter than 3:1 Requirements
Protecting Slopes from Rainfall-Induced Erosion	ASTM D6459 Soil tested shall be sandy loam as defined by the NRCS** Soil Texture Triangle	C factor = 0.15 maximum for cumulative R-Factor<231
Mass Per Unit Area	ASTM D6475	7.6 oz./sq. yd. minimum
Light Penetration	ASTM D6567	40% maximum
Tensile Strength MD × XD*	ASTM D6818	6.5 × 2.3 pounds/inch minimum
Tensile Elongation MD × XD*	ASTM D6818	38% × 33% maximum

*MD is Machine Design and XD is Cross Direction
**Natural Resource Conservation Services

9-14.6(2)C Biodegradable Erosion Control Blanket for Ditches

Table 8

Properties	Test Method	Requirements
Performance in Protecting Earthen Channels from Stormwater-Induced Erosion	ASTM D6460 Soil tested shall be sandy loam as defined by the NRCS** Soil Texture Triangle	Limiting Shear (T_{Limit}) = 2.0 psf minimum. Limiting Velocity (V_{Limit}) = 7.5 ft/sec flow minimum.
Mass per Unit Area	ASTM D6475	7.4 oz./ sq. yd. minimum
Light Penetration	ASTM D6567	65% maximum
Tensile Strength MD × XD*	ASTM D6818	9.6 × 3.2 lbs/inch minimum
Tensile Elongation MD × XD*	ASTM D6818	38% × 33% maximum

*MD is Machine Design and XD is Cross Direction
**Natural Resource Conservation Services

9-14.6(3) Plastic Covering

Plastic covering shall meet the requirements of ASTM D4397 for polyethylene sheeting.

9-14.6(4) Check Dams

All materials used for check dams shall be non-toxic and not pose a threat to wildlife when installed.

9-14.6(4)A Biodegradable Check Dams

Biodegradable check dams shall meet the following requirements:

Wattle	Section 9-14.6(5)
Compost Sock	Section 9-14.6(6)
Coir Log	Section 9-14.6(7)

The Contractor may substitute a different biodegradable check dam as long as it complies with the following and is accepted by the Engineer:

1. Made of natural plant fiber unaltered by synthetic material.
2. Netting if present shall be made of natural plant fibers unaltered by synthetic materials. Materials shall effectively perform the intended erosion control function until permanent vegetation has been established or for a minimum of 6 months, whichever comes first.
3. Straw bales shall not be used as check dams.

9-14.6(4)B Non-biodegradable Check Dams

Non-biodegradable check dams shall meet the following requirements:

1. Geotextile materials shall conform to Section 9-33 for silt fence.
2. Other such devices that meet the requirements of Section 9-14.6(4) and shall be approved by the Engineer prior to installation.

9-14.6(5) Wattles

Wattles shall consist of cylinders of plant material such as weed-free straw, coir, wood chips, excelsior, or wood fiber or shavings encased within netting made of natural plant fibers unaltered by synthetic materials. Wattles shall be a minimum of 8 inches in diameter. Netting material shall be clean, evenly woven, and free of encrusted concrete or other contaminating materials such as preservatives. Netting material shall be free from cuts, tears, or weak places and shall effectively perform the intended erosion control function until permanent vegetation has been established or for a minimum of 6 months, whichever comes first.

If wood chip filler is used, it shall meet the material requirements as specified in Section 9-14.5(3). If straw filler is used, it shall meet the material requirements as specified in Section 9-14.4(1). If wood shavings are used, 80 percent of the fibers shall have a minimum length of 6 inches between 0.030 and 0.50 inches wide and between 0.017 and 0.13 inches thick.

Stakes for wattles shall be made of wood from untreated Douglas fir, hemlock, or pine species.

9-14.6(6) Compost Socks

Compost socks shall consist of fabric made of natural plant fibers unaltered by synthetic materials. The compost sock shall be filled with Medium Compost as specified in Section 9-14.5(8). Compost socks shall be at least 8 inches in diameter. The sock shall be clean, evenly woven; free of encrusted concrete or other contaminating materials; free from cuts, tears, broken or missing yarns; free of thin, open, or weak areas; and free of any type of preservative. Sock fabric shall effectively perform the intended erosion control function until permanent vegetation has been established or for a minimum of 6 months, whichever comes first.

Stakes for compost socks shall be made of wood from untreated Douglas fir, hemlock, or pine species.

9-14.6(7) Coir Log

Coir logs shall be made of 100 percent durable coconut (coir) fiber uniformly compacted within woven netting made of bristle coir twine with a minimum tensile strength of 80 lbs. The netting shall have nominal 2 by 2-inch openings. Log segments shall have a maximum length of 20 feet, with a minimum diameter as shown in the Plans. Logs shall have a minimum density of 7 lbs/cf.

Stakes shall be untreated Douglas fir, hemlock, or pine species. Wood stakes shall have a notch to secure the rope ties. Rope ties shall be made of ¼-inch diameter commercially available hemp rope.

9-14.6(8) High Visibility Fencing

High visibility fence shall be UV stabilized, orange, high-density polyethylene or polypropylene mesh.

Support posts shall be wood or steel in accordance with Standard Plan I-10.10. The posts shall have sufficient strength and durability to support the fence through the life of the project.

9-14.6(9) High Visibility Silt Fence

High visibility silt fence shall be a minimum of 5 feet in height, high visibility orange, UV stabilized and shall meet the geotextile requirements in Section 9-33 Table 6. Support posts shall be in accordance with the Standard Plans. The posts shall have sufficient strength and durability to support the fence through the life of the project.

9-14.7 Plant Materials

9-14.7(1) Description

Bareroot plants are grown in the ground and harvested without soil or growing medium around their roots.

Container plants are grown in pots or flats that prevent root growth beyond the sides and bottom of the container.

Balled and burlapped plants are grown in the ground and harvested with soil around a core of undisturbed roots. This rootball is wrapped in burlap and tied or placed in a wire basket or other supportive structure.

Cuttings are live plant material without a previously developed root system. Source plants for cuttings shall be dormant when cuttings are taken and all cuts shall be made with a sharp instrument. Cuttings may be collected. If cuttings are collected, the requirement to be nursery grown or held in nursery conditions does not apply. Written permission shall be obtained from property owners and provided to the Engineer before cuttings are collected. The Contractor shall collect cuttings in accordance with applicable sensitive area ordinances. Cuttings shall meet the following requirements:

1. Live branch cuttings shall have flexible top growth with terminal buds and may have side branches. The rooting end shall be cut at an approximate 45-degree angle.
2. Live stake cuttings shall have a straight top cut immediately above a bud. The lower, rooting end shall be cut at an approximate 45-degree angle. Live stakes are cut from one to two year old wood. Live stake cuttings shall be cut and installed with the bark intact with no branches or stems attached, and be ½ to 1½ inch in diameter.
3. Live pole cuttings shall have a diameter between 2 inches and 3.5 inches. Live poles shall have no more than three branches which must be located at the top end of the pole and those branches shall be pruned back to the first bud from the main stem.

Rhizomes shall be a prostrate or subterranean stem, usually rooting at the nodes and becoming erect at the apex. Rhizomes shall have a minimum of two growth points. Tubers shall be a thickened and short subterranean branch having numerous buds or eyes.

9-14.7(2) Quality

At the time of delivery, all plant material furnished shall meet the grades established by the latest edition of the American Standard for Nursery Stock, (ASNS) ANSI Z60.1 and shall conform to the size and acceptable conditions as listed in the Contract, and shall be free of all foreign plant material.

All plant material shall comply with State and Federal laws with respect to inspection for plant diseases and insect infestation. Plants must meet Washington State Department of Agriculture plant quarantines and have a certificate of inspection. Plants originating in Canada must be accompanied by a phytosanitary certificate stating the plants meet USDA health requirements.

All plant material shall be purchased from a nursery licensed to sell plants in their state or province.

Live woody or herbaceous plant material, except cuttings, rhizomes, and tubers, shall be vigorous, well formed, with well developed fibrous root systems, free from dead branches, and from damage caused by an absence or an excess of heat or moisture, insects, disease, mechanical or other causes detrimental to good plant development. Evergreen plants shall be well foliated and of good color. Deciduous trees that have solitary leaders shall have only the lateral branches thinned by pruning. All conifer trees shall have only one leader (growing apex) and one terminal bud, and shall not be sheared or shaped. Trees having a damaged or missing leader, multiple leaders, or Y-crotches shall be rejected.

Root balls of plant materials shall be solidly held together by a fibrous root system and shall be composed only of the soil in which the plant has been actually growing. Balled and burlapped rootballs shall be securely wrapped with jute burlap or other packing material not injurious to the plant life. Root balls shall be free of weed or foreign plant growth.

Plant materials shall be nursery grown stock. Plant material, with the exception of cuttings, gathered from native stands shall be held under nursery conditions for a minimum of one full growing season, shall be free of all foreign plant material, and meet all of the requirements of these Specifications, the Plans, and the Special Provisions.

Container grown plants shall be plants transplanted into a container and grown in that container sufficiently long for new fibrous roots to have developed so that the root mass will retain its shape and hold together when removed from the container, without having roots that circle the pot. Plant material which is root bound, as determined by the Engineer, shall be rejected. Container plants shall be free of weed or foreign plant growth.

Container sizes for plant material of a larger grade than provided for in the container grown Specifications of the ASNS shall be determined by the volume of the root ball specified in the ASNS for the same size plant material.

All bare root plant materials shall have a heavy fibrous root system and be dormant at the time of planting.

Average height to spread proportions and branching shall be in accordance with the applicable sections, illustrations, and accompanying notes of the ASNS.

Plants specified or identified as “Street Tree Grade” shall be trees with straight trunks, full and symmetrical branching, central leader, and be developed, grown, and propagated with a full branching crown. A “Street Tree Grade” designation requires the highest grade of nursery shade or ornamental tree production which shall be supplied.

Street trees with improperly pruned, broken, or damaged branches, trunk, or root structure shall be rejected. In all cases, whether supplied balled and burlapped or in a container, the root crown (top of root structure) of the tree shall be at the top of the finish soil level. Trees supplied and delivered in a nursery fabric bag will not be accepted.

Plants which have been determined by the Engineer to have suffered damage for the following reasons will be rejected:

1. Girdling of the roots, stem, or a major branch.
2. Deformities of the stem or major branches.
3. Lack of symmetry.
4. Dead or defoliated tops or branches.
5. Defects, injury, and condition which renders the plant unsuitable for its intended use.

Plants that are grafted shall have roots of the same genus as the specified plant.

9-14.7(3) Handling and Shipping

Handling and shipping shall be done in a manner that is not detrimental to the plants.

The nursery shall furnish a notice of shipment in triplicate at the time of shipment of each truck load or other lot of plant material. The original copy shall be delivered to the Engineer, the duplicate to the consignee and the triplicate shall accompany the shipment to be furnished to the Inspector at the job site. The notice shall contain the following information:

1. Name of shipper.
2. Date of shipment.
3. Name of commodity (including all names as specified in the Contract).
4. Consignee and delivery point.
5. State Contract number.
6. Point from which shipped.
7. Quantity contained.
8. Size (height, runner length, caliper, etc., as required).
9. Signature of shipper by authorized representative.

To acclimate plant materials to Northwest conditions, all plant materials used on a project shall be grown continuously outdoors north of the 42nd Latitude (Oregon-California border) from not later than August 1 of the year prior to the time of planting.

All container grown plants shall be handled by the container.

All balled and burlapped plants shall be handled by the ball.

Plant material shall be packed for shipment in accordance with prevailing practice for the type of plant being shipped, and shall be protected at all times against drying, sun, wind, heat, freezing, and similar detrimental conditions both during shipment and during related handling. Where necessary, plant material shall be temporarily heeled in. When transported in closed vehicles, plants shall receive adequate ventilation to prevent sweating. When transported in open vehicles, plants shall be protected by tarpaulins or other suitable cover material.

9-14.7(4) Sod

The sod shall be field grown one calendar year or older, have a well developed root structure, and be free of all weeds, disease, and insect damage.

Prior to cutting, the sod shall be green, in an active and vigorous state of growth, and mowed to a height not exceeding 1 inch.

The sod shall be cut with a minimum of 1 inch of soil adhering.

9-14.8 Stakes, Guys, and Wrapping

The minimum size of wire used for guying shall be 12-gauge, soft drawn.

Hose for guying shall be nylon, rubber, or reinforced plastic and shall have an inside diameter of at least 1 inch.

Tree wrap shall be a crinkled waterproof paper weighing not less than 4 pounds per 100 square feet and shall be made up of two sheets cemented together with asphalt.

9-15 Irrigation System

All materials and equipment incorporated in the system shall be new, undamaged, of standard quality, and shall be subject to testing as specified. When the water supply for the irrigation system is from a nonpotable source, irrigation components shall have lavender indicators supplied by the equipment manufacturer.

9-15.1 Pipe, Tubing, and Fittings

Pipe shall be copper, galvanized iron, PVC, or polyethylene, as specified in the Plans or in the Special Provisions.

Copper pipe or tubing shall be annealed, seamless, and conform to the requirements of ASTM B88, and shall be a minimum of Type L rating.

Threaded cast brass or bronze fittings shall meet the requirements of Section 9-30.6(6).

9-15.1(1) Galvanized Pipe and Fittings

Pipe shall be standard weight, hot-dip galvanized iron or steel pipe, threaded and coupled. Pipe shall meet the requirements of ASTM A53.

All pipe fittings shall be standard threaded galvanized malleable iron fittings.

9-15.1(2) Polyvinyl Chloride Pipe and Fittings

PVC pipe and fittings shall be of PVC compound Type 1, Grade 1, conforming to ASTM D1785 Specifications. The pipe and fittings shall be approved and certified by the National Sanitation Foundation. Pipe and fittings shall be free from defects in materials, workmanship, and handling. The Engineer may require dimensional and quick burst tests of pipe and fittings after arrival at the job site. Acceptance of the materials shall be subject to passing the designated tests per ASTM Standards.

PVC solvent weld pipe shall be of PVC 1120 material and shall have 200 psi minimum pressure rating with SDR 21 walls which conform to ASTM D2241. PVC pipe with walls heavier than SDR 21 shall be installed when noted in the Plans and specified in the Special Provisions. PVC threaded pipe shall be of PVC 1120 material and shall be schedule 80 which conforms to ASTM D1785.

PVC pipe fittings shall conform to ASTM D2466, Type I, Grades 1 or 2. Pipe may be belled on one end with the dimensions of the tapered bell conforming to ASTM D2672.

Each length of PVC pipe is to be marked with an identifying extrusion “run” number and the manufacturer’s name or trade name plus the pipe size and schedule.

9-15.1(3) Polyethylene Pipe

Polyethylene pipe shall be Class 80, SDR 15, medium density polyethylene pipe, meet the requirements of ASTM D2239, conform to U.S. Commercial Standard CS-255, and be National Sanitation Foundation (NSF) approved.

Thick walled polyethylene (poly) pipe shall be used in conjunction with fittings recommended by the manufacturer of the poly pipe to produce a flexible swing joint assembly between the lateral line and the irrigation head. The pipe shall be manufactured from high quality, low density virgin polyethylene material and have a minimum wall thickness of 0.10 inch and a minimum inside diameter of 0.49 inch. The pipe shall be capable of withstanding 80 psi operating water pressure at 110°F. The length of thick walled poly pipe at each flexible swing joint assembly shall be 18 inches minimum to 36 inches maximum.

9-15.2 Drip Tubing

Drip tubing shall be manufactured from specially formulated, chemical resistant, low to medium density virgin polyethylene or polybutylene selected for excellent weatherability and stress cracking resistance and designed specifically for use in drip irrigation systems. Drip tubing shall have a minimum wall thickness of 0.045 inch.

9-15.3 Automatic Controllers

The automatic controller shall be an electronic timing device for automatically opening and closing control valves for predetermined periods of time. The automatic controller shall be enclosed in a weatherproof painted metal housing fabricated from 16-gauge sheet aluminum alloy 6061-T6 or 16-gauge sheet steel or unpainted, nonrusting industrial grade stainless steel. The pedestal shall have a completely removable locking faceplate to allow easy access to wiring.

The automatic controller housing shall have hasp and lock or a locking device. All locks or locking devices shall be master keyed, and three sets of keys shall be provided to the Engineer. The controller shall be compatible with and capable of operating the irrigation system as designed and constructed and shall include the following operating features:

1. Each controller station shall be adjustable for setting to remain open for any desired period of time, from 5 minutes or less to at least 99 minutes.
2. Adjustments shall be provided whereby any number of days may be omitted and whereby any one or more positions on the controller can be skipped. When adjustments are made, they shall continue automatically within a 14-day cycle until the operator desires to make new adjustments.
3. Controls shall allow any position to be operated manually, both on or off, whenever desired, without disrupting the 14-day cycle.
4. Controls shall provide for resetting the start of the irrigation cycle at any time and advancing from one position to another.
5. Controllers shall contain a power on-off switch and fuse assembly.
6. Output shall be 24-volt AC with battery back-up for memory retention of the 14-day cycle.
7. Each controller shall have both normally-open or normally-closed rain sensor compatibility.

9-15.4 Irrigation Heads

Irrigation heads shall be of the type, pattern, and coverage shown in the Plans at rated operating pressure specified, discharging not more than the amount of gallons per minute listed.

Sprinkler heads shall be designed so that spray adjustments can be made by either an adjustment screw or interchangeable nozzles. Watering cores shall be easily removed without removing the housing from the pipe.

All instructions, special wrenches, clamps, tools, and equipment supplied by the manufacturer necessary for the installation and maintenance of the irrigation heads shall be turned over to the Engineer upon completion and acceptance of the project.

9-15.5 Valve Boxes

Valve boxes shall conform to the Plans and be extendable to obtain the depth required. All manual drain valves and manual control valves shall be installed in valve box with a vandal-resistant lid as shown in the Plans.

9-15.6 Gate Valves

Valves shall be of the same size as the pipes on which they are placed and shall have union or flange connections. Service rating (for nonshock cold water) shall be 150 psi. Valves shall be of the double disk, taper seat type, with rising stem, union bonnet and hand wheel or suitable cross wheel for standard key operation. Manufacturer's name, type of valve, and size shall be imprinted or printed on the valve.

9-15.7 Control Valves

9-15.7(1) Manual Control Valves

Manual valves shall be angle type. Service rating shall be not less than 150 psi nonshock cold water. Valves shall be designed for underground installation with suitable cross wheel for operation with a standard key. The Contractor shall furnish three suitable operating keys. Valves shall have removable bonnet and stem assemblies with adjustable packing glands and shall house long acme threaded stems to ensure full opening and closing.

9-15.7(2) Automatic Control Valves

Automatic remote control valves shall be globe pattern with flanged or screwed connections as required. The valve shall be constructed so as to allow all internal parts to be removable from the top of the valve without disturbing the valve installation.

Valves shall be of a normally-closed design and shall be operated by an electronic solenoid having a maximum rating of 6.5 watts utilizing 24-volt AC power. Electronic solenoids shall have a stainless steel plunger and be directly attached to the valve bonnets or body with all control parts fully encapsulated. Valves shall be of 200 psi heavy-duty glass filled nylon and a standard product of a reputable manufacturer of irrigation valves and equipment. The opening and closing speed of the valve shall be a minimum of five

seconds for closure and a minimum of three seconds for opening with a constant rate of opening and closing. A manual control bleed cock shall be included on the valve to operate the valve without the requirement of electrical current. A manual shutoff stem with cross handle for wrench operation is required for manual adjustment from fully closed to wide open. Once the manual adjustment is set, the valve shall operate automatically in the adjusted position. Water flow shall be completely stopped when the control valve is closed either manually or automatically. Automatic control valves and automatic controllers need not be from the same manufacturer.

9-15.7(3) Automatic Control Valves With Pressure Regulator

Automatic control valves with pressure regulators shall be similar to the automatic control valves described in Section 9-15.7(2) and shall reduce the inlet pressure to a constant pressure regardless of supply fluctuations. The regulator must be fully adjustable.

9-15.8 Quick Coupling Equipment

Quick coupler valves shall have a service rating of not less than 125 psi for nonshock cold water. The body of the valves shall be of cast Copper Alloy No. C84400 Leaded Semi-Red Brass conforming to ASTM B584. The base of the valve shall have standard female pipe threads. The design of the valve shall be such that it will open only upon inserting a coupler key and will close as the coupler is removed from the valve. Leakage of water between the coupler and valve body when in operation shall not be accepted. The valve body receiving the coupler shall be designed with double worm slots to allow smooth action in opening and closing of the valve with a minimum of effort. Slots shall be notched at the base to hold the coupler firmly in the open position. Couplers shall be of the same material as the valve body with stainless steel double guide lugs to fit the worm slots. Couplers shall be of one piece construction with steel reinforced side handles attached. All couplers shall have standard male pipe threads at the top. Couplers shall be furnished with all quick coupler valves unless otherwise specified.

9-15.9 Drain Valves

Drain valves may be a ½- or ¾-inch PVC or metal gate valve manufactured for irrigation systems. Valves shall be designed for underground installation with suitable cross wheel for operation with a standard key, and shall have a service rating of not less than 150 psi nonshock cold water. The Contractor shall furnish three standard operating keys per Contract. Drain valves shall be installed in a valve box with a vandal-resistant lid as shown in the Plans.

Drain valves on potable water systems shall only be allowed on the downstream side of approved cross-connection control devices.

9-15.10 Hose Bibs

Hose bibs shall be angle type, constructed of bronze or brass, threaded to accommodate a ¾-inch hose connection, and shall be key operated. Design shall be such as to prevent operation by wrench or pliers.

9-15.11 Cross Connection Control Devices

Atmospheric vacuum breaker assemblies (AVBAs), pressure vacuum breaker assemblies (PVBAs), double check valve assemblies (DCVAs), and reduced pressure backflow devices (RPBDs) shall be of a manufacturer and product model approved for use by the Washington State Department of Health, Olympia, Washington, or a Department of Health-certified agency.

9-15.12 Check Valves

Adjustable spring check valves shall be PVC and shall be pressure rated at 200 psi. Valves shall be adjustable from 5 to 15 pounds spring tension, but shall not cause pressure loss in excess of 5 psi for flows up to 30 gpm. Valves shall have angled seats, Buna-N seals, and threaded connections, and shall be installed in 8-inch-round plastic valve boxes with vandal-resistant lids.

9-15.13 Pressure Regulating Valves

Pressure regulating valves shall have a minimum of 150 psi working pressure with an adjustable outlet range of 20 to 70 psi. The valves shall be factory set as shown in the Plans. Pressure regulating valves shall be rated for safe operation at 175 psi nonshock cold water.

9-15.14 Three-Way Valves

Three-way valves shall be tight closing, three port, ball or plug type, constructed to permit straight through and 90-degree flow only. The valve shall be of bronze or approved corrosion resistant body materials and shall have a minimum of 150 psi working pressure. The head of the valve, or handle when applicable, shall be permanently marked to indicate port position. When handles are included as an integral part of the valves, the Contractor shall remove the handles and give them to the Engineer.

9-15.15 Flow Control Valves

Valve body materials shall be plastic or metal. Internal parts shall be stainless steel. Valves shall be factory set to the flows as shown in the Plans. Valves shall have no external adjustment and be tamper-proof when installed. One-quarter inch and smaller flow control valves shall have a minimum pressure absorption range of 2 to 32 psi. One and one half inch and larger flow control valves shall have a minimum pressure absorption range of 3 to 50 psi.

Flow shall be controlled to 5 percent of Plan volumes.

9-15.16 Air Relief Valve

The air relief valve shall automatically relieve air and break a vacuum in the serviced pipe. Body materials shall be installed exactly at all high points.

9-15.17 Electrical Wire and Splices

Electrical wire used between the automatic controller and automatic control valves shall be solid or stranded copper, minimum size AWG 14. Insulation shall be Type USE Chemically Cross Linked Polyethylene or Type UF, and shall be listed by a Nationally Recognized Testing Laboratory. Each conductor shall be color coded and marked at each end and at all splices with zone or station number identification.

Low voltage splices shall be made with a direct bury splice kit using a twist-on wire connector and inserted in a waterproof polypropylene tube filled with a silicone electrical insulating gel or heat-shrinkable insulation tubing. Heat-shrinkable insulation tubing shall consist of a mastic-lined heavy-wall polyolefin cable sleeve.

9-15.18 Detectable Marking Tape

Detectable marking tape shall consist of inert polyethylene plastic that is impervious to all known alkalis, acids, chemical reagents, and solvents likely to be encountered in the soil, with a metallic foil core to provide for the most positive detection and pipeline location.

The tape shall be color coded and shall be imprinted continuously over its entire length in permanent black ink indicating the type of line buried below and shall also have the word “Caution” prominently shown. Color coding of the tape shall be as follows:

Utility	Tape Color
Water	Blue
Sewer	Green
Electrical	Red
Gas/Oil	Yellow
Telephone/CATV	Orange
Non-Potable Water	Purple

The width of the tape shall be as recommended by the manufacture based on depth of installation.

9-15.19 Wye Strainers

Wye strainers shall be bronze or brass with screwed end connections, 20 mesh Monel or stainless steel screen, and standard tapped bronze retainer cap and closure plug. Service rating shall be not less than 150 psii nonshock cold water.

9-16 Fence and Guardrail

9-16.1 Chain Link Fence and Gates

9-16.1(1) General

All material used in the construction of chain link fence and gates shall be new. Iron or steel material shall be galvanized unless specified otherwise. Material upon which serious abrasions of galvanizing occur shall not be acceptable.

9-16.1(1)A Post Material for Chain Link Fence

Except as noted otherwise, post material shall conform to the requirements of AASHTO M 181, Type I (zinc-coated steel), Grade 1 or 2, and shall include all round and roll-formed material (line posts, brace posts, end posts, corner posts, and pull posts).

Round Post Material

Round post material shall be Grade 1 or 2.

Roll Form Material

Roll-formed post material shall be Grade 1.

Roll-formed end, corner, and pull posts shall have integral fastening loops to connect to the fabric for the full length of each post.

Grade 1 post material shall conform to the weight per linear foot, minimum wall thickness and detail requirements of ASTM F1043. Grade 1 post material that exceeds the maximum wall thickness requirement of ASTM F1043 may be accepted, provided it does not interfere with the proper construction of the fence.

Grade 2 post material shall meet the organic exterior coatings requirements of AASHTO M 181 (Section 33) and the additional requirement that the interior coated surface shall be capable of resisting 300 hours of exposure to salt fog with a maximum of 5 percent red rust when tested in accordance with ASTM B117.

9-16.1(1)B Chain Link Fence Fabric

Chain link fabric shall consist of 11-gage wire for chain link fence Types 3, 4, and 6, and 9-gage wire for chain link fence Type 1. The fabric shall be zinc-coated steel wire conforming to AASHTO M 181, Class C. Zinc 5 percent Aluminum-Mischmetal alloy meeting the requirements of ASTM B750 may be substituted for zinc coating (hot-dipped) at the application rate specified by AASHTO M 181 for hot-dip zinc coating. Coating for chain link fence fabric shall meet the requirements of ASTM A817 with minimum weight of coating of uncoated wire surface 1.0 oz/sq ft (305 g/m^2). The wire shall be woven into approximately 2-inch diamond mesh. The width and top and bottom finish of the fabric shall be as specified in AASHTO M 181.

9-16.1(1)C Tension Wire

Tension wire shall meet the requirements of AASHTO M 181. Tension wire galvanizing shall be Class 1.

9-16.1(1)D Fittings and Hardware

Except where indicated, fittings shall be malleable cast iron or pressed steel and shall conform to the requirements of ASTM F626 or AASHTO M 232, whichever is applicable.

Tension truss rods shall be ⅜-inch round galvanized rods with drop forged turnbuckles or other approved type of adjustment. Couplings for tubular sections shall be outside sleeve type and shall be at least 6 inches long.

Eye bolts for attaching tension wire shall be ⅜-inch diameter and of sufficient length to fasten to the type of post being used.

Tension bars shall be 3/16 by ¾-inch nominal and cross sectional area shall be 0.141 in^2 ± 5 percent.

Hog rings shall be 12-gage galvanized steel wire. Tie wire shall be 9-gage galvanized steel wire or 9-gage aluminum wire meeting the requirements of ASTM F626.

Fabric bands and stretcher bars shall meet the requirements of Section 9-16.6(9).

9-16.1(1)E Chain Link Gates

Gate frames shall be constructed of not less than 1½-inch (I.D.) galvanized pipe conforming to AASHTO M 181 Type I, Grade 1 or 2, as specified in Section 9-16.1(1)A. The corners of the gate frame shall be fastened together and reinforced with a malleable iron or pressed steel fitting designed for the purpose, or they may be welded. Welding shall conform to the requirements of Section 6-03.3(25). All welds shall be ground smooth coated with paint conforming to Section 9-08.1(2)B. The paint shall be applied in one or more coats to provide a minimum dry film thickness of 3.5 mils.

Chain link fence fabric for filling the gate frame shall meet the requirements of Section 9-16.1(1)B for the fence type being furnished.

Cross trussing shall be 5/16-inch steel adjustable rods galvanized in accordance with Section 9-16.1(1)D.

Each gate shall be furnished complete with necessary hinges, latch, and drop bar locking device designed for the type of gate posts and gate used on the project. Gates shall have positive type latching devices with provisions for padlocking. Hinges, latches, and locking devices shall be galvanized in accordance with Section 9-16.1(1)D.

Gate frames constructed of steel sections, other than pipe, that are fabricated in such a manner as to form a gate of equal or better rigidity may be used provided they are approved by the Engineer.

9-16.1(1)F Concrete

All concrete for chain link fence shall be as specified in Section 6-02.3(2)B.

9-16.2 Wire Fence and Gates

9-16.2(1) General

All materials used in the construction of the wire fence shall be new. All iron or steel material shall be galvanized. Material upon which serious abrasions of galvanizing occur will not be acceptable.

9-16.2(1)A Steel Post Material

Round Post Material
Round post material shall conform to AASHTO M 181, Type I, Grade 1.

Angle Post Material (Channel, T, U, Y, or Other Approved Style)
All angle post material shall be galvanized in accordance with the requirements of AASHTO M 111, except the anchor plate on fence post material shall be Grade 55. Angle post used for end, corner, gate, and pull post and brace shall have a minimum weight of 3.1 lb/ft.

Posts shall not be less than 7 feet in length. A tolerance of -5 percent on the weight of individual posts, braces or anchor plates will be permitted. One type of line post shall be used throughout the project. Line posts shall be studded, slotted, or properly adapted for attaching either wire or mesh in a manner that will not damage the galvanizing of posts, wire or mesh during the fastening. Line posts shall have a minimum weight of 1.33 lbs/ft and shall be provided with a tapered galvanized steel anchor plate. The anchor plate shall be securely attached and have a surface area of 20 ±2 in^2, and a minimum weight of 0.67 pounds.

9-16.2(1)B Wood Fence Posts and Braces

Douglas fir, Western red cedar, hemlock, or larch shall be used in the construction of wood fence posts and braces. The material shall be of good quality and approved by the Engineer before use. Peeler cores shall not be used for round posts. Wood fencing materials shall have sufficient sapwood in the outer periphery to obtain the specified penetration of preservative. Western red cedar will not require preservative treatment. Fencing materials shall be cut to the correct length before pressure treatment.

Line posts shall be 3-inch minimum diameter round posts or nominal 3 by 3-inch square sawed posts. If the posts are to be pointed for driving, they shall be pointed before treatment. Line posts shall be at least 7 feet in length.

Pull posts and brace posts shall be 6-inch diameter round posts or nominal 6 by 6-inch material not less than 7 feet in length.

End, gate, and corner posts, and posts at an intersecting fence shall be 6-inch diameter round posts or nominal 6 by 6-inch material not less than 7′ 10″ in length.

All sawed posts and timbers shall meet the requirements in the table under Section 9-09.2.

The preservatives used to pressure treat wood fencing materials shall meet the requirements of Section 9-09.3.

The retention and penetration of the preservative shall be as follows:

Minimum Retention in Pounds Per Cubic Foot		
Preservative	**Sawed Posts**	**Round Posts**
Creosote	10.00	8.00
Pentachlorophenol	0.50	0.40
ACZA	0.40	0.40
CCA	0.40	0.40

Minimum Penetration

for material 5 inches or less – 0.40 inches penetration and 90 percent of sapwood

for material 5 inches or greater – 0.50 inches penetration and 90 percent of sapwood

9-16.2(1)C Brace Wire

Brace wire shall be 9 gage wire galvanized to meet the requirements of AASHTO M 279, Type Z, Class 1.

9-16.2(1)D Staples and Wire Clamps

The staples used to attach the wire fencing to wood posts shall be 9 gage wire, 1½ inches long, galvanized to meet the requirements of AASHTO M 279, Type Z, Class 1.

The wire clamps used to attach the wire fencing to steel posts shall be 11 gage wire, galvanized to meet the requirements of AASHTO M 279, Type Z, Class 1.

9-16.2(1)E Barbed Wire

Barbed wire shall conform to the requirements of AASHTO M 280, Type Z and shall consist of two strands of 12½-gage wire, twisted with four point 14-gage barbs with barbs spaced 5 inches apart (Design 12-4-5-14R). Galvanizing shall be Class 3.

9-16.2(1)F Wire Mesh

Wire mesh shall conform to the requirements of AASHTO M 279, Type Z and shall consist of eight horizontal wires with vertical stays spaced 6 inches apart. The top and bottom wires shall be 10 gage, and the intermediate wires and vertical stays shall be 12½ gage. The mesh shall have a total width of 32 inches (Design 832-6-12½). Galvanizing shall be Class 3.

The zinc coated wire as represented by the test specimens shall be capable of being wrapped in a close helix at a rate not exceeding 15 turns/minute around a cylindrical steel mandrel having a diameter the same as the specimen being tested, without cracking or flaking the zinc coating to such an extent that any zinc can be removed by rubbing with the bare fingers.

9-16.2(1)G Vertical Cinch Stays

Vertical cinch stays shall be 10 gage galvanized wire meeting the requirements of AASHTO M 279, Type Z, Class 1.

9-16.2(1)H Miscellaneous Hardware

Bolts, nuts, hinges, latches and other miscellaneous hardware shall be galvanized in accordance with AASHTO M 232.

9-16.2(1)I Wire Gates

Gate frames shall be constructed of galvanized pipe with a nominal diameter of not less than 1 inch. The pipe shall conform to the requirements of AASHTO M 181 Type I, Grade 1. Wire gates shall be not less than 48 inches in height and shall be designed to fit openings of the width called for in the Plans or as indicated by the Bid items. Each gate shall be provided with two upright braces of the same material as the frame, spaced at ⅓ points in the gate. All gates shall be provided with adjustable 5⁄16-inch diameter galvanized diagonal truss rods from corner to corner. Galvanizing shall be in accordance with Section 9-16.2(1)H.

The gate frame shall be provided with wire mesh conforming to the requirements specified in Section 9-16.2(1)F, except that it shall consist of 10 horizontal wires and have a total width of 47 inches.

Each gate shall be furnished complete with necessary galvanized hinges and latch designed for use with the type of gate posts used on the project. The hinges shall be so designed as to be securely attached to the gate post and to enable the gate to be swing back against the fence. Double gates shall be hinged in the same manner as single gates and shall be provided with an approved galvanized drop bar locking device. Galvanizing for hinges, latches, and locking devices shall be in accordance with Section 9-16.2(1)H.

9-16.2(1)J Concrete

All concrete for wire fence shall be as specified in Section 6-02.3(2)B.

9-16.3 Beam Guardrail

9-16.3(1) Rail Element

The W-beam or thrie beams rail elements, backup plates, reducer sections, and end sections shall conform to *A Guide to Standardized Highway Barrier Hardware* published by AASHTO, AGC, and ARTBA. All rail elements shall be formed from 12-gage steel except for thrie beam reducer sections, reduced length thrie beam rail elements, thrie beams used for bridge rail retrofits, and Design F end sections, which shall be formed from 10-gage steel.

The rail splices shall have a minimum total ultimate strength of 80,000 pounds at each joint.

The 6-inch channel rails and splice plates shall conform to ASTM A36, except that the channel rails may conform to ASTM A992. All fabrication shall be complete before galvanizing.

The holes in the plate shall be slotted to facilitate erection and to permit expansion and contraction. The edges of the rail shall be rolled or rounded so they will present no sharp edges. Where the rail is on a curve, the plates at the splice shall make contact throughout the area of splice. When the radius of curvature is less than 150 feet, the rail shall be shaped in the shop.

9-16.3(2) Posts and Blocks

Posts and blocks may be of creosote, pentachlorophenol, waterborne chromate copper arsenate (CCA), or ammoniacal copper zinc arsenate (ACZA), treated timber, or galvanized steel (galvanized steel posts only – no blocks). Blocks made from alternate materials that meet Manual for Assessing Safety Hardware (MASH) criteria may be used in accordance with the manufacturer's recommendations. Wood posts and blocks may be surface four sides (S4S) or rough sawn.

Posts and blocks shall be of the size, length, and type as shown in the Plans and shall meet the requirements of the below Specifications.

Timber posts and blocks shall conform to the grade specified in Section 9-09.2. Timber posts and blocks shall be fabricated as specified in the Plans before being treated. Timber posts and blocks shall be treated by the empty cell process to provide a minimum retention, depending on the treatment used, according to the following:

Creosote oil	10.0 lbs. pcf.
Pentachlorophenol	0.50 lbs. pcf.
ACZA	0.50 lbs. pcf.
CCA	0.50 lbs.pcf.

Treatment shall be in accordance with Section 9-09.3.

Galvanized steel posts, and base plates, where used, shall conform to either ASTM A36 or ASTM A992, and shall be galvanized in accordance with AASHTO M 111. Welding shall conform to Section 6-03.3(25). All fabrication shall be completed prior to galvanizing.

9-16.3(3) Galvanizing

W-beam or thrie beam rail elements and terminal sections shall be galvanized in accordance with AASHTO M 180, Class A, Type II. Channel rails, splice plates, WF steel posts, and base plates shall be galvanized in accordance with ASTM A123. Anchor cables shall be galvanized in accordance with Federal Specification RR-W-410, Table II, galvanized at finished size. Bolts, nuts, washers, plates, rods, and other hardware shall be galvanized in accordance with ASTM A153.

9-16.3(4) Hardware

Unfinished bolts (ordinary machine bolts), nuts, and washers for unfinished bolts, shall conform to Section 9-06.5(1). High-strength bolts, nuts, and washers for high-strength bolts shall conform to Section 9-06.5(3).

Unfinished bolts shall be accepted by field verification and documentation that bolt heads are stamped 307A. The Contractor shall submit a manufacturer's certificate of compliance per Section 1-06.3 for high-strength bolts, nuts, and washers prior to installing any of the hardware.

9-16.3(5) Anchors

Welding shall conform to Section 6-03.3(25).

All welding shall be equal in strength to the parent metal.

All fabrication shall be complete and ready for assembly before galvanizing. No punching, drilling, cutting, or welding will be permitted after galvanizing unless authorized by the Engineer.

Foundation tubes shall be fabricated from steel conforming to the requirements of ASTM A500, Grade B or ASTM A501.

The anchor plate assembly shall develop a minimum tensile strength of 40,000 pounds.

The anchor plate, W8 × 18, and metal plates shall be fabricated of steel conforming to the Specifications of ASTM A36, except that the W8 × 18 may conform to ASTM A992.

Anchor cable shall be ¾ inch preformed, 6 by 19 wire strand core or independent wire rope core (IWRC), galvanized, right regular lay manufactured of improved plow steel with a minimum breaking strength of 42,800 pounds. Two certified copies of mill test reports of the cable used shall be furnished to the Engineer.

Swaged cable fittings shall develop 100 percent of the specified breaking strength of the cable. One swaged fitting attached to 3 feet of cable shall be furnished to the Engineer for testing.

The swaged fitting and stud assembly shall be of steel conforming to the requirements of American Iron and Steel Institute C-1035 and shall be annealed and galvanized suitable for cold swaging.

All metal components of the anchor and cable assembly and not less than the top 14 inches of the W8 × 18 for the Type 2 anchor shall be galvanized in accordance with Section 9-16.3(3).

Cement concrete shall conform to the requirements of Section 6-02.3(2)B.

Cement grout shall conform to Section 9-20.3(4) and consist of one part portland cement or blended hydraulic cement and two parts sand.

9-16.3(6) Inspection and Acceptance

The Contractor shall give notice to the Engineer before the rail elements are fabricated in order that inspections may be provided. The Contractor shall arrange for all facilities necessary for the inspection of material and workmanship at the point of fabrication of the rail element, and inspectors shall be allowed free access to necessary parts of the premises.

The Inspector shall have the authority to reject materials or workmanship which do not fulfill the requirements of these Specifications. In cases of dispute, the Contractor may appeal to the Engineer, whose decision will be final.

The Inspector may accept a mill test report certifying that the steel used in fabricating the rail element meets the requirements of the Specifications. The Contracting Agency reserves the right, however, to require the Contractor to furnish samples of the steel proposed for use and to determine to its satisfaction that the steel meets the Specification requirements. Steel rail elements, fittings, end section hardware, and bolts may be accepted by the Engineer based on the Manufacturer's Certification of Compliance.

9-16.4 Wire Mesh Slope Protection

9-16.4(1) General

All metal material used in the construction of wire mesh slope protection shall be new and galvanized. Imperfectly galvanized material or material upon which serious abrasion of galvanizing occurs will not be acceptable.

9-16.4(2) Wire Mesh

The galvanized wire mesh shall be a Style 1 double-twisted hexagonal mesh conforming to ASTM A975 with 8 by 10 opening, except when a colorized, polyvinyl chloride coating is required then the Style shall be a Style 3.

The longitudinal edges of the wire mesh fabric shall have knuckled selvedges with continuous selvedge wire as specified in ASTM A975.

9-16.4(3) Wire Rope

Wire rope shall be ¾-inch-diameter, independent wire rope class (IWRC) 6x19, extra improved plow steel (EIP) wire rope galvanized in accordance with ASTM A1023. Each lot of wire rope shall be accompanied by a Manufacturer's Certificate of Compliance, a mill certificate, and a test report showing the wire rope meets the minimum breaking force requirements of ASTM A1023.

9-16.4(4) Hardware

Weldless steel rings shall be drop-forged steel and heat treated after forging; have a single pull, working load limit of at least 10,000 lbs; and meet performance requirements of Federal Specification RR-C-271D Type VI.

Thimbles required for all wire rope loops shall be standard weight, galvanized, and meet performance requirements of Federal Specification FF-T-276b Type II.

Wire rope clips shall have drop-forged steel bases, be galvanized, and meet performance requirements of Federal Specification FF-C-450 Type I Class 1.

9-16.4(5) Fasteners and Lacing Wire

Fasteners shall consist of 11 gauge high tensile steel. Lacing wire shall consist of 9 gauge, zinc-coated steel wire conforming to ASTM A641.

9-16.4(6) Ground Anchors

Threaded bar ground anchors shall be deformed, continuously threaded, steel reinforcement bars conforming to either Section 9-07.2 or Section 9-07.11. Threaded bar ground anchors shall be either epoxy-coated in accordance with Sections 6-02.3(24)H and 9-07.3 or galvanized after fabrication in accordance with ASTM A767 Class I.

Hollow-core anchor bars shall have continuous threads/deformations and be fabricated from steel tubing conforming to ASTM A519. Couplers and nuts shall provide 100 percent of the guaranteed minimum tensile strength of the hollow core anchor bars.

Bearing plates shall conform to ASTM A572 Grade 50 and shall be galvanized after fabrication in accordance with AASHTO M 111. Nuts shall conform to either AASHTO M 291 Grade B, hexagonal, or Section 9-07.11. Nuts shall be galvanized after fabrication in accordance with AASHTO M 111 for plate washers and AASHTO M 232 for all other hardware.

Grout for ground anchors shall be Grout Type 2 for Nonshrink Applications, conforming to Section 9-20.3(2).

Concrete for soil anchor deadmen shall be either commercial concrete conforming to Section 6-02.3(2)B or Class 3000 conforming to Section 6-02.

Steel reinforcing bars for soil anchor deadmen shall conform to Section 9-07.2, and shall be epoxy-coated in accordance with Sections 6-02.3(24)H and 9-07.3.

9-16.5 Vacant

9-16.6 Glare Screen

9-16.6(1) General

All material used in the construction of the fence shall be new. Iron or steel material shall be galvanized or aluminum coated as specified. Imperfectly galvanized or aluminum coated material, or material upon which serious abrasions of galvanizing or aluminum coating occur, will not be acceptable.

9-16.6(2) Glare Screen Fabric

Glare screen fabric shall consist of diamond woven wire mesh. The fabric wire may be 0.148-inch diameter aluminum alloy complying with the Aluminum Association requirements for alloy 6061T94, or it may be 0.148-inch diameter (9-gage) iron or steel wire which shall meet all of the requirements of ASTM A392 galvanized or ASTM A491 for aluminum coated, except that galvanizing of Type 2 glare screen fabric shall be not less than 0.8 ounce per square foot and shall be done before weaving. Aluminum coating shall be Class II.

Type 1 glare screen mesh size shall be approximately a 1 inch diamond. Type 2 glare screen mesh size shall be a maximum of 3½ inch vertical and 5½ inch horizontal. The design shall permit the slats to be installed in a vertical position as shown in the Plans without distortion of the slats.

9-16.6(3) Posts

Line posts for Types 1 and 2 glare screens shall be 2 inch inside diameter galvanized steel pipe with a nominal weight of 3.65 pounds per linear foot. End, corner, brace, and pull posts for Type 1 Design A and B and Type 2 shall be 2½ inch inside diameter galvanized steel pipe with a nominal weight of 5.79 pounds per linear foot. Intermediate pull posts (braced line posts) shall be as specified for line posts.

The base material for the manufacture of steel pipes used for posts shall conform to the requirements of ASTM A53, except the weight tolerance on tubular posts shall be applied as provided below.

Posts provided for glare screen will have an acceptance tolerance on the weight per linear foot, as specified, equal to plus or minus 5 percent. This tolerance will apply to each individual post.

All posts shall be galvanized in accordance with AASHTO M 181, Section 32. The minimum average zinc coating is per square foot of surface area. This area is defined as the total area inside and outside. A sample for computing the average of mass of coating is defined as a 12-inch piece cut from each end of the galvanized member.

9-16.6(4) Tension Wire

Top and bottom tension wire shall be 7 gage coil spring steel wire of good commercial quality and shall have a zinc coating averaging 0.8 ounces per square foot of surface area.

9-16.6(5) Vacant

9-16.6(6) Tension Wire Attachments

All tension wire attachments shall be galvanized steel conforming to the requirements of AASHTO M 232 unless otherwise specified. Eye bolts shall have either a shoulder or a back-up nut on the eye end and be provided with an eye nut where needed or standard hex nut and lock washer ⅜-inch diameter for tension wire and of sufficient length to fasten to the type of posts used. Turnbuckles shall be of the shackle end type, ½-inch diameter, with standard take-up of 6 inches and provided with ⅜-inch diameter pins.

9-16.6(7) Slats

9-16.6(7)A Wood Slats

Wood slats shall be ⅜ by 2⅜ inch by the height designation of the fence. Material shall be finished and treated cedar or redwood and shall be free from loose knots, cracks, and other imperfections. A dimensional tolerance of plus or minus 1⁄16 inch in width or thickness is allowed provided that the maximum space between slats does not exceed ¾ inch.

9-16.6(7)B Plastic Slats

Plastic slats shall be ⅜ by 2⅜ inch by the height designation of the fence. They shall be manufactured from tubular polyethylene color pigmented material consisting of high-density virgin polyethylene and color pigments, designed to retard ultraviolet penetration. The material shall have a minimum wall thickness of 0.0030 inch plus or minus 0.0003 inch and shall remain flexible without distortion and without becoming brittle through a temperature range of -70°F to + 250°F. Tensile strength shall be at least 3,600 psi and the melt index shall not exceed 0.25.

Plastic slats shall be retained in place by means of U-shaped retainer members at the bottom and top of the fence. Retainer members shall be of the same material as the slats.

The color for plastic slats will be approved by the Engineer from samples submitted by the Contractor or supplier.

9-16.6(8) Fittings

Fittings shall be malleable cast iron or pressed steel and galvanized in accordance with the requirements of AASHTO M 232.

Fittings for any particular fence shall be those furnished by the manufacturer of the fence.

9-16.6(9) Fabric Bands and Stretcher Bars

Fabric bands shall be ⅛ inch by 1-inch nominal. Stretcher bars shall be 3⁄16 inch by ¾ inch nominal or 5⁄16 inch diameter round bar nominal 5⁄16 inch diameter round stretcher bar shall be used with Type 1. Nominal shall be construed to be the area of the cross section of the shape obtained by multiplying the specified width by thickness. A variation of minus 5-percent from this theoretical area shall be construed as “nominal” size. All shall be galvanized to meet the requirements of ASTM F626.

9-16.6(10) Tie Wire and Hog Rings

Tie wire shall be 9-gage aluminum wire complying with the ASTM B211 for alloy 1100 H14 or 9-gage galvanized wire meeting the requirements of AASHTO M 279. Galvanizing shall be Class 1.

Hog rings shall be 12-gage galvanized steel wire.

9-17 Flexible Guide Posts

9-17.1 General

Flexible guide posts shall be made of a flexible, nonwarping, nonmetallic, durable plastic material; shall be resistant to damage due to impact, ultraviolet light, ozone, hydrocarbons, and other effects of atmospheric weathering; shall resist stiffening with age; and shall exhibit good workmanship and be free of burns, discoloration, contamination and other objectionable marks or defects that affect appearance or serviceability. The portion of ground mounted guide post installed below ground may be the same material as the portion above ground or other durable material suitable for firmly anchoring the post in the ground. When iron or steel are used for the in ground portion, galvanize in accordance with AASHTO M111. The top of tubular posts shall be closed to prevent moisture or debris from entering. Surface mounted guide posts shall be mounted on a base made of a rigid high impact resistant material and be resistant to ultraviolet light, ozone, and hydrocarbons. The post shall mount directly into or onto the base in a tamper proof manner and shall allow for easy replacement. Guardrail mounted guide posts shall be the same as ground mounted guide posts except the length shall be adjusted to meet the mounting height requirements in the *Standard Plans*. Appropriate holes shall be provided for fastening the guide post to the guard rail post.

The material composition of flexible guide posts subsequently furnished shall not vary from that of the samples upon which the State Materials Laboratory pre-approval is based. If analysis by the Materials Laboratory determines there is a change in material composition, such change shall constitute grounds for rejection and/or removal from the Qualified Products List.

The post system shall be designed for permanent installation to resist overturning, twisting, and displacement from wind and impact forces.

Each flexible guide post shall be permanently identified with the manufacturer's name, and the month and year of fabrication. Ground mounted guide posts shall have a permanent a mark indicating the recommended burial depth. The letters shall be solvent resistant, a minimum of ¼ inch in height, and permanently affixed to the post.

Unless otherwise specified, the color of the guide post shall be white or brown as indicated in the Plans.

The reflective panel on a flat or elliptical guide post shall have a minimum width of 3 inches facing traffic. The reflective sheeting shall have a minimum area of 24 square inches (3 by 8 inches). The reflective panel on a round guide post shall have an 8-inch minimum band of reflective sheeting visible for 360 degrees.

9-17.1(1) Dimensions

1. **Flat Type** – The post has a minimum width of 3 inches of continuous flat surface with no curvature for the entire length of the post. This will allow for ridges on the outer edges and back of post intended for structural support.
2. **Tubular Type** – The post is tubular or round/circular in shape. This allows for a tubular post with a minimum diameter of 3 inches or a tubular post with a minimum diameter of 2 inches with a flat or flattened oval surface at least 3 inches wide and 12 inches long measured from the top for mounting reflective sheeting.
3. **Non-flat and Non-Tubular Type** – This includes all post that do not fit into the two types indicated above. This would include convex, w-shape, oval, and other post designs. The post shall be wide enough to accept a 3-inch wide reflective sheeting. Any curvature or rounding shall not significantly reduce the brightness value of the reflective sheeting.
4. **Surface Mount Guide Post Base** – The base for surface mount guide posts shall be approximately 8 inches in diameter with a maximum height of 2 inches.
5. Guide posts shall be of such length to provide the required mounting height above the pavement surface in accordance with the *Standard Plans*.

9-17.1(2) Reflective Sheeting

Reflective sheeting for guide posts shall be Type III, IV, V, or VII conforming to Section 9-28.12. The reflective panel on a flat or elliptical guidepost shall have a minimum width of 3 inches facing traffic. The reflective sheeting shall have a minimum area of 24 square inches (3 by 8 inches). The reflective panel on a round guidepost shall have an 8-inch minimum band of reflective sheeting visible for 360 degrees. Mount the reflective sheeting on the guide post as detailed in the *Standard Plans*. Sheeting shall remain in place during the life of the post.

9-17.2 Ultraviolet Resistance Test Procedure (Laboratory Test)

Two posts will be tested initially for tensile strength and elongation according to ASTM D638 and again after 1,000 hours QUV weatherometer exposure (ASTM G53).

Six bow tie specimens shall be prepared from the delineator post samples submitted for the purpose of ultraviolet (UV) exposure. The specimens shall be cycled at 1,000 hours in a weatherometer in accordance with ASTM G53 (3 hr. 60C UV, 3 hr. 50C CON). Three of each type shall be used for control purposes. The remaining three shall be subjected to 1,000 hours of UV exposure in the QUV weatherometer. Specimen dimensions conform to those outlined below.

The laboratory test data shall summarize the tensile strength of each, and the average tensile strength for both control and weathered samples. The data shall also summarize the elongation of each, and the average elongation for both control and weathered samples. The average values shall be used to show the percent change in tensile and elongation.

9-17.2(1) Acceptance

The specimens shall show no signs of delamination, distress, or discoloration. Physical properties of tensile strength and rigidity shall be maintained within 80 percent of the unconditioned values.

9-17.3 Field Impact Test Procedure

Sample size of eight units will be tested the following way:

Flexible Ground Mounted Posts

Eight flexible ground mounted posts installed by the manufacturer (four installed manually and four installed mechanically). The delineators will be hit ten times (four posts for glancing bumper hits and four posts for wheel hits). A standard sedan with a bumper height of approximately 18 inches while traveling at a speed of 55 ± 2 mph will be used for impact testing. Five of the impacts will be at an ambient temperature of 32 ± 5°F and the remaining five impacts at an ambient temperature of 85 ± 5°F. The test vehicle shall impact four of the posts at an angle perpendicular to the front of the post and shall impact the remaining posts at an angle of 25 degrees clockwise from the angle perpendicular to the front of the posts. The same test samples will be used for the ten hits. Two flexible posts will be used for weatherometer testing. A glancing hit is defined as one on the bumper near the vehicle headlight. The delineators shall be installed a minimum of eight hours prior to being hit.

Flexible Surface Mounted Posts

Eight flexible surface mounted posts installed by the manufacturer will be hit ten times (four posts for glancing bumper hits and four posts for wheel hits). A standard sedan with a bumper height of approximately 18 inches while traveling at a speed of 55 ± 2 mph will be used for impact testing. Five of the impacts will be at an ambient temperature of 32 ± 5°F and the remaining five impacts at an ambient temperature of 85 ± 5°F. The test vehicle shall impact four of the posts at an angle perpendicular to the front of the post and shall impact the remaining posts at an angle of 25 degrees clockwise from the angle perpendicular to the front of the posts. The same test samples will be used for the ten hits. Two flexible posts will be used for weatherometer testing. A glancing hit is defined as one on the bumper near the vehicle headlight. The delineators shall be installed a minimum of eight hours prior to being hit.

9-17.3(1) Test Observations

Inspect each post after each impact and document the following:

1. Any splits, cracks, breaks, or other forms of deformation or distress;
2. The percent list to vertical 2 minutes after each impact;
3. The approximate percentage of the reflective area that is damaged after each impact to an extent it no longer performs as intended;
4. Any problems or comments associated with the installation and removal of the posts and bases. The testing agent will document any special equipment or techniques required for installing or removing the posts and bases.
5. Any problems or comments associated with the performance of each ground mounted flexible delineator post that would be of interest to the states;
6. Type of soil and impact surface.

9-17.3(2) Acceptance

A failure is defined as any of the following:

1. A minimum of 50 percent of the reflective sheeting shall be retained undamaged. An area of damage greater than 50 percent is considered a failure.
2. If the guide post leans more than 10 degrees from vertical it is considered a failure.
3. Any cracking, other than surface cracking evident on only one face of the post, is considered a failure.
4. Pullout in excess of 3 inches is considered a failure.

At least six of the guide posts must pass each criteria in the 55 ± 2 mph series of impacts to be acceptable.

9-17.4 Pre-approval

In order for a particular model of flexible guide post to become preapproved, the following conditions must be met:

1. The manufacturer must submit a written request for pre-approval along with samples for each model to be tested to: State Materials Engineer, Department of Transportation Materials Laboratory, PO Box 47365, Olympia, WA 98504-7365. Requests shall identify the model for which approval is being requested. Samples shall be complete with reflective panel attached, and shall be accompanied by the manufacturer's written installation procedures.
2. The guide posts will be field impact tested by the State Materials Laboratory to verify compliance with these Specifications.

3. In lieu of State Materials Laboratory testing, the Lab will accept the results of preapproved testing performed by the National Transportation Product Evaluation Program (NTPEP), the manufacturer, or other agencies under the following conditions:
   a. The State Materials Laboratory is informed of the preapproval testing sufficiently in advance in order to attend and observe. Attendance will be at the discretion of the Materials Laboratory.
   b. The results of the testing shall be reported in sufficient detail to enable the State Materials Laboratory to evaluate compliance with these Specifications.
4. The manufacturer must submit a certified test report, including test data developed by an approved testing laboratory, which demonstrates that the guide post complies with the requirements of these Specifications. Certified test data supplied by the manufacturer shall be subject to verification by appropriate tests conducted by the State Materials Laboratory.

Frequency of field testing, evaluation, and pre-approval updating shall be at the sole discretion of the State Materials Laboratory.

9-18 Precast Traffic Curb

9-18.1 Precast Traffic Curb

9-18.1(1) Aggregates and Proportioning

The cement, fine and coarse aggregate, and reinforcing steel to be used in the manufacture of precast concrete traffic curb shall meet the following requirements:

1. Portland cement or blended hydraulic cement shall conform to the requirements of Section 9-01 except that it may be Type I portland cement conforming to AASHTO M 85.
2. Aggregates shall conform to the requirements of Section 9-03 except that they shall be uniformly graded up to a maximum size of ⅜ inch and shall contain sufficient fine fractions to permit securing the type of surface finish specified herein. The aggregate shall be approved by the Materials Laboratory before it is used.
3. Reinforcing steel shall conform to the requirements of Section 9-07.1.
4. The cement concrete mix shall be composed of not less than one part portland cement to approximately two parts of fine aggregate and 3¼ parts of coarse aggregate adjusted to secure proper workability. The Contractor will be allowed to use a different concrete mix if approved by the Engineer, provided that it develops not less than 4,000 psi compressive strength when tested at the age of 28 days.

9-18.1(2) Mixing

The mixers shall be kept in good repair and be equipped with an automatic timing device and a positive device for regulating the quantity of water added to each batch. Such a device must be approved by the Engineer before use.

After all materials, including water, have been placed in the mixer, the materials shall be mixed for a period of not less than 1¾ minutes, or as much longer as may be necessary to produce a thorough and uniform mixture of the concrete. No water shall be added to any batch after the completion of the initial mixing period. Each batch of concrete shall be completely emptied from the mixer before placing more materials in it. A batch which has not been placed within 30 minutes from the time water was first added shall not be used.

The amount of water in the concrete shall be kept at a minimum consistent with the manufacture of dense curb, free from air bubbles and surface defects in excess of the tolerance limits specified.

9-18.1(3) Forms

Forms shall be of concrete or steel. The use of forms or molds made of plaster of paris, wood, or other absorptive material will not be permitted.

Bulkheads shall be tight fitting so that there is no leakage of mortar between the bulkhead and form.

The materials and methods used for lubricating the forms shall be such that they will not result in discoloration of the curb at any time. A minimum quantity of lubricant shall be used and all excess lubricant shall be removed.

9-18.1(4) Placing Concrete

The concrete shall be consolidated by external vibration, or by other means if approved by the Engineer, to produce a dense concrete throughout, having a minimum of air bubbles and honeycombing.

Reinforcing steel shall be placed and maintained in its proper position as shown in detail drawings.

Curb or buttons shall not be manufactured in an atmospheric temperature of less than 50°F.

9-18.1(5) Removal of Forms

The curb shall be removed from the molds or forms in accordance with the instructions or by some other method acceptable to the Engineer.

The loosening of the curb from the molds shall be carefully performed to avoid excessive shock and straining of the curb. When, in the opinion of the Engineer, undue shock is required to remove the curb from the molds, the stripping operation shall be deferred until such time as the curb may be removed without breakage.

9-18.1(6) Curing Concrete

Immediately after the concrete has been placed and consolidated in the mold, each unit shall be placed in a curing room fitted with water sprays and maintained at a relative humidity of not less than 90 percent and a temperature of not less than 60°F, nor more than 100°F. Each unit shall remain in the curing room for a period of not less than 10 days, except that if Type III cement is used, the period in the curing room may be reduced to 5 days.

9-18.1(7) Finish

The curb shall have a smooth, glassy finish on all exposed surfaces.

Excess honeycombing in the back of the curb may be cause for rejection of the curb. Honeycombing areas in the back of the curb which, in the opinion of the Engineer, are not detrimental to the curb need not be patched. The workmanship of the bottom finish shall be such that no mechanical interlocking of the mortar bed and the curb bottom or anchor groove will occur.

9-18.1(8) Surface Treatment

As soon as the units have been taken out of the curing room and thoroughly surface dried to a depth of at least ¼ inch, two coats of a water repellent compound, meeting the requirements of Section 9-18.4, shall be brush applied. When the first coat has dried, the second coat of water repellent compound shall be applied.

9-18.1(9) Dimensions and Shape

The curb shall conform to the dimensions and shape shown in the Plans within a tolerance of ¼ inch in length and ⅛ inch in alignment.

9-18.1(10) Curb Lengths

Curb lengths shall be in accordance with the *Standard Plans*, except in special cases where different lengths are specified. Circular curbing shall be made only for such radii as called for in the detail plans.

9-18.1(11) Defective Curb

Not more than 2 percent of the top area in any one piece of curb shall be defective, and not more than 5 percent of the total length of the top corners of reflecting faces in any one piece of curb shall be broken or rounded. There shall be not more than 50 holes in any linear foot of curb. All curb having defects in excess of any of the above will be rejected immediately upon inspection after removal from the forms. However, failure to reject the curb at that time will not ensure its final acceptance. Ninety percent of the curb laid shall not have more than 10 percent of the maximum allowable number of defects specified above.

An air hole shall be defined as any hole ⅛ inch or larger in diameter or depth.

All defects within the limits permitted, apparent upon removal of forms, shall be repaired immediately.

The sum of the length of the lines of discoloration caused by a cracked mold in any one piece of curb shall not exceed 50 percent of the length of the curb, and the maximum length of any single line of discoloration shall not exceed 18 inches. 75 percent of the curb laid shall be entirely free from lines of discoloration. The employment of heat to obliterate lines of discoloration will not be permitted. The process used to obliterate lines of discoloration shall be subject to the approval of the Engineer.

The repairing of molds which are chipped or broken shall be done in a manner that the broken or chipped areas will not be apparent on the curb made in those molds.

All curb in which surface checking develops during the first five days after manufacture will be rejected.

Hidden air holes at or immediately below the exposed surface of the curb, in excess of the limits specified that are disclosed by testing the surface by means of a rubber hammer will be cause for rejection of the curb.

All curb in which cracking is in evidence immediately after removal from the molds will be rejected. A crack is defined as any separation of the concrete of a continuous length greater than 3 inches.

All curb which varies in dimensions, alignment, or surface contour in excess of the tolerance specified will be rejected.

Failure to comply with the Plans, Specifications, or instructions of the authorized representative of the Contracting Agency in the manufacture and laying of any curb will be cause for rejection of such curb.

9-18.1(12) Repairing Curb

Curb having defects which are not sufficient cause for its rejection shall be neatly repaired immediately after removal from the molds in a manner subject to the approval of the Engineer. However, no patching or other repairs shall be made without the permission of the Engineer. Patches shall be undercut if, in the opinion of the Engineer, this operation is necessary to achieve a satisfactory patch.

All holes larger than $\frac{1}{16}$-inch diameter in the exposed surface of acceptable curb or buttons shall be filled with cement mortar.

9-18.1(13) Identification Marking

The date of manufacture, the length, and identification number corresponding to the detail layout shall be marked in black paint on the back or end of each piece of curb.

Rejected curb shall be marked on the back or end surfaces in a practical and semi-permanent manner to identify each cause of rejection.

9-18.1(14) Shipping

No unit of curb shall be shipped from the manufacturing plant prior to 21 days after manufacture, except, however, that if Type III cement has been used, the units may be shipped 14 days after manufacture.

9-18.1(15) Sampling and Inspection

The Contractor shall submit, for the approval of the Engineer, an advance sample of curb which shall be at least equivalent in color, surface texture, and bottom finish to the standard as set forth in these Specifications. No repairing of any kind shall be done on the advance sample. Upon approval, the advance sample shall be stored at the plant or site of manufacture in a location readily accessible to the Inspector where there is adequate daylight for examination. The advance sample shall be protected from damage and discoloration and shall be used as a standard of comparison for color, surface texture, and bottom finish for all curb manufactured. All curb furnished shall be equivalent in the foregoing respects.

The inspection at the plant will be made just prior to shipment, at which time examination will be made of the alignment, contour, color, cracks, surface damage or discoloration, broken corners or edges, and any other defects which may have developed, and to check the laboratory test reports for strength. However intermediate inspections may be made to determine surface checking and hidden air holes if it is impractical to examine for these defects at the final inspection.

9-18.2 Vacant

9-18.3 Vacant

9-18.4 Water Repellent Compound

The water repellent compound shall be a clear, penetrating type, silicone resin base compound containing no filler or other material which will leave a film on the surface of the masonry after it is applied. It shall be of such consistency that it can be applied readily by brush or spray to the masonry at atmospheric temperature down to -20°F.

The average absorption of three test specimens treated with the water repellent compound, when tested in accordance with the methods used in the State Materials Laboratory, shall not exceed 2 percent after being partially immersed in water for 72 hours immediately after curing.

The average moisture vapor transpiration (breathing) of three test specimens, when tested in accordance with the methods used in the State Materials Laboratory, shall be not less than 50 percent at 7 days.

The water repellent compound shall be approved by the State Materials Laboratory before it is used.

9-18.5 Sodium Metasilicate

Sodium metasilicate shall comply with ASTM D537.

9-19 Vacant

9-20 Concrete Patching Material, Grout, and Mortar

9-20.1 Patching Material for Cement Concrete Pavement

Concrete patching material will be prepackaged mortar extended with aggregate. The amount of aggregate for extension shall conform to the manufacturer's recommendation.

Patching mortar and patching mortar extended with aggregate shall contain cementitious material and conform to Sections 9-20.1(1) and 9-20.1(2). The Manufacturer shall use the services of a laboratory that has an equipment calibration verification system and a technician training and evaluation process in accordance with AASHTO R 18 to perform all tests specified in Section 9-20.1.

9-20.1(1) Patching Mortar

Patching mortar shall conform to the following requirements:

Compressive Strength	ASTM Test Method	Specification
at 3 hours	C 39	Minimum 3,000 psi
at 24 hours	C 39	Minimum 5,000 psi
Length Change		
at 28 days	C 157	0.15 percent maximum
Total Chloride Ion Content	C 1218	1 lb/yd^3 maximum
Bond Strength		
at 24 hours	C 882 (As modified by C 928, Section 9.5)	Minimum 1,000 psi
Scaling Resistance (at 25 cycles of freezing and thawing)	C 672 (As modified by C 928, Section 9.4)	1 lb/ft^2 maximum

9-20.1(2) Patching Mortar Extended With Aggregate

Patching mortar extended with aggregate shall meet the following requirements:

Compressive Strength	ASTM Test Method	Specification
at 3 hours	C 39	Minimum 3,000 psi
at 24 hours	C 39	Minimum 5,000 psi
Length Change		
at 28 days	C 157	0.15 percent maximum
Bond Strength		
at 24 hours	C 882 (As modified by ASTM C928, Section 9.5)	Minimum 1,000 psi
Scaling Resistance (at 25 cycles of freezing and thawing)	C 672	2 Maximum Visual Rating
Freeze thaw	C 666	Maximum expansion 0.10% Minimum durability 90.0%

9-20.1(3) Aggregate

Aggregate used to extend the patching mortar shall meet the requirements of Section 9-03.1(4) and be AASHTO Grading No. 8. A Manufacturer's Certificate of Compliance shall be required showing the aggregate source and the gradation. Mitigation for Alkali Silica Reaction (ASR) will not be required for the extender aggregate used for concrete patching material.

9-20.1(4) Water

Water shall meet the requirements of Section 9-25.1. The quantity of water shall be within the limits recommended by the manufacturer.

9-20.2 Patching Material for Concrete Structure Repair

Concrete patching material shall be a prepackaged mixture of portland or blended hydraulic cement, aggregate, and admixtures. Fly ash, ground granulated blast furnace slag and microsilica fume may be used. The concrete patching material may be shrinkage compensated. The concrete patching material shall also meet the following requirements:

- Compressive strength of 6000 psi or higher at 28 days in accordance with AASHTO T 22 (ASTM C 39), unless noted otherwise
- Bond strength of 250 psi or higher at 28 days or less in accordance with ASTM C 1583 or ICRI 210.3R
- Shrinkage shall be 0.05 percent (500 microstrain) or lower at 28 days in accordance with AASHTO T 160 (ASTM C 157) as modified by ICRI 320.3R
- Permeability shall be 2,000 coulombs or lower at 28 days in accordance with AASHTO T 277 (ASTM C 1202)
- Freeze-thaw resistance shall have a durability factor of 90 percent or higher after a minimum of 300 cycles in accordance with AASHTO T 161 Procedure A (ASTM C 666)
- Soluble chloride ion limits in Section 6-02.3(2) shall be satisfied

9-20.3 Grout

Grout is a mixture of Portland or blended hydraulic cement and water with or without aggregates and with or without admixtures. Grout may also contain fly ash and/or concrete admixtures. Grout may be a Contractor's submitted mix design or a Manufacturer's prepackaged grout product.

All prepackaged grouts shall be used in accordance with the manufacturer's recommendations, including but not limited to, shelf life, mixing, surface preparation, and curing.

Where required, all 2-inch cube specimens fabricated in the field shall be made in accordance with WSDOT T 813. All 2-inch cube specimens fabricated in a laboratory shall be made in accordance with FOP for AASHTO T 106. All 2-inch cube specimens shall be tested in accordance with FOP for AASHTO T 106.

When coarse aggregate is used, specimens shall be fabricated in accordance with FOP for AASHTO T 23 and tested in accordance with AASHTO T 22.

9-20.3(1) Grout Type 1 for Post-Tensioning Applications

Grout Type 1 shall be a Class C prepackaged, pumpable, nonbleed, nonshrink, and high-strength material conforming to the requirements of AASHTO *LRFD Bridge Construction Specifications* Section 10.9.3. The water/cement ratio shall not exceed 0.45.

9-20.3(2) Grout Type 2 for Nonshrink Applications

Grout Type 2 shall be a nonshrink, prepackaged material meeting the requirements of ASTM C1107. The minimum compressive strength shall be 4,000 psi at 7 days.

9-20.3(3) Grout Type 3 for Unconfined Applications

Grout Type 3 shall be a prepackaged material that does not include expansive admixtures meeting the following requirements:

- Compressive strength shall be 4000 psi or higher at 28 days in accordance with AASHTO T 22 (ASTM C 39) for grout extended with coarse aggregate or AASHTO T 106 (ASTM C109) otherwise.
- Bond strength shall meet one of the following:
  - 250 psi or higher at 28 days or less in accordance with ASTM C1583.
  - 2000 psi or higher at 28 days or less in accordance with ASTM C882. The following modification to ASTM C882 is acceptable: use Type 3 Grout in lieu of epoxy resin base bonding system and freshly mixed portland-cement mortar in the procedure for testing Type II and V systems.
- Drying shrinkage shall be 0.08 percent (800 microstrain) or lower at 28 days in accordance with AASHTO T 160 (ASTM C157). The following modification to AASHTO T 160 is acceptable: use a standard specimen size of 3 x 3 x 11-¼ inches.

9-20.3(4) Grout Type 4 for Multipurpose Applications

Grout Type 4 shall be a multipurpose grout material for structural and nonstructural applications. The grout shall be produced using portland cement Type I/II. The water to cementitious material ratio shall not exceed 0.45 and water-reducing admixtures may be used. Multipurpose grout may be extended up to three parts fine aggregate to one part cement. The minimum compressive strength shall be 4,000 psi at 7 days. Substitution of fly ash for cement is allowed up to 20 percent.

9-20.4 Mortar

Mortar shall be material made from Portland or blended hydraulic cement, water, and fine aggregate.

9-20.4(1) Fine Aggregate for Mortar

Fine Aggregate for mortar shall conform to the requirements of Section 9-03.2.

9-20.4(2) Mortar Type 1 for Concrete Surface Finish

Mortar Type 1 for concrete surface finishing shall be either prepackaged or a Contractor-recommended blend of portland cement Type I/II and fine aggregate conforming to Section 9-20.4(1). If the Class 1 concrete surface finishing mortar is a Contractor-recommended blend, it shall conform to the sand-to-cement ratios specified in Section 6-02.3(14)A.

9-20.4(3) Mortar Type 2 for Masonry Applications

Mortar Type 2 for masonry shall be either prepackaged or a Contractor-recommended blend of portland cement Type I/II and fine aggregate conforming to Section 9-20.4(1).

9-20.4(4) Mortar Type 3 for Concrete Repair

Mortar Type 3 shall be a prepackaged material that does not include expansive admixtures. Aggregate extension and mixing procedures shall be in accordance with the manufacturer's recommendation. The minimum compressive strength shall be 4,000 psi at 7 days.

9-20.5 Bridge Deck Repair Material

Bridge deck repair material shall be either an ultra-low viscosity, two-part liquid, polyurethane-hybrid polymer concrete, or a pre-packaged cement based repair mortar, conforming to the following requirements:

1. Minimum compressive strength of 2,500 psi, in accordance with ASTM C 109.
2. Total soluble chloride ion content by mass of product shall conform to the limits specified in Section 6-02.3(2) for reinforced concrete.
3. Permeability of less than 2,000 coulombs at 28-days or more in accordance with AASHTO T 277.

If pre-packaged deck repair material does not include coarse aggregate, the Contractor shall extend the mix with coarse aggregate as recommended by the manufacturer.

9-21 Raised Pavement Markers (RPM)

9-21.1 Raised Pavement Markers Type 1

9-21.1(1) Physical and Chemical Properties

The markers shall be of uniform composition and free from surface irregularities, cracks, checks, chipping, peeling, spalling, crazing, and other physical damage interfering with appearance, application, or durability.

The markers shall be precast in the form of a single based spheroidal segment terminating in a rounded or squared shoulder. Markers shall be white or yellow.

The markers shall meet the following requirements:

Property	Unit	Thermoplastic Markers	Plastic Markers
Mass	grams	N/A	125 min.
Height	inches	0.65-0.78	0.65-0.78
Diameter/Width	inches	3.85-4.05	3.85-4.05
Shoulder height	inches	0.08-0.22	0.08-0.22
Planeness of base:			
Concavity	inches	0.05 max.	0.05 max.
Convexity	inches	0.05 max.	0.05 max.
Reflectance (white only)	%MgO	80 min.	80 min.
Impact resistance	inch-pound	15 min.	15 min.
Titanium Dioxide (white only)	% by weight	N/A	21 min.

The markers passing laboratory tests will be field tested for approval. The field tests will include installation with control markers to determine relative adhesion and durability characteristics.

9-21.2 Raised Pavement Markers Type 2

9-21.2(1) Standard Raised Pavement Markers Type 2

The marker housing shall contain reflective faces as shown in the Plans to reflect incident light from either a single or opposite directions and meet the requirements of ASTM D 4280 including Flexural strength requirements.

9-21.2(2) Abrasion Resistant Raised Pavement Markers Type 2

Abrasion Resistant Raised Markers Type 2 shall comply with Section 9-21.2(1) and meet the requirements of ASTM D 4280 with the following additional requirement: The coefficient of luminous intensity of the markers shall be measured after subjecting the entire lens surface to the test described in ASTM D 4280 Section 9.5 using a sand drop apparatus. After the exposure described above, retroreflected values shall not be less than 0.5 times a nominal unblemished sample.

9-21.3 Raised Pavement Markers Type 3

Raised pavement markers Type 3 shall be extruded from high impact thermoplastic material which has been ultra-violet radiation stabilized and shall meet the following requirements:

Impact resistance	15 inch-lbs, min.
Reflectance (White Only)	80 percent min.
Concavity & Convexity	
Transverse	$\frac{1}{16}$ inch, max.
Longitudinal	$\frac{1}{8}$ inch, max
Base Width	4″
Length	6″, 8″, 10″ or 12″
Height	0.60-0.75″
Shoulder height	0.08-0.20

The ends shall be beveled from the top of the shoulder edge at a slope of 1:1 nominal.

9-22 Monument Cases

9-22.1 Monument Cases, Covers, and Risers

Castings for monument cases, covers, and risers shall be gray iron castings conforming to the requirements of AASHTO M306, Class 35B. The cover and seat shall be machined so as to have perfect contact around the entire circumference and full width of bearing surface. Dipping, painting, welding, plugging, or repairing defects will not be permitted.

9-23 Concrete Curing Materials and Admixtures

9-23.1 Sheet Materials for Curing Concrete

Sheet materials for curing concrete shall meet the requirements of ASTM C171, Sheet Materials for Curing Concrete, except that only white reflective type shall be used.

9-23.2 Liquid Membrane-Forming Concrete Curing Compounds

Liquid membrane-forming compounds for curing concrete shall conform to the requirements of ASTM C309 Type 1 or 2, Class A or B, except that the water retention when tested in accordance with WSDOT T 814 shall be 2.50 grams for all applications.

Each lot of liquid membrane-forming curing compound shall be sampled at the project site and tested for acceptance. Liquid membrane-forming curing compound shall not be used in the absence of satisfactory test results.

9-23.3 Vacant

9-23.4 Vacant

9-23.5 Burlap Cloth

Burlap cloth shall meet the requirements of AASHTO M182, Class 4.

9-23.6 Chemical Admixtures for Concrete

Acceptance of chemical admixtures will be based on Manufacturer's Certificate of Compliance. If required by the Engineer, admixtures shall be sampled and tested before they are used. A 1-pint (500-milliliter) sample of the admixture shall be submitted to the WSDOT Headquarters Materials Laboratory for testing 10 days prior to use. Chemical Admixtures shall contain less than 1 percent chloride ion (Cl-) by weight of admixture.

9-23.6(1) Air-Entraining Admixtures

Air-Entraining admixtures shall meet the requirements of AASHTO M154 or ASTM C260.

9-23.6(2) Type A Water-Reducing Admixtures

Type A Water-Reducing admixtures shall conform to the requirements of AASHTO M194 Type A or ASTM C494 Type A.

9-23.6(3) Type B Retarding Admixtures

Type B Retarding admixtures shall conform to the requirements of AASHTO M194 Type B or ASTM C494 Type B.

9-23.6(4) Type C Accelerating Admixtures

Type C Accelerating admixtures shall conform to the requirements of AASHTO M194 Type C or ASTM C494 Type C, and only nonchloride accelerating admixtures shall be used.

9-23.6(5) Type D Water-Reducing and Retarding Admixtures

Type D Water-Reducing and Retarding admixtures shall conform to the requirements of AASHTO M194 Type D or ASTM C494 Type D.

9-23.6(6) Type E Water-Reducing and Accelerating Admixtures

Type E Water-Reducing and Accelerating admixtures shall conform to the requirements of AASHTO M194 Type E or ASTM C494 Type E, and only nonchloride accelerating admixtures shall be used.

9-23.6(7) Type F Water-Reducing, High Range Admixtures

Type F Water-Reducing, High Range admixtures shall conform to the requirements of AASHTO M194 Type F or ASTM C494 Type F.

9-23.6(8) Type G Water-Reducing, High Range, and Retarding Admixtures

Type G Water-Reducing, High Range, and Retarding admixtures shall conform to the requirements of AASHTO M194 Type G or ASTM C494 Type G.

9-23.6(9) Type S Specific Performance Admixtures

Type S Specific Performance admixtures are limited to ASR-mitigating, viscosity modifying, shrinkage reducing, rheology-controlling, and workability-retaining admixtures. They shall conform to the requirements of ASTM C494 Type S. When a Type S admixture is used, a report on the performance characteristics of the Type S admixture shall be submitted along with the WSDOT concrete mix design (WSDOT Form 350-040). The report shall describe the performance characteristics and provide data substantiating the specific characteristics of the Type S admixture in accordance with ASTM C494.

9-23.7 Vacant

9-23.8 Waterproofing

Concrete made with waterproofing admixtures shall have a percent absorption after immersion and boiling of less than 5.0 percent at 7 days and a volume of permeable voids less than 11 percent at 7 days per ASTM C642. The Contractor shall submit evidence in the form of test results showing compliance with these specifications, when they submit their concrete mix design.

If the concrete requires air entrainment, the Contractor shall also submit evidence to the Engineer that the admixture will not adversely effect the air void system of the hardened concrete. Test results complying with ASTM C457 shall be provided as evidence to satisfy this requirement.

9-23.9 Fly Ash

Fly ash shall conform to the requirements of AASHTO M295 Class C or F including supplementary optional chemical requirements as set forth in Table 2.

Fly ash that exceeds the available alkali limits set in AASHTO M295 Table 2 may be used if they meet the tests requirements of Section 9-03.1(1). The supplementary optional chemical limits in AASHTO M295 Table 2 do not apply to fly ash used in Controlled Density Fill.

9-23.9(1) Tests and Acceptance

Fly ash may be accepted by the Engineer based on the Manufacturer's Mill Test Report Number indicating full conformance to the Specifications. All shipments of the fly ash to the Contractor or concrete supplier shall identify the applicable Mill Test Report Number. The concrete supplier or Contractor shall provide mill test identification on all concrete deliveries.

Fly ash producers, importers/distributors, and suppliers that certify fly ash shall participate in the fly ash acceptance program as described in WSDOT QC 4.

Each mixing facility or plant utilizing fly ash shall be equipped with a suitable means or device for obtaining a representative sample of the fly ash. The device shall enable the sample to be readily taken in proximity to the fly ash weigh hopper and from a container or conveyor holding only fly ash.

Fly ash may be tested using samples taken at the job site by the Engineer for submission to the State Materials Laboratory for testing.

9-23.10 Ground Granulated Blast Furnace Slag

Ground granulated blast furnace slag shall meet the requirements of AASHTO M 302, Grade 100 or Grade 120. The grade of the ground granulated blast furnace slag, the source, and type of manufacturing facility shall be certified on the cement mill test certificate.

9-23.10(1) Tests and Acceptance

Ground granulated blast furnace slag may be accepted by the Engineer based on the Manufacturer's Mill Test Report Number indicating full conformance to the Specifications. All shipments of the ground granulated blast furnace slag to the Contractor or concrete supplier shall identify the applicable Mill Test Report Number. The concrete supplier or Contractor shall provide mill test identification on all concrete deliveries.

Ground granulated blast furnace slag producers, importers/distributors, and suppliers that certify ground granulated blast furnace slag shall participate in the ground granulated blast furnace slag acceptance program as described in WSDOT QC 5.

Each mixing facility or plant utilizing ground granulated blast furnace slag shall be equipped with a suitable means or device for obtaining a representative sample of the ground granulated blast furnace slag. The device shall enable the sample to be readily taken in proximity to the ground granulated blast furnace slag weigh hopper and from a container or conveyor holding only ground granulated blast furnace slag.

Ground granulated blast furnace slag may be tested using samples taken at the job site by the Engineer for submission to the State Materials Laboratory for testing.

9-23.11 Microsilica Fume

Microsilica Fume shall conform to the requirements of AASHTO M307. The optional physical requirement for Reactivity with Cement Alkalies set forth in Table 3 will be required when Microsilica Fume is being used as an ASR mitigation measure.

9-23.12 Natural Pozzolan

Natural Pozzolans shall be ground Pumice and shall conform to the requirements of AASHTO M295 Class N, including supplementary optional chemical requirements as set forth in Table 2.

9-23.13 Blended Supplementary Cementitious Material

Blended Supplementary Cementitious Material (SCM) shall meet the requirements of ASTM C1697. Blended SCMs shall be limited to binary or ternary blends of fly ash, ground granulated blast furnace slag, and microsilica fume. Fly ash shall meet the requirements of Section 9-23.9. Ground granulated blast furnace slag shall meet the requirements of Section 9-23.10. Microsilica fume shall meet the requirements of Section 9-23.11. The individual SCMs composing the blended SCM shall be individually listed on the WSDOT Qualified Products List.

9-24 Plastic Waterstop

9-24.1 Material

The waterstops shall be fabricated from a plastic compound, the basic resin of which shall be polyvinyl chloride. The compound shall contain any additional resins, plasticizers, inhibitors, or other material such that when the material is compounded, it shall meet the performance requirements given in these Specifications.

Single-pass reworked material of the same composition generated from the fabricator's waterstop production may be used. No reclaimed polyvinyl chloride shall be used.

All waterstops shall be molded or extruded in such a manner that any cross section will be dense, homogeneous, and free from porosity and other imperfections.

The waterstops shall be symmetrical in shape, nominal 4 inches in width, by 3⁄16 inch thick, and a minimum of four ribs on each side of the bulb. The bulb thickness and diameter shall be as noted in the Plans.

9-24.1(1) Tests of Material

The waterstops shall meet all of the physical and other test requirements of this material as defined in the Corps of Engineers Specifications for Polyvinyl Chloride Water Stop CRD-C572, except that the tear resistance of the material shall be not less than 160 pounds per inch. The Contractor shall furnish such sample material as required by the Engineer for the purpose of making tests.

9-25 Water

9-25.1 Water for Concrete

Water for concrete, grout, and mortar shall be clear, apparently clean, and suitable for human consumption (potable). If the water contains substances that cause discoloration, unusual smell or taste, or other suspicious content, the Engineer may require the Contractor to provide test results documenting that the water meets the physical test requirements and chemical limits described in ASTM C1602 for nonpotable water.

Water from mixer washout operations may be used in concrete provided it meets or exceeds the above criteria as well as the following additional requirements:

1. Concrete with water from mixer washout operations shall not be used in bridge roadway deck slabs, flat slab bridge superstructures, modified concrete overlays, or prestressed concrete.
2. Specific Gravity shall not exceed 1.07.
3. Alkalies, expressed as [Na2O+0.658 K2O], shall not exceed 600 ppm.
4. Shall be free of coloring agents.
5. If the wash water contains admixtures from different manufacturers, the Contractor shall provide evidence that the combination of admixtures are compatible and do not adversely affect the air void system of the hardened concrete as per Section 6-02.3(3).
6. All tests to verify that the physical and chemical requirements are met, shall be conducted on the following schedule:
    a. The physical requirements shall be tested on weekly intervals for four weeks and thereafter on monthly intervals.
    b. The chemical requirements shall be tested on monthly intervals.
    c. The specific gravity shall be determined daily in accordance with ASTM D1429, Test Method D.

The Contractor shall use the services of a Laboratory that has a equipment calibration/verification system, and a technician training and evaluation process per AASHTO R 18 to conduct all tests. The laboratory shall use testing equipment that has been calibrated/verified at least once within the past 12 months to meet the requirements of each test procedure in accordance with the appropriate section of AASHTO R 18. Documentation of tester qualifications and equipment verification records shall be maintained and available for review by the Contracting Agency upon request. Agency reviews of the laboratory facility, testing equipment, personnel, and all qualification, calibration, and verification records will be conducted at the Contracting Agency's discretion.

9-25.2 Water for Plants

Water for plants shall not contain dissolved or suspended matter which will be harmful to the plant material on which it is to be used.

9-26 Epoxy Resins

9-26.1 Epoxy Bonding Agents

9-26.1(1) General

Epoxy bonding agents shall be two-component epoxy resin-base systems that meet the requirements of ASTM C881, shall be furnished in the type, grade, and class specified, and shall meet the requirements below. For pre-packaged cartridge kits, the epoxy bonding agent shall meet the requirements of ASTM C881 when mixed according to the manufacturer's instructions, utilizing the manufacturer's mixing nozzle. When not specified, an appropriate grade and class shall be selected for the particular application. Epoxy bonding agents for patching external concrete shall be concrete-gray in color.

9-26.1(1)A Type I and Type IV

Epoxy bonding agents used for bonding hardened concrete to hardened concrete and other materials shall be Type I for non-load bearing applications and Type IV for load bearing applications.

9-26.1(1)B Type II and Type V

Epoxy bonding agents used for bonding freshly mixed concrete to hardened concrete shall be Type II for non-load bearing applications and Type V for load bearing applications.

9-26.1(1)C Type III

Epoxy bonding agents used for bonding skid-resistant materials to hardened concrete and as a binder in epoxy mortars and epoxy concretes used on traffic bearing surfaces shall be Type III.

9-26.1(2) Packaging and Marking

The components of the epoxy system furnished under these Specifications shall be supplied in separate containers or pre-packaged cartridge kits that are non-reactive with the materials contained. The contents of each container shall be such that when the container contents are combined, a properly proportioned final mixture results.

Separate containers shall be marked by permanent marking that identify the formulator, "Component A" (Contains the Epoxy Resin) and "Component B" (Contains the Curing Agent), type, grade, class, lot or batch number, mixing instructions and the quantity contained in pounds or gallons as defined by these Specifications.

Pre-packaged cartridge kits shall be marked by permanent marking that identify the formulator, type, grade, class, lot or batch number, mixing instructions and the quantity contained in ounces or milliliters as defined by these Specifications.

Potential hazards shall be so stated on the package in accordance with the Federal Hazardous Products Labeling Act and State of Washington, Department of Labor and Industries Regulations for Shipment of Hazardous Products.

9-26.1(3) Certification

If requested by the Contracting Agency, the manufacturer of the epoxy system shall certify that components A and B meet the requirements of this Specification before a sample will be accepted for testing by the Contracting Agency. The Manufacturer's Certificate of Compliance shall be furnished in accordance with Section 1-06.3.

9-26.1(4) Rejection

Except as noted otherwise, the entire lot of both components may be rejected if samples submitted for test fail to meet any requirements of this Specification.

9-26.1(5) Acceptance

Acceptance of the Epoxy Bonding Agents for use on the project shall be based on a passing test report from the State Materials Laboratory.

9-26.2 Epoxy Adhesive for Lane Markers

9-26.2(1) General

Epoxy adhesives for lane markers shall meet the requirements of AASHTO M237 for Type II – Standard Setting, High Viscosity, Epoxy Adhesive. In lieu of the square base test specimen molds for the Slant Shear Strength test specified in AASHTO M237, cylindrical molds in accordance with ASTM C882 may be used.

9-26.2(2) Packaging and Marking

Packaging and Marking of Epoxy Adhesive for Lane Markers shall meet the requirements of Section 9-26.1(2).

9-26.2(3) Certification

Certification of Epoxy Adhesive for Lane Markers shall meet the requirements of Section 9-26.1(3).

9-26.2(4) Rejection

Rejection of Epoxy Adhesive for Lane Markers shall meet the requirements of Section 9-26.1(4).

9-26.2(5) Acceptance

Acceptance of each lot of the Epoxy Adhesive for Lane Markers for use on the project shall be based on a Manufacturer's Certificate of Compliance.

9-26.3 Epoxy Grout/Mortar/Concrete

9-26.3(1) General

This Specification shall apply to epoxy grout, epoxy mortar and epoxy concrete for traffic and non-traffic bearing applications. Epoxy grout/mortar/concrete shall consist of an epoxy bonding agent and an aggregate component.

Prepackaged epoxy grout/mortar/concrete shall be prepared from a ready-to-mix epoxy bonding agent/aggregate system supplied by a manufacturer in kit form.

Non-prepackaged epoxy grout/mortar/concrete shall be prepared from an epoxy bonding agent and an aggregate component that is clean, surface dry and inert and that is of a quality and gradation suitable for portland cement mortar or concrete. Aggregate meeting the requirements of Section 9-03.1(2) will be satisfactory. Epoxy grout/mortar/concrete for patching external concrete shall be concrete-gray in color.

9-26.3(1)A Traffic Bearing Applications

Epoxy grout/mortar/concrete for traffic bearing applications shall have a 7-day compressive strength of not less than 4,000 psi when tested in accordance with ASTM C579. Epoxy bonding agent shall be Type III as described in Section 9-26.1(1)C.

9-26.3(1)B Non-Traffic Bearing Applications

Epoxy grout/mortar/concrete for non-traffic bearing applications shall have a 7-day compressive strength of not less than 4,000 psi when tested in accordance with ASTM C579. Epoxy bonding agent shall be Type I, II, IV, or V as appropriate for intended use as described in Sections 9-26.1(1)A and 9-26.1(1)B.

9-26.3(2) Packaging and Marking

Packaging and Marking of the epoxy bonding agent component of epoxy grout/mortar/concrete shall meet the requirements of Section 9-26.1(2).

9-26.3(3) Certification

Certification of the epoxy bonding agent component of epoxy grout/mortar/concrete shall meet the requirements of Section 9-26.1(3).

9-26.3(4) Rejection

Rejection of the epoxy bonding agent component of epoxy grout/mortar/concrete shall meet the requirements of Section 9-26.1(4).

9-26.3(5) Acceptance

Acceptance of the epoxy grout/mortar/concrete material for use on the project shall be based on a passing test report from the State Materials Laboratory.

9-27 Cribbing

9-27.1 Vacant

9-27.2 Vacant

9-27.3 Gabion Cribbing

9-27.3(1) Gabion Fabric

Gabions may be fabricated from either hexagonal twisted wire or from welded wire. Only one type of wire and protective coating shall be used throughout a structure.

Baskets shall be furnished in the required dimensions with a dimensional tolerance of plus or minus 5 percent.

Wire for construction of gabions shall be either galvanized steel wire conforming to ASTM A641, Class 3, Soft Temper, or aluminized steel wire conforming to ASTM A809, Soft Temper. The wire shall have a minimum tensile strength of 60,000 psi when tested in accordance with ASTM A370.

9-27.3(2) Gabion Baskets

Gabion baskets 1 foot or greater in the vertical dimension shall have openings with nominal dimensions not to exceed 4½ inches and the maximum area of any opening shall not exceed 10 square inches.

1. **Hexagonal Twisted Wire**

   a. Wire for galvanized or aluminized hexagonal twisted welded wire shall be nominal sized 0.120 inch galvanized steel wire or aluminized steel wire.

   b. Hexagonal twisted wire shall be formed from galvanized or aluminized wire in a uniform hexagonal pattern with nonraveling double twist. The perimeter edges of each panel shall be tied to a selvage wire of the same composition as the panel body and have a minimum diameter of 0.150 inch so that the selvage is at least the same strength as the body of the panel.

2. **Welded Wire**

   a. Welded wire shall be fabricated from galvanized steel wire having a diameter of 0.106 inch. Wire shall be galvanized prior to fabrication.

   b. Welded wire shall be formed in a uniform square pattern with openings 3 by 3 inches with a resistance weld at each connection in accordance with ASTM A1064.

   c. If required, a PVC coating shall be fusion bonded onto the welded wire mesh to provide a nominal coating thickness of 0.0216 inch per side with a minimum of 0.0150 inch.

3. **PVC Coating (For Welded Wire Only)**

   Acceptance of PVC coating material shall be by certified test reports of an independent laboratory. The initial properties of PVC coating material shall have a demonstrated ability to conform to the following requirements:

   a. **Specific Gravity** – In the range of 1.2 to 1.4, when tested according to ASTM D792.

   b. **Tensile Strength** – Not less than 2,275 psi, when tested according to ASTM D638.

   c. **Modulus of Elasticity** – Not less than 1,980 psi at 100 Strain, when testing according to ASTM D638.

   d. **Hardness** – Shore "A" not less than 75 when tested according to ASTM D2240.

   e. **Brittleness Temperature** – Not higher than 15°F when tested according to ASTM D746.

   f. **Resistance to Abrasion** – The percentage of the mass loss shall be less than 12 percent when tested according to ASTM D1242, Method B at 200 cycles, CSI-A Abrader Tape, 80 Grit.

   g. **Salt Spray Exposure and Ultraviolet Light Exposure** – The PVC shall show no effect after 3,000 hours of salt spray exposure according to ASTM B117. The PVC shall show no effect of exposure to ultraviolet light with test exposure of 3,000 hours using apparatus Type E and 63°C, when tested according to Practice D1499 and Practice G 23. After the salt spray test and exposure to ultraviolet light as specified above, the PVC coating shall not show cracks, blister, split, nor show a noticeable change of color. In addition, the specific gravity, tensile strength, modulus of elasticity, and resistance to abrasion shall not change more than 6, 25, 25, and 10 percent respectively from their initial values.

9-27.3(3) Gabion Mattresses

Gabion baskets less than 1 foot in the vertical dimension shall have openings with nominal dimensions not to exceed 3.3 inches, and the maximum area of any opening shall not exceed 6 square inches.

1. **Hexagonal Twisted Wire**

   a. Wire for galvanized or aluminized hexagonal twisted wire shall be nominal sized 0.086 inch galvanized steel wire or aluminized steel wire.

   b. Hexagonal twisted wire shall be formed from galvanized or aluminized wire in a uniform hexagonal pattern with nonraveling double twisted. The perimeter edges of each panel shall be tied to a selvage wire of the same composition as the panel body and have a minimum diameter of 0.1062 inch so that the selvage is at least the same strength as the body of the panel.

2. **Welded Wire**

   a. Welded wire shall be fabricated from galvanized steel wire having a diameter of 0.080 inch. Wire shall be galvanized prior to fabrication.

   b. Welded wire shall be formed in a uniform rectangular pattern with openings 1½ by 3 inches with a resistance weld at each connection in accordance with ASTM A1064.

   c. If required, a PVC coating shall be fusion bonded onto the welded wire to provide a nominal coating thickness of 0.0216 inch per side with a minimum of 0.0150 inch. The PVC coating shall be in conformance with Section 9-27.3(2).

9-27.3(4) Fasteners for Basket Assembly

The lacing wire shall be a nominal sized 0.0866 inch galvanized steel wire or aluminized steel wire. Lacing wire shall have the same coating as the basket.

Spiral binders, if used for joining welded wire panels shall be formed from 0.106 inch nominal diameter steel wire with a 3-inch pitch having the same Specifications and coating as the welded wire. Lacing wire may be used in lieu of spiral binders.

Alternate fasteners for basket assembly shall remain closed when subjected to a 600 pound tensile force when confining the maximum number of wires to be confined. Installation procedures and test results for alternate fasteners shall be submitted for approval.

Internal connecting wires shall be the same as required for lacing wire. Alternate stiffeners acceptable to the gabion manufacturer may be used.

9-27.3(5) Nonraveling Construction

The gabion wire shall be fabricated in a manner to be nonraveling. This is defined as the ability to resist pulling apart at any of the connections forming the panel when a single strand in a section of panel is cut.

9-27.3(6) Stone

Stone for filling gabions shall have a Degradation Factor of at least 30. The stone shall be dense enough to pass the unit weight test described in Section 8-24.3(3)F. Stone shall meet the following requirements for gradation:

Sieve Size	Percent Passing
8″	100
6″	75-90
4″	0-10
% Fracture	75 min.

All percentages are by weight.

9-28 Signing Materials and Fabrication

9-28.1 General

Unless noted otherwise in the Plans, permanent signs shall be constructed of sheet aluminum. Permanent signs which measure 36 inches or less on a side and are to be mounted on a single post may be constructed of single 0.135-inch fiberglass reinforced plastic panels. Sign overlay panels may be either 0.050-inch aluminum or 0.075-inch fiberglass reinforced plastic panels. All signs, except internally illuminated signs, shall be reflectorized.

See ASTM D4956 for reflective sheeting type designations. Standard control signs and guide sign borders, letters, numerals, symbols, shields, and arrows shall be in accordance with the WSDOT *Sign Fabrication Manual* M 55-05.

All STOP, YIELD, DO NOT ENTER, WRONG WAY, FREEWAY ENTRANCE, and HIGHWAY ENTRANCE signs shall be constructed entirely of Type III or IV reflective sheeting. All M series, I series, and D-10 series signs and all signs with blue or brown backgrounds shall be constructed entirely of Type II reflective sheeting unless otherwise specified. Background reflective sheeting for all other signs shall be as noted in the Plans. Sign legends for all other signs shall be constructed of Type III or IV reflective sheeting. Sign legends include: borders, letters, numerals, symbols, shields, and arrows. Reflective legend sheeting types shall not be mixed on individual signs.

9-28.2 Manufacturer's Identification and Date

All signs shall show the manufacturer's name and date of manufacture on the back. In addition, the width and height dimension, in inches, the Contract number, and the number of the sign as it appears in the Plans shall be placed using 3-inch series C black letters on the back of destination, distance, and large special signs. Hand painted numbers are not permitted.

9-28.3 Corner Radius

All regulatory and warning signs shall have rounded corners with the exception of stop signs. Information and guide signs may have square cut corners. Borders for signs having square cut corners shall have a corner radius approximately ⅛ of the lesser side dimension of the sign up to a maximum radius of 12 inches. For signs with rounded corners, the borders shall be concentric with the rounded corners.

9-28.4 Extruded Windbeams and "Z" Bar

All multiple post and multiple panel signs shall be constructed and installed with horizontal extruded windbeams and "Z" bar, when required, as shown in the Plans or the *Standard Plans*. All bolt and rivet heads visible on the sign face shall be anodized or painted to match the sign area immediately surrounding the bolt or rivet head. Extruded windbeams and "Z" bar shall be accepted on the basis of a certificate of compliance from the manufacturer. Materials shall be as designated in Section 9-28.11.

9-28.5 Letter and Spacing Formula

Letter and arrow sizes shall be as specified in the Plans. Spacing formulas shall be those furnished by the manufacturer of the letters.

9-28.6 Destination Sign Messages

Destination sign messages, borders, shields, and symbols shall be direct applied unless otherwise noted in the sign plans. All message components shall be one piece construction unless the least dimension exceeds available sheeting widths. All components shall have smooth, sharp cut edges. Components which are torn, wrinkled, or exhibit poor workmanship, will not be permitted.

9-28.7 Process Colors

Transparent and opaque process colors used in silk screening sign messages shall be as recommended by the manufacturer. When properly applied, process colors shall perform satisfactorily for the expected life of the sheeting. Applied colors shall present a smooth surface, free from foreign material, and all messages and borders shall be clear and sharp. Sheeting shall conform to the retroreflective minimum values and color limits established for its type and color without regard to whether the color is integral to the sheeting or achieved by applying transparent colors to silver/white sheeting. There shall be no variations in color, and overlapping of colors will not be permitted.

Properly applied and cured process colors shall exhibit no blistering, bubbling, or loss of color or transparency when cleaned with a mild non-abrasive detergent solution. Minor loss of color may be detected when solvents such as kerosene, mineral spirits, heptane, or VM&P Naphtha are used to clean severely contaminated signs; e.g., paint vandalism. However, the colors shall not blister, bubble, peel, or be easily removed.

9-28.8 Sheet Aluminum Signs

Sheet aluminum signs shall be constructed of material conforming to ASTM B209 alloy 6061-T6 or alloy 5052-H36 or H38. Alloy 5005-H34 may be used for sign overlays. The Contractor shall provide a mill test certificate from the aluminum manufacturer attesting to the correct alloy and temper of the metal supplied, when requested by the Engineer.

After the sheeting has been fabricated, the surface of each panel shall be protected from corrosion. The corrosion protection shall meet the requirements of ASTM B449 Class II Specification for Chromates on Aluminum. Aluminum signs over 12 feet wide by 5 feet high shall be comprised of vertical panels in increments of 2, 3, or 4 feet wide. No more than one 2-foot and/or 3-foot panel may be used per sign. The Contractor shall use the widest panels possible. All parts necessary for assembly shall be constructed of aluminum, galvanized steel, or stainless steel in accordance with the Plans. Sheet thickness shall be as follows:

Maximum Horizontal Dimension	Sheet Aluminum Thickness
Overlay panels	0.050 inch
Up to 20 inches	0.063 inch
20 to 36 inches, inclusive	0.080 inch
Over 36 inches (Permanent Signs)	0.125 inch

The side dimension for a diamond shaped warning sign is considered to be the maximum horizontal dimension.

Before placing aluminum in contact with untreated steel, the steel surfaces shall be protected by proper cleaning and painting with one coat of paint conforming to Section 9-08.1(2)B and two coats of aluminum paint.

Metal shall be handled by device or clean canvas gloves between all cleaning and etching operations and the application of reflective sheeting.

9-28.9 Fiberglass Reinforced Plastic Signs

Fiberglass reinforced plastic signs and overlay panels shall be constructed of a fiberglass reinforced thermoset polyester laminate. The sign panel shall be acrylic modified and UV stabilized for outdoor weathering ability.

The sign panel shall be stabilized to prevent the release of migrating constituents (such as solvents, monomers, etc.) over the expected life of the sign. The sign panel shall contain no residue release agents on the surface of the laminate so neither migrating constituents or release agents will be present in amounts which will interfere with any subsequent bonding operations.

The sign panel shall not contain visible cracks, pinholes, foreign inclusions, or surface wrinkles that would affect implied performance, alter the specific dimensions of the panel, or otherwise affect its serviceability.

The sign panel surface shall be wiped clean with a slightly water dampened cloth before applying reflective sheeting.

9-28.9(1) Mechanical Properties

All mechanical properties are stated as minimum requirements. The mechanical properties are measured in both the line direction of the panel and at 90 degrees to the line as noted in the appropriate ASTM test referenced.

Mechanical Property	Ave. Min. Requirement	ASTM Test
Tensile Strength	10.0 psi × 10^3	D638
Tensile Modulus	1.2 psi × 10^6	D638
Flexural Strength	20.0 psi × 10^3	D790
Flexural Modulus	1.2 psi × 10^6	D790
Compression Strength	32.0 psi × 10^3	D695
Compression Modulus	1.4 psi × 10^6	D695
Punch Shear	12.0 psi × 10^3	D732

9-28.9(2) Physical Properties

Sign Panels are to be 0.135 inch thick. Overlay panels are to be 0.075 inch thick. Panel thickness tolerance shall be plus or minus 0.005 inch. Panel tolerance on nominal length and width shall be plus or minus ⅛ inch for dimensions of 12 feet or less and shall be within ⅛ inch of square per 12 feet of length when measured in accordance with ASTM D3841.

Panels shall be manufactured with smooth surfaces on both top and bottom of the panel.

Panel flatness of a 30 by 30-inch panel shall be measured by hanging the panel diagonally in suspension. The maximum deflection measured diagonally, parallel and perpendicular to the panel by lines drawn through the center of the panel, shall not exceed ½ inch. The panel shall then be hung diagonally in suspension in an oven for 48 hours at 180°F. The maximum deflection shall again be measured as previously noted and shall not exceed ½ inch. All measurements shall be made when panels are at ambient temperature.

Panels shall be pigmented to a visually uniform gray color within the MunselR range of N.7.5/to N.8.5/.

Panels shall have a maximum coefficient of lineal thermal expansion of 1.8 × 10^{-5} in/in/°F. when tested in accordance with ASTM D696.

Panels shall be classified as to a minimum Grade II (weather resistant) panel as specified in ASTM D3841 following 3,000 plus or minus 100 hour weatherometer test.

Panels shall contain additives designed to be less responsive to fire ignition and flame propagation. As such, the extent of burning shall not exceed 1.0 inch when tested in accordance with ASTM D635.

Panels shall resist the impact energy of 20 foot-pounds applied with a hemispherical tipped object 1 inch in diameter.

The panels thermal stability for strength and impact resistance qualities shall not be appreciably affected over a temperature range of -65°F to 212°F.

Fiberglass reinforced plastic panels for signs shall be accepted on the basis of a certificate of compliance from the manufacturer as outlined in Section 1-06.3.

9-28.10 Digital Printing

Transparent and opaque durable inks used in digital printed sign messages shall be as recommended by the manufacturer. When properly applied, digital printed colors shall have a warranty life of the base retroreflective sign sheeting. Digital applied colors shall present a smooth surface, free from foreign material, and all messages and borders shall be clear and sharp. Digital printed signs shall conform to 70% of the retroreflective minimum values established for its type and color. Digitally printed signs shall meet the daytime color and luminance, and nighttime color requirements of ASTM D 4956. No variations in color or overlapping of colors will be permitted. Digital printed permanent traffic signs shall have an integrated engineered match component clear protective overlay recommended by the sheeting manufacturer applied to the entire face of the sign. On Temporary construction/maintenance signs printed with black ink only, the protective overlay film is optional, as long as the finished sign has a warranty of a minimum of three years from sign sheeting manufacturer.

All digital printed traffic control signs shall be an integrated engineered match component system. The integrated engineered match component system shall consist of retroreflective sheeting, durable ink(s), and clear overlay film all from the same manufacturer applied to aluminum substrate conforming to Section 9-28.8.

The sign fabricator shall use an approved integrated engineered match component system as listed on the Qualified Products List (QPL). Each approved digital printer shall only use the compatible retroreflective sign sheeting manufacturer's engineered match component system products.

Each retroreflective sign sheeting manufacturer/integrated engineered match component system listed on the QPL shall certify a department approved sign fabricator is approved to operate their compatible digital printer. The sign fabricator shall re-certify annually with the retroreflective sign manufacturer to ensure their digital printer is still meeting manufacturer's specifications for traffic control signs. Documentation of each re-certification shall be submitted to the QPL Engineer annually.

9-28.11 Hardware

Bolts, nuts, locknuts, and washers shall be of the same material for each attachment. Bolts, nuts, locknuts, and washers for signs mounted on overhead sign structures (i.e., sign bridges, cantilevers sign structures, and bridge mounted sign brackets) shall be stainless steel only.

Hardware	Specification
Bolts	ASTM F468 2024-T4 Aluminum ASTM A307 Steel ASTM F593 Group 1, Condition A Stainless Steel, or ASTM A193, Grade B8, Class 1 Stainless Steel
U-bolts	ASTM A276 Type 304 Stainless Steel
Washers	ASTM B209 2024-T4 Aluminum ASTM F844 Steel ANSI B18.22.1 Stainless Steel Alloy 304
Nuts	ASTM F467 2024-T4 Aluminum ASTM A563 Grade A Steel ASTM F594 Group 1 Stainless Steel, or ASTM A194 Grade 8 or 8A Stainless Steel
Locknuts (with nylon insert unless otherwise in the Plans)	ASTM F467 2024-T4 Aluminum ASTM A563 Grade A Steel ASTM F594 Group 1 Stainless Steel, or noted ASTM A194 Grade 8 or 8A Stainless Steel
Rivets	ASTM B316 5052 Aluminum Alloy ASTM B316 5056 Aluminum Alloy
Post Clips	ASTM B179 356-T6 Aluminum
Windbeams	ASTM B221 6061-T6 Aluminum
Angle and “Z” Bar	ASTM B221 6061-T6 Aluminum ASTM A36 or ASTM A992 Steel
Strap and Mounting Bracket	ASTM A666, Type 201 Stainless Steel

All steel parts shall be galvanized in accordance with AASHTO M111. Steel bolts and related connecting hardware shall be galvanized in accordance with ASTM F 2329.

9-28.12 Reflective Sheeting

Type I and Type II reflective sheeting shall consist of spherical lens elements embedded within a transparent plastic having a smooth, flat outer surface. Type III and Type IV reflective sheeting shall consist of spherical or prismatic lens elements adhered to a synthetic resin and encapsulated by a flexible, transparent, weatherproof plastic having a smooth outer surface. Type V reflective sheeting shall consist of metallized microprismatic lens bonded to a flexible, smooth-surfaced, weather resistant polymeric film. Type VI reflective sheeting shall consist of unmetallized microprismatic lens formed on a flexible vinyl material. Type VII, VIII, IX and Type X Fluorescent Orange reflective sheeting shall consist of unmetallized microprismatic lens formed in a synthetic resin and encapsulated by a flexible, transparent, weatherproof plastic having a smooth outer surface. All sheeting shall be weather resistant and have a protected pre-coated adhesive backing. Type II reflective sheeting shall contain an identifying marking, such as a water mark, which is visible after sheeting application. The marking shall not adversely affect the performance or life of the sheeting.

The reflective sheeting shall have the following minimum coefficient of retroreflection values at 0.2 degrees and 0.5 degrees observation angle expressed as average candelas per foot-candle, per square foot of material. Measurements shall be conducted in accordance with ASTM E810.

Type I Glass Bead Retroreflective Element Material								
Obs. Angle	Entrance Angle	Silver White	Yellow	Orange	Green	Red	Blue	Brown
0.2°	-4°	70	50	25	9.0	14	4.0	1.0
0.2°	+30°	30	22	7.0	3.5	6.0	1.7	0.3
0.5°	-4°	30	25	13	4.5	7.5	2.0	0.3
0.5°	+30°	15	15	4.0	2.2	3.0	0.8	0.2

Type II Glass Bead Retroreflective Element Material								
Obs. Angle	Entrance Angle	White	Yellow	Orange	Green	Red	Blue	Brown
0.2°	-4°	140	100	60	30	30	10	5.0
0.2°	+30°	60	36	22	10	12	4.0	2.0
0.5°	-4°	50	33	20	9.0	10	3.0	2.0
0.5°	+30°	28	20	12	6.0	6.0	2.0	1.0

Type III Glass Bead Retroreflective Element Material								
Obs. Angle	Entrance Angle	Silver White	Yellow	Orange	Green	Red	Blue	Brown
0.2°	-4°	250	170	100	45	45	20	12
0.2°	+30°	150	100	60	25	25	11	8.5
0.5°	-4°	95	62	30	15	15	7.5	5.0
0.5°	+30°	65	45	25	10	10	5.0	3.5

Type IV Micro Prismatic Retroreflective Element Material							
Obs. Angle	Entrance Angle	White	Yellow	Green	Red	Blue	Brown
0.2°	-4°	250	170	35	35	20	7.0
0.2°	+30°	80	54	9	9	5.0	2.0
0.5°	-4°	135	100	17	17	10	4.0
0.5°	+30°	55	37	6.5	6.5	3.5	1.4

Type VI Vinyl Micro Prismatic Retroreflective Element Material							
Obs. Angle	Entrance Angle	White	Yellow	Orange	Green	Red	Blue
0.2°	-0.4°	250	170	70	30	35	20
0.2°	+30°	95	64	26	11	13	7.6
0.5°	-0.4°	200	136	56	24	28	18
0.5°	+30°	60	40	17	7.2	8.4	4.8

Type VII Micro Prismatic Retroreflective Element Material							
Obs. Angle	Entrance Angle	White	Yellow	Orange	Green	Red	Blue
0.2°	-0.4°	750	560	280	75	150	34
0.2°	+30°	430	320	160	43	86	20
0.5°	-0.4°	240	180	90	24	48	11
0.5°	+30°	135	100	50	14	27	6.0

Type VIII Micro Prismatic Retroreflective Element Material								
Obs. Angle	Entrance Angle	White	Yellow	Orange	Green	Red	Blue	Brown
0.2°	-0.4°	700	525	265	70	105	42	21
0.2°	+30°	325	245	120	33	49	20	10
0.5°	-0.4°	250	190	94	25	38	15	7.5
0.5°	+30°	115	86	43	12	17	7	3.5

Type IX Micro Prismatic Retroreflective Element Material							
Obs. Angle	Entrance Angle	White	Yellow	Orange	Green	Red	Blue
0.2°	-0.4°	380	285	145	38	76	17
0.2°	+30°	215	162	82	22	43	10
0.5°	-0.4°	240	180	90	24	48	11
0.5°	+30°	135	100	50	14	27	6.0
1.0	-0.4°	80	60	30	8.0	16	3.6
1.0	+30°	45	34	17	4.5	9.0	2.0

Type X Micro Prismatic Retroreflective Element Material		
Obs. Angle	**Entrance Angle**	**Fluorescent Orange**
0.2°	-0.4°	200
0.2°	+30°	90
0.5°	-0.4°	70
0.5°	+30°	26

The wet performance measurements on unweathered sheeting shall be conducted in accordance with one of the following methods:

1. The standard rainfall test specified in Federal Specification LS 300C and the brightness of the reflective sheeting totally wet by rain shall not be less than 90 percent of the above values.
2. Samples shall be submerged in a tank of clean water (approximately 72°F) for a period of 5 minutes. Reflex-reflective performance of the sheeting shall be viewed in a darkened room by reflected light through the surface of the water or through a transparent plane surface of the tank parallel to the sample surface. Light source shall be such as a hand flashlight held close to the eye. The wet sheeting shall show no apparent loss of reflective performance as compared to dry material.

The sheeting shall conform to the applicable daytime color and luminance factor requirements of ASTM D4956 when tested instrumentally in accordance with Section 8.4 of that Specification; OR, the diffuse day color of the reflective sheeting shall be visually evaluated by comparison with the applicable Highway Color Tolerance Chart. Color comparison shall be made under north daylight or a scientific daylight having a color temperature from 6500 degrees to 7500 degrees Kelvin. Daytime color evaluation shall be illuminated at 45 degrees and viewed at 90 degrees. There shall be no significant color shift when viewed under nighttime (retroreflective) conditions.

The reflective sheeting shall have a pre-coated pressure sensitive adhesive (Class 1) or a heat-activated adhesive (Class 2) either of which will adhere to flat, clean surfaces without necessity of additional adhesive coats on the reflective sheeting or application surface. Chemical activators shall not be used to activate Class 2 adhesive. The pre-coated adhesive shall be protected by an easily removed liner which, when removed, shall not have a staining effect on the reflective sheeting and shall be mildew resistant. The protective liner attached to the adhesive shall be removable by peeling without soaking in water or other solvents and shall be easily removed after storage for 4 hours at 150°F under weight of 215 psi. The sheeting with liner removed, conditioned for 24 hours at 72°F and 50 percent relative humidity, shall be sufficiently flexible to show no cracking when bent around a 1.2-inch diameter mandrel with the adhesive side contacting the mandrel. For ease of testing, talcum powder may be spread on the adhesive to prevent sticking to the mandrel. The sheeting surface shall be smooth and flat to facilitate self-cleaning in the rain, regular cleaning, and wet performance, and exhibit 85 degrees glossmeter rating of not less than 50 when tested in accordance with ASTM D523. The sheeting surface shall be readily processed and compatible with transparent and opaque process colors and show no loss of the color coat with normal handling, cutting, and

application. The sheeting shall permit cutting and color processing at temperatures of 60°F to 100°F and 20 to 80 percent RH. The sheeting shall be heat resistant and permit force curing without staining of unapplied sheeting or applied sheeting at temperatures recommended by the manufacturer not to exceed 150°F for unapplied sheeting or 200°F for applied sheeting. The sheeting surface shall be solvent resistant to permit cleaning by wiping with a clean soft cloth dampened with VM&P Naphtha or mineral spirits.

The adhesive shall form a durable bond to smooth, corrosion and weather resistant surfaces and permit the reflective sheeting to adhere securely, 48 hours after application at temperatures of -30°F to 200°F. The adhesive bond shall be sufficient to render the applied sheeting vandal-resistant and prevent its shocking off when subjected to an impact energy of 20 ft. lbs. applied with a hemispherical tipped object 1 inch in diameter at -0°F. The test specimen shall be applied to aluminum backing not less than 0.080 inch thick and having a dimension of not less than 4 inches square. During testing, the specimen shall be supported on a 3-inch diameter ring.

The adhesion test shall conform to ASTM D4956 with the addition of the temperatures noted above.

The resistance to accelerated weathering shall be as described in ASTM D4956 except the weathering apparatus and procedure shall be in accordance with ASTM G154.

The reflective sheeting shall be sufficiently flexible to be cut to shape easily and permit application over, and conform to, moderate shallow embossing characteristic of certain sign borders and symbols. The tensile strength of the sheeting shall be 5 to 20 pounds per square inch width when conditioned for 48 hours in accordance to ASTM D685 and tested in accordance with ASTM D828. Following liner removal, the reflective sheeting shall not shrink more than 1/32 inch in 10 minutes nor more than 1/8 inch in 24 hours in any dimension per 9 inch square at 72°F and 50 percent relative humidity.

The sheeting, when applied according to manufacturer's recommendations to cleaned and etched 0.020 by 2 by 8-inch aluminum, conditioned (24 hours) and tested at 72°F and 50 percent relative humidity, shall be sufficiently flexible to show no cracking when bent around a 3/4-inch diameter mandrel.

9-28.12(1) Application

The reflective sheeting shall be applied in the manner specified by the sheeting manufacturer. The applied sign face shall not have bubbles, wrinkles, or foreign material beneath the reflective sheeting.

9-28.12(2) Edge Treatment

All edges and splices of reflective sheeting signs shall be coated with an edge sealer when recommended by the manufacturer of the reflectorized sheeting.

9-28.12(3) Splices and Color Matching

Splicing of reflective sheeting shall not be permitted on signs or panels with dimensions up to and including 48 inches in height or width unless the reflective sheeting specified does not come in this width, then the widest width material shall be used. When sheeting joints are required, they shall be lap-jointed with the top sheet overlapping the bottom sheet by no less than 3⁄16 inch. The fabricator shall endeavor to use the least number of seams possible with the horizontal lap preferable. Roller applied or reverse screened sheeting may be butt-jointed with joint gap not to exceed 1⁄32 inch. Color matching of adjacent sheets of reflective sheeting comprising a sign shall be accomplished without a noticeable difference in color. No borders shall be spliced other than the splice of the tangent border to the corner radius.

9-28.13 Demountable Prismatic Reflectorized Message and Borders

The letters, digits, and alphabet accessories shall consist of embossed 0.040-inch thick sheet aluminum frames conforming to ASTM B209 grade 3003-H14 in which prismatic reflectors are installed to prevent their displacement in handling or service. Letters in which reflectors are assembled by means of tape are unacceptable. The plastic reflectors face shall be colorless and be entirely smooth to present a water repellent and dirt resistant surface. The area indicating the letter shape that is not reflectorized shall be white for maximum daytime contrast with the sign background. All letters shall be free of any imperfections and shall present a high quality appearance. Demountable prismatic border shall be comprised of a minimum length of 2 feet with allowance of one shorter section between each corner radius.

Letters shall be fastened to the sign with aluminum screws or blind rivets conforming to ASTM B209 grade 2024-T4.

The coefficient of retroreflection of each reflex reflector intended for use in cutout letters, symbols, and accessories shall be equal to or exceed the following minimum values with measurements made with reflectors spinning.

Observation Angle (Degrees)	Entrance Angle (Degrees)	Coefficient of Retroreflection Candle Power/Square inch/Foot Candle
0.1	0	14.0
0.1	20	5.6

Failure to meet the specific minimum values shall constitute failure of the reflector being used. Upon failure of more than two of the 50 samples tested, a resample of 100 reflectors shall be tested. Failure of more than four of these samples shall be cause for rejection of the lot.

9-28.14 Sign Support Structures

All sign support structures shall be constructed as shown in the Plans.

9-28.14(1) Timber Sign Posts

At the Contractor's options, timber sign posts and mileposts shall be treated Douglas Fir or treated Hem-Fir meeting the grades specified in Section 9-09.2. Douglas Fir and Hem-Fir posts shall be given a treatment in accordance with Section 9-09.3(1). Preservative and retention shall be as shown in Section 9-16.2 for sawn posts.

9-28.14(2) Steel Structures and Posts

Truss chords, struts, and diagonals, end posts, and end post struts and diagonals for sign bridge structures and cantilever sign structures shall conform to either ASTM A36 or ASTM A53 Grade B Type E or S. The nominal pipe diameter and the pipe wall thickness shall be as shown in the Plans or *Standard Plans*. All other structural steel for sign bridge structures and cantilever sign structures shall conform to either ASTM A36 or ASTM A992. Truss member connection hardware shall conform to Section 9-06.5(3).

Pipe members for bridge mounted sign brackets shall conform to ASTM A53 Grade B Type E or S, and shall be Schedule 40 unless otherwise specified. All other structural steel for bridge mounted sign brackets shall conform to either ASTM A36 or ASTM A992. U bolts, and associated nuts and washers, shall be stainless steel conforming to Section 9-28.11, and shall be fabricated hot.

Anchor rods for sign bridge and cantilever sign structure foundations shall conform to Section 9-06.5(4), including Supplemental Requirement S4 tested at -20°F. Nuts and washers for sign bridge and cantilever sign structure foundations shall conform to ASTM A563 Grade DH and ASTM F436, respectively.

Steel sign structures and posts shall be galvanized after fabrication in accordance with AASHTO M111, unless noted otherwise in the Plans. All bolts, nuts, and washers shall be galvanized after fabrication in accordance with ASTM F2329. Unless otherwise specified in the Plans or Special Provisions, metal surfaces shall not be painted.

Except as otherwise noted, steel used for sign structures and posts shall have a controlled silicon content of either 0.00 to 0.06 percent or 0.15 to 0.25 percent. Steel used for slip bases (SB-1, SB-2, SB-3) and heavy-duty anchors shall have a controlled silicon maximum of 0.40 percent. If the Plans or Special Provisions specify painting of the galvanized steel surfaces, then the controlled silicon content requirement does not apply for those steel members. Mill test certificates verifying the silicon content of the steel shall be submitted to both the galvanizer and the Engineer prior to beginning galvanizing operations.

Minor fabricating and modifications necessary for galvanizing will be allowed if not detrimental to the end product as determined by the Engineer. If such modifications are contemplated, the Contractor shall submit a Type 2 Working Drawing of the proposed modifications.

9-28.14(2)A Monotube Sign Bridge and Cantilever Sign Structures

Structural steel, except for cover plates, anchor rod templates and as otherwise shown in the Plans, shall conform to either ASTM A572 Grade 50, or ASTM A588. Cover plates shall conform to ASTM A36.

Handhole cover screws shall conform to ASTM F593, Grade 1.

Sign bracket bolts, nuts, and washers shall conform to Section 9-06.5(1).

Monotube splice bolts, mounting beam bolts, and associated nuts and washers, shall conform to ASTM F3125 Grade A325, and shall be galvanized after fabrication in accordance with ASTM F2329. Tension control bolts conforming to ASTM F 3125 Grade F1852 may be used as monotube splice bolts, and if used shall be galvanized after fabrication in accordance with ASTM B695 Class 55 Type I. Monotube sign bracket rods shall conform to Section 9-06.5(1) and shall be galvanized after fabrication in accordance with ASTM F2329.

Anchor rods and associated nuts and washers shall conform to Section 9-06.5(4) with supplemental requirement S4 tested at -20°F. Anchor rods shall be galvanized a minimum of 1'-0" at the exposed end in accordance with ASTM F2329. Nuts and washers shall be galvanized in accordance with ASTM F2329.

9-28.14(3) Aluminum Structures

Welding of aluminum shall be in accordance with AWS D1.2/D1.2M, latest edition, Structural Welding Code – Aluminum.

Aluminum alloy filler metals utilized on anodized structures shall result in color matching to base metals.

9-28.15 Vacant

9-29 Illumination, Signal, Electrical

9-29.1 Conduit, Innerduct, and Outerduct

Conduit shall be free from defects, including out of round and foreign inclusions. Conduit shall be uniform in color, density, and physical properties. The inside shall be smooth and free from burrs, which could damage cable during installation. Conduit ends shall be cut square to the inside diameter and supplied with thread protectors. All conduit, conduit fittings, and associated hardware/appurtenances shall be listed by a Nationally Recognized Testing Laboratory.

9-29.1(1) Rigid Metal Conduit, Galvanized Steel Outerduct, and Fittings

Rigid metal conduit shall be straight and be rigid galvanized steel or stainless steel, as required, and bear the mark of a Nationally Recognized Testing Laboratory. Exterior and interior surfaces of the galvanized steel conduit, except threaded ends, shall be uniformly and adequately zinc coated by a hot-dip galvanizing process. The average of the zinc coating shall comply with Federal Specification WW-C-581d.

9-29.1(2) Rigid Metal Conduit Fittings and Appurtenances

Couplings for rigid metal-type conduits may be either hot-dip or electroplated galvanized.

Conduit bodies and fittings for rigid steel conduit systems shall be listed by a Nationally Recognized Testing Laboratory listed for wet locations and shall be hot-dip galvanized malleable iron or bronze. Conduit bodies shall have tapered threads and include a bolt on cover with stainless steel screws and a neoprene gasket seal.

Grounding end bushings shall be bronze or galvanized malleable iron with copper, tinned copper, stainless steel, or integral lug with stainless steel clamping screw, mounting screw, and set screw.

Conduit clamps and straps shall be Type 304 or Type 316 stainless steel or hot-dip galvanized. Two-hole-type straps shall span the entire width of the support channel and attach to the supports on both sides of the conduit with bolts and associated hardware. Two-piece conduit clamps shall interlock with the support channel with a single bolt.

Conduit supports for surface-mounted conduit shall be hot-dip galvanized or Type 304 or Type 316 stainless steel channel using Type 304 or Type 316 stainless steel bolts and spring nuts.

9-29.1(2)A Expansion Fittings, Deflection Fittings, and Combination Expansion/Deflection Fittings

Expansion fittings for rigid galvanized steel conduit shall be weather tight, with hot-dip galvanized malleable or ductile iron end couplings and body and shall allow for 4 inches of movement minimum (2 inches in each direction). Expansion fittings for rigid galvanized steel conduit shall have an external tinned copper bonding jumper or an internal tinned copper bonding jumper. The internal tinned copper bonding jumper shall not reduce the conduit conductor capacity.

Deflection fittings for rigid galvanized steel conduit shall be weather tight, with hot-dip galvanized ductile iron or bronze end couplings, with molded neoprene sleeve, stainless steel bands, and internal tinned copper bonding jumper. Deflection fittings shall provide for conduit movement of ¾ inch in all directions and angular movement of 30 degrees in any direction.

A combination of a deflection and an expansion fitting for rigid galvanized steel conduit shall be assembled from a deflection fitting and an expansion fitting as defined above.

The bonding jumper used for expansion fittings and combination expansion deflection fittings shall be a tinned copper braid attached to the conduit with a galvanized “U” bolt-type connection designed for the application.

9-29.1(3) Flexible Metal Conduit

Liquidtight flexible metal conduit shall consist of a single strip of continuous flexible interlocked steel galvanized inside and out, forming a smooth internal wiring channel with a liquid tight covering of sunlight-resistant flexible PVC conforming to NEC Article 350.

9-29.1(3)A Flexible Metal Conduit Appurtenances

Liquidtight connectors shall be the insulated throat type, conforming to NEC Article 350, and listed for wet locations.

9-29.1(4) Non-Metallic Conduit

9-29.1(4)A Rigid PVC Conduit

Rigid PVC conduit shall conform to NEMA TC 2 and UL 651. Fittings shall conform to NEMA TC-3, and be UL 514C and UL 651.

PVC solvent cement shall meet ASTM D2564, including note 8 (label to show pipe sizes for which the cement is recommended).

9-29.1(4)B Expansion Fittings

Expansion fittings for use with PVC shall allow for 4 inches of movement minimum (2 inches in each direction). Expansion fittings for PVC conduit shall be PVC and have a threaded terminal adaptor or coupling end, and shall meet the requirements listed in Section 9-29.1(4)A.

9-29.1(4)C HDPE Conduit

HDPE conduit shall be listed by a Nationally Recognized Testing Laboratory recognized by the United States Department of Labor, Occupational Safety and Health Administration's Nationally Recognized Testing Laboratory (NRTL) Program. Couplings for HDPE shall be mechanical and listed for use with HDPE.

Aluminum mechanical couplings are prohibited.

9-29.1(4)D Deflection Fittings

Deflection Fittings for use with rigid PVC conduit shall be as described in Section 9-29.1(2)A.

9-29.1(5) Innerduct and Outerduct

The innerduct system shall be factory-installed and shall be designed so that expansion and contraction of the innerducts takes place in the coupling body to eliminate compatibility problems. The conduit coupling body shall have a factory-assembled gasket that is multistage and antireversing, sealing both the outerduct and innerducts. A secondary midbody O-ring gasket shall be seated into the coupling body and shall hold the coupling body firmly in the outerduct.

All fittings, adapters, and bends (sweeps) shall be provided and shall be manufactured from the same materials and manufacturing process as the conduit, except as specified otherwise. The conduit system shall be a complete system with the following accessories:

Manhole Terminator Kits	Conduit and Innerduct Plugs
Deflection Fittings	Pull string
Offset Fittings	Pull rope
Expansion/Contraction Fittings	Conduit spacers
Repair Kits	Split Plugs

9-29.1(5)A Rigid Galvanized Steel Outerduct With PVC or PE Innerduct

Each section of steel outerduct shall be supplied with one reversing spin coupling that allows straight sections and fittings to be joined without spinning the conduit. The reversing coupling shall be galvanized and have three setscrews or a lock nut ring to lock the coupling in place. Setscrews or lock nut ring shall be galvanized or stainless steel and ensure continuous electrical ground. The couplings shall be galvanized steel with the same material properties as the conduit.

The conduit system shall be designed so that assembly of components can be accomplished in the following steps:

1. Loosen setscrews or lock nut ring on coupling and spin back to allow for insertion.
2. Spin coupling mating sections forward to bottom.
3. Tighten setscrews on lock nut ring.

9-29.1(5)B Rigid PVC Outerduct With PVC or PE Innerduct

Protective outerduct for Schedule 40 PVC and Schedule 80 PVC conduit outerduct shall be 4 inch with a minimum 5-inch extended integral “bell end” and shall be gray in color. The outerduct minimum wall thickness shall be 0.23 inch for Schedule 40 PVC and 0.32 inch for Schedule 80 PVC.

Conduit and fittings for PVC outerduct shall be manufactured with an ultraviolet inhibitor.

The coupling body for PVC outerduct shall include a factory-assembled, multistage gasket that is antireversing, sealing both the outer and innerducts. A secondary midbody gasket shall be seated at the shoulder of the bell to ensure air and water integrity of the system. The bell end and the coupling body assembly shall accept a minimum of 5 inches of the spigot end.

The conduit system shall be designed so that straight sections and fittings will assemble without the need for lubricants or cement.

PVC outerduct shall have a longitudinal print-line that denotes “Install This Side Up” for proper innerduct alignment. PVC outerducts shall have a circumferential ring on the spigot end of the duct to provide a reference point for ensuring the proper insertion depth when connecting conduit ends. The line shall be a minimum of 5 inches from the end of the conduit.

9-29.1(5)C Innerduct for Straight Sections of Galvanized Steel Outerduct or PVC Outerduct

The innerducts shall have a minimum outside diameter of 1.25 inch and a minimum inside diameter of 1.2 inch. Larger-diameter innerducts may be provided if the wall thickness and diameter tolerances are met. The tolerance for inside and outside diameters shall be 0.005 inch. The innerducts shall have a minimum wall thickness of 0.060 inch. Innerduct shall be color coded and shall index a minimum of one innerduct with a different color. Alternate color codes are permitted as long as the color codes are contiguous between adjacent junction boxes. The innerducts shall be factory installed in the outerduct.

Dynamic coefficient of friction of innerducts shall be tested in accordance with Telcordia GR-356-CORE procedure. The coefficient of friction shall be less than 0.30 between medium-density polyethylene jacketed fiber optic cable and the prelubricated innerduct. The coefficient of friction shall be less than 0.10 between the ¼-inch diameter polypropylene rope (suitable for fiber optic cable pulling) and the prelubricated innerduct. Pull rope used for testing (meeting the 0.10 coefficient of friction requirement) shall be the same type as the pull rope used for cable installation. The Contractor shall provide as part of the conduit submittals a certificate of compliance with these coefficient of friction requirements.

The innerduct shall have a smooth, nonribbed interior surface, with a factory prelubricated coating. The coating shall provide the required dynamic coefficient of friction.

Innerduct shall be extruded polyvinyl chloride (PVC) or polyethylene (PE).

The coupling body for the innerduct shall be factory assembled in the bell end of the outerduct and shall be manufactured from a high-impact engineered thermoplastic. The coupling body face shall be supplied with lead-ins to facilitate assembly.

All outerduct shall be marked with data traceable to plant location.

9-29.1(5)D Conduit With Innerducts Fittings and Appurtenances

Duct plugs shall be polypropylene and be equipped with a neoprene or polyurethane gasket. Plugs shall be equipped with an attachment to secure the pull rope in the innerduct. The plug shall withstand 5 psi.

9-29.1(5)D1 Bends for 4-Inch PVC Conduit With Innerducts or Galvanized Steel Conduit With Innerducts

All bend radii shall be 36 inches or greater. The conduit system shall provide a complete line of fixed and flexible sweeps with system-compatible bell and spigot or threaded ends. The bends shall contain high-temperature burn-through-resistant innerducts manufactured from PVC, PE, or Nylon-66. The innerducts shall meet all other requirements for innerduct in Sections 9-29.1(1) and 9-29.1(5)A.

9-29.1(5)D2 Prefabricated Fixed and Flexible Bends (for Innerducts)

The prefabricated standard fixed PVC bends shall have a radius between 4 and 9 feet and sweep angles of 11.25, 22.5, 45, or 90 degrees.

Flexible bends shall be prefabricated. These conduits may be field bent to a uniform radius no less than 4 feet. The field bend shall be no greater than 90 degrees. Grounding shall be continuous in flexible bends. Outerduct for flexible ends shall be manufactured from reinforced PVC. Expansion and deflection fittings for rigid galvanized steel conduit with innerduct shall be provided in accordance with Section 9-29.1(2)A.

9-29.1(6) Detectable Underground Warning Tape

Detectable Underground Warning tape shall be Orange imprinted in black lettering with the message “FIBER OPTIC CABLE BURIED BELOW” or equal. The warning tape shall be polyethylene with a metallic backing. The polyethylene shall be a minimum 4 mils thick and 3 inches wide.

9-29.1(7) Steel Casings

Steel casing material shall conform to ASTM A252 Grade 2 or 3 or casing as approved by the Engineer. The Contractor shall furnish pipe of adequate thickness to withstand the forces exerted by the boring operation as well as those forces exerted by the earth during installation and shall be a minimum of ⅜ inch thick. All joints shall be welded by a welder qualified in accordance with AWS D1.1 structural welding code, Section 3.

9-29.1(8) Drilling Fluid

Drilling fluid used for directional boring shall be an inert mixture of water and bentonite clay, conforming to the drilling equipment manufacturer's recommendations.

9-29.1(9) Repair

Manufacturer repair kits shall be used for field repair of existing conduit, innerduct and outerduct. The conduit repair kit shall be manufactured specifically for the repair of existing damaged conduit, inner duct and outer duct. The repair kit shall be prepackaged and include the split conduit and split couplings necessary to restore the damaged conduit to the original inside dimensions including a water and air tight seal.

9-29.1(10) Pull Tape

Pull tape shall be pre-lubricated polyester pulling tape. The pull tape shall have a minimum width of ½-inch and a minimum tensile strength of 500 pounds. Pull tape may have measurement marks.

9-29.1(11) Foam Conduit Sealant

Foam conduit sealant shall be self-expanding waterproof foam designed to prevent both water and pest intrusion. The foam shall be designed for use in and around electrical equipment, including both insulated and bare conductors.

9-29.2 Junction Boxes, Cable Vaults, and Pull Boxes

The Contractor shall perform quality control inspection. The Contracting Agency intends to perform Quality Assurance Inspection. By its inspection, the Contracting Agency intends only to verify the quality of that Work. This inspection shall not relieve the Contractor of any responsibility for identifying and replacing defective material and workmanship. Prior to the start of production of the precast concrete units, the Contractor shall advise the Engineer of the production schedule. The Contractor shall give the Inspector safe and free access to the Work. If the Inspector observes any non-specification Work or unacceptable quality control practices, the Inspector will advise the plant manager. If the corrective action is not acceptable to the Engineer, the unit(s) will be rejected.

9-29.2(1) Junction Boxes

For the purposes of this Specification concrete is defined as portland cement or blended hydraulic cement concrete and non-concrete is all others.

The Contractor shall provide shop drawings for all components, hardware lid, frame, reinforcement, and box dimensions. The shop drawings shall be prepared by (or under the supervision of) a Professional Engineer, licensed under Title 18 RCW, State of Washington, in the branch of Civil or Structural. Each sheet shall carry the following:

1. Professional Engineer's original signature, date of signature, original seal, and registration number. If a complete assembly drawing is included which references additional drawing numbers, including revision numbers for those drawings, then only the complete assembly drawing is required to be stamped.
2. The initials and dates of all participating design professionals.
3. Clear notation of all revisions including identification of who authorized the revision, who made the revision, and the date of the revision.

Design calculations shall carry on the cover page, the Professional Engineer's original signature, date of signature, original seal, and registration number.

For each type of junction box, or whenever there is a change to the junction box design, a proof test, as defined in this Specification, shall be performed and new shop drawings submitted.

9-29.2(1)A Standard Duty Junction Boxes

Standard Duty Junction Boxes are defined as Type 1, 2 and 8 junction boxes and shall have a minimum load rating of 22,500 pounds and be tested in accordance with Section 9-29.2(5). A complete Type 8 Junction Box includes the spread footing shown in the *Standard Plans*. All Standard Duty Junction Boxes placed in sidewalks, walkways, and shared use paths shall have slip resistant surfaces. Non-slip lids and frames shall be hot dip galvanized in accordance with AASHTO M111.

9-29.2(1)A1 Concrete Junction Boxes

The Standard Duty Concrete Junction Box steel frame, lid support, and lid shall be painted with a black paint containing rust inhibiters or painted with a shop applied, inorganic zinc primer in accordance with Section 6-07.3, or hot-dip galvanized in accordance with AASHTO M 111.

Concrete used in Standard Duty Junction Boxes shall have a minimum compressive strength of 6,000 psi when reinforced with a welded wire hoop, or 4,000 psi when reinforced with welded wire fabric or fiber reinforcement. The frame shall be anchored to the box by welding headed studs ⅜ by 3 inches long, as specified in Section 9-06.15, to the frame. The wire fabric shall be attached to the studs and frame with standard tie practices. The box shall contain ten studs located near the centerline of the frame and box wall. The studs shall be placed one anchor in each corner, one at the middle of each width and two equally spaced on each length of the box.

Materials for Type 1, 2, and 8 Concrete Junction Boxes shall conform to the following:

Materials	Requirement
Concrete	Section 6-02
Reinforcing Steel	Section 9-07
Fiber Reinforcing	ASTM C1116, Type III
Lid	ASTM A786 diamond plate steel
Slip Resistant Lid	ASTM A36 steel
Frame	ASTM A786 diamond plate steel or ASTM A36 steel
Slip Resistant Frame	ASTM A36 steel
Lid Support	ASTM A36 steel, or ASTM A1011 SS Grade 36 (or higher)
Handle & Handle support	ASTM A36 steel, or ASTM A1011 CS (Any Grade) or SS (Any Grade)
Anchors (studs)	Section 9-06.15
Bolts, Studs, Nuts, Washers	ASTM F593 or A193, Type 304 or 316, or Stainless Steel grade 302, 304, or 316 steel in accordance with approved shop drawings
Locking and Latching Mechanism Hardware and Bolts	In accordance with approved shop drawings

9-29.2(1)A2 Non-Concrete Junction Boxes

Material for the non-concrete junction boxes shall be of a quality that will provide for a similar life expectancy as portland cement or blended hydraulic cement concrete in a direct burial application.

Type 1, 2, and 8 non-concrete junction boxes shall have a Design Load of 22,500 pounds and shall be tested in accordance with Section 9-29.2(5). Non-concrete junction boxes shall be gray in color and have an open bottom design with approximately the same inside dimensions, and present a load to the bearing surface that is less than or equal to the loading presented by the concrete junction boxes shown in the *Standard Plans*. Non-concrete junction box lids shall be steel and shall include a pull slot and shall be secured with two stainless steel Penta-head auger bolts recessed into the cover. The tapped holes for the securing bolts shall extend completely through the box to prevent accumulation of debris. Bolts shall conform to ASTM F593, stainless steel.

9-29.2(1)B Heavy-Duty Junction Boxes

Heavy-Duty Junction Boxes are defined as Type 4, 5 and 6 junction boxes and shall be concrete and have a minimum vertical load rating of 46,000 pounds without permanent deformation and 60,000 pounds without failure when tested in accordance with Section 9-29.2(5).

The Heavy-Duty Junction Box steel frame, lid support and lid fabricated from steel plate and shapes shall be painted with a shop applied, inorganic zinc primer in accordance with Section 6-07.3. Ductile iron and gray iron castings shall not be painted.

The concrete used in Heavy-Duty Junction Boxes shall have a minimum compressive strength of 4,000 psi.

Materials for Type 4, 5, and 6 Concrete Junction Boxes shall conform to the following:

Materials	Requirement
Concrete	Section 6-02
Reinforcing Steel	Section 9-07
Lid	ASTM A786 diamond plate steel, rolled from plate complying with ASTM A572, grade 50 or ASTM A588, and having a min. CVN toughness of 20 ft-lb at 40 degrees F Or Ductile iron casting meeting Section 9-05.15
Frame and stiffener plates	ASTM A572 grade 50 or ASTM A588, both with min. CVN toughness of 20 ft-lb at 40 degrees F Or Gray iron casting meeting Section 9-05.15
Handle	ASTM A36 steel or ASTM A1011 Grade CS or SS
Anchors (studs)	Section 9-06.15
Threaded Anchors for Gray Iron Frame	ASTM F1554 grade 55 Headed Anchor Requirements
Bolts, Studs, Nuts, Washers	ASTM F593 or A193, Type 304 or 316, or Stainless steel grade 302, 304, or 316 in accordance with approved shop drawing
Hinges and Locking and Latching Mechanism and associated Hardware and Bolts	In accordance with approved shop drawings
Safety Bars	In accordance with approved shop drawings

The bearing seat and lid perimeter shall be free from burrs, dirt, and other foreign debris that would prevent solid seating. Bolts and nuts shall be liberally coated with anti-seize compound. Bolts shall be installed snug tight. The bearing seat and lid perimeter shall be machined to allow a minimum of 75 percent of the bearing areas to be seated with a tolerance of 0.0 to 0.005 inches measured with a feeler gage. The bearing area percentage will be measured for each side of the lid as it bears on the frame.

9-29.2(2) Cable Vaults and Pull Boxes

Cable Vaults and Pull Boxes shall be constructed as a concrete box and as a concrete lid. The lids for the Cable Vaults and Pull Boxes shall be interchangeable and both shall fit the same box as shown in the *Standard Plans*.

The Contractor shall provide shop drawings for all components, including concrete box, Cast Iron Ring, Ductile Iron Lid, Steel Rings, and Lid. In addition, the shop drawings shall show placement of reinforcing steel, knock outs, and any other appurtenances. The shop drawing shall be prepared by or under the direct supervision of a Professional Engineer, licensed under Title 18 RCW, State of Washington, in the branch of Civil or Structural. Each sheet shall carry the following:

1. Professional Engineer's original signature, date of signature, original seal, and registration number. If a complete assembly drawing is included which references additional drawing numbers, including revision numbers for those drawings, then only the complete assembly drawing is required to be stamped.
2. The initials and dates of all participating design professionals.
3. Clear notation of all revisions including identification of who authorized the revision, who made the revision, and the date of the revision.

Design calculations shall carry on the cover page, the Professional Engineer's original signature, date of signature, original seal, and registration number.

For each type of box or whenever there is a change to the Cable Vault or Pull Box design, a proof test, as defined in this Specification, shall be performed and new shop drawings submitted.

9-29.2(2)A Standard Duty Cable Vaults and Pull Boxes

Standard Duty Cable Vaults and Pull Boxes shall be concrete and have a minimum load rating of 22,500 pounds and be tested in accordance with Section 9-29.2(5). For the purposes of this section, Small Cable Vaults are considered a type of Standard Duty Cable Vault.

Concrete for Standard Duty Cable Vaults and Pull Boxes shall have a minimum compressive strength of 4,000 psi. The lid frame shall be anchored to the vault/box concrete lid by welding headed studs ⅜ by 3 inches long, as specified in Section 9-06.15, to the frame. The wire fabric shall be attached to the studs and frame with standard tie practices. The vault/box concrete lid shall contain ten studs located near the centerline of the frame and wall. Studs shall be placed one anchor in each corner, one at the middle of each width and two equally spaced on each length of the vault/box. The steel frame, lid support, and lid shall be painted with a black paint containing rust inhibiters or painted with a shop applied, inorganic zinc primer in accordance with Section 6-07.3 or hot-dip galvanized in accordance with AASHTO M111.

All Standard Duty Cable Vaults and Pull Boxes placed in sidewalks, walkways, and shared-use paths shall have slip-resistant surfaces. The steel frame, lid support, and lid for the Standard Duty Cable Vaults and Pull Boxes shall be hot-dip galvanized.

Materials for Standard Duty Cable Vaults and Pull Boxes shall conform to the following:

Materials	Requirement
Concrete	Section 6-02
Reinforcing Steel	Section 9-07
Lid	ASTM A786 diamond plate steel
Slip Resistant Lid	ASTM A36 steel
Frame	ASTM A36 steel
Slip Resistant Frame	ASTM A36 steel
Lid Support	ASTM A36 Steel, or ASTM A1011 Grade SS
Handle & Handle Support	ASTM A36 steel or ASTM A1011 Grade CS or SS
Anchors (studs)	Section 9-06.15
Bolts, Studs, Nuts, Washers	ASTM F593 or A193, type 304 or 316, or Stainless steel grade 302, 304, 316 in accordance with approved shop drawing
Hinges and Locking Mechanism Hardware and Bolts	In accordance with approved shop drawings

9-29.2(2)B Heavy-Duty Cable Vaults and Pull Boxes

Heavy-Duty Cable Vaults and Pull Boxes shall be constructed of concrete having a minimum compressive strength of 4,000 psi, and have a minimum vertical load rating of 46,000 pounds without permanent deformation and 60,000 pounds without failure when tested in accordance with Section 9-29.2(5).

Materials for Heavy Duty Cable Vaults and Pull boxes shall conform to the following:

Materials	Requirement
Concrete	Section 6-02
Reinforcing Steel	Section 9-07
Cover	Section 9-05.15(1)
Ring	Section 9-05.15(1)
Anchors (studs)	Section 9-06.15
Bolts, Nuts, Washers	ASTM F593 or A193, Type 304 or 316, or Stainless steel grade 302, 304, 316 in accordance with approved shop drawing

9-29.2(3) Structure Mounted Junction Box

Surface mounted junction boxes and concrete embedded junction boxes installed in cast-in-place structures shall be stainless steel NEMA 4X.

Concrete embedded junction boxes installed in structures constructed by slip forming shall be stainless steel NEMA 3R and shall be adjustable for depth, with depth adjustment bolts, which are accessible from the front face of the junction box with the lid installed.

NEMA stainless steel junction boxes and cover screws shall conform to ASTM A304. Junction boxes installed on exterior of structures shall have an external hinge. Junction boxes shall be labeled with the appropriate designation.

Polyethylene drain tubes for junction boxes mounted in structures shall be ⅜-inch diameter with a wall thickness of 0.062 inches and shall be rated for a 110 psi working pressure at 73°F.

The size of NEMA 4X junction boxes and NEMA 3R junction boxes shall be as shown in the Plans.

9-29.2(4) Cover Markings

Junction boxes, cable vaults, and pull boxes with metallic lids shall be marked with the appropriate legend in accordance with the bead weld details in the *Standard Plans*. Non-metallic lids shall be embossed with the appropriate legend and a non-skid surface. Legends for metallic lids and non-metallic lids shall be 1-inch nominal height.

Junction boxes, cable vaults and pull boxes shall be marked or embossed for use in accordance with the Plans and following schedule:

System Type	Legend	System Type	Legend
Traffic Signal Interconnect	COMM	Power, Service to Signal or ITS Cabinet	LT
Fiber Optic Trunk Lines	ITS	Power, Service to Transformer	LT
Fiber Optic Laterals	ITS	Power, Lighting Circuits	LT
ITS Cabinet (any type) to Field Equipment (CCTV, Detection, VMS, etc.)	ITS	Power, Metering point (pedestal, pole, etc.) to Service Cabinet	PWR
Telephone (POTS or DSL) Service Drop	TEL	Signal Cabinet to Field Equipment (Displays, Detection, etc.)	TS

Spare junction boxes connected to a labeled system shall use the same system label. Spare junction boxes that are not connected to a labeled system may be left unlabeled (blank).

9-29.2(5) Testing Requirements

The Contractor shall provide for testing of junction boxes, cable vaults and pull boxes. Junction boxes, cable vaults and pull boxes shall be tested by an independent materials testing facility, and a test report issued documenting the results of the tests performed.

For each junction box, vault and pull box type, the independent testing laboratory shall meet the requirements of AASHTO R 18 for Qualified Tester and Verified Test Equipment. The test shall be conducted in the presence of a Professional Engineer, licensed under Title 18 RCW, State of Washington, in the branch of Civil or Structural, and each test sheet shall have the Professional Engineer's original signature, date of signature, original seal, and registration number. One copy of the test report shall be furnished to the Contracting Agency certifying that the box and cover meet or exceed the loading requirements for that box type, and shall include the following information:

1. Product identification.
2. Date of testing.

3. Description of testing apparatus and procedure.
4. All load deflection and failure data.
5. Weight of box and cover tested.
6. Upon completion of the required test(s) the box shall be loaded to failure or to the maximum load possible on the testing machine (70,000 pounds minimum).
7. A brief description of type and location of failure or statement that the testing machine reached maximum load without failure of the box.

9-29.2(5)A Standard Duty Boxes and Vaults

Standard Duty Concrete Junction Boxes, Cable Vaults, and Pull Boxes shall be load tested to 22,500 pounds. The test load shall be applied uniformly through a 10 by 10 by 1-inch steel plate centered on the lid. The test load shall be applied and released ten times, and the deflection at the test load and released state shall be recorded for each interval. At each interval the junction box shall be inspected for lid deformation, failure of the lid/frame welds, vertical and horizontal displacement of the lid/frame, cracks, and concrete spalling.

Concrete junction boxes will be considered to have withstood the test if none of the following conditions are exhibited:

1. Permanent deformation of the lid or any impairment to the function of the lid. Permanent deformation is defined as greater than 0.125 inches.
2. Vertical or horizontal displacement of the lid frame.
3. Cracks wider than 0.012 inches that extend 12 inches or more.
4. Fracture or cracks passing through the entire thickness of the concrete.
5. Spalling of the concrete.

9-29.2(5)B Retrofit Security Lids for Standard Duty Concrete Junction Boxes

Security lids used to retrofit existing Standard Duty Concrete Junction Boxes shall be tested as follows:

1. The security lid shall be installed on any appropriately sized box that is currently approved on the Qualified Products List.
2. The security lid and box assembly shall be load tested in accordance with Section 9-29.2(5)A. After the ten load cycles but before loading to failure, the security lid shall be fully opened and removed to verify operability.

3. The locking mechanism(s) shall be tested as follows:
   a. The locking mechanism shall be cycled 250 times (locked, then unlocked again) at room temperature (60-80°F). If there is more than one identical locking mechanism, only one needs to be cycled in this manner.
   b. Temperature changes should be limited to no more than 60°F per hour.
   c. The security lid shall be cooled to and held at -30°F for 15 minutes. The locking mechanism shall then be cycled once to verify operation at this temperature.
   d. The security lid shall be heated to and held at 120-122°F for 15 minutes. The locking mechanism shall then be cycled once to verify operation at this temperature.
   e. The security lid shall be temperature adjusted to and held at 110°F and 95 percent humidity for 15 minutes. The locking mechanism shall then be cycled once to verify operation at this temperature and humidity.

9-29.2(5)C Standard Duty Non-Concrete Junction Boxes

Non-concrete Junction Boxes shall be tested in the same manner as for Standard Duty Boxes and Vaults described in Section 9-29.2(5)A. In addition, the Contractor shall provide a Manufacturer Certificate of Compliance for each non-concrete junction box installed.

9-29.2(5)D Heavy-Duty Boxes and Vaults

Heavy-Duty Junction Boxes, Cable Vaults, and Pull Boxes shall be load tested to 46,000 pounds. The test load shall be applied vertically through a 10 by 20 by 1-inch steel plate centered on the lid with an orientation both on the long axis and the short axis of the junction box. The test load shall be applied and released ten times on each axis. The deflection at the test load and released state shall be recorded for each interval. At each interval the test box shall be inspected for lid deformation, failure of the lid or frame welds, vertical and horizontal displacement of the lid frame, cracks, and concrete spalling. After the twentieth loading interval the test shall be terminated with a 60,000 pound load being applied vertically through the steel plate centered on the lid and with the long edge of steel plate orientated parallel to the long axis of the box.

Heavy-Duty Junction Boxes will be considered to have withstood the 46,000 pound test if none of the following conditions are exhibited:

1. Permanent deformation of the lid or any impairment to the function of the lid. Permanent deformation is defined as greater than 0.125 inches.
2. Vertical or horizontal displacement of the lid frame.
3. Cracks wider than 0.012 inches that extend 12 inches or more.
4. Fracture or cracks passing through the entire thickness of the concrete.
5. Spalling of the concrete.

Heavy-Duty Junction Boxes will be considered to have withstood the 60,000 pound test if all of the following conditions are exhibited:

1. The lid is operational.
2. The lid is securely fastened.
3. The welds have not failed.
4. Permanent dishing or deformation of the lid is ¼ inch or less.
5. No buckling or collapse of the box.

9-29.3 Fiber Optic Cable, Electrical Conductors, and Cable

9-29.3(1) Fiber Optic Cable

All fiber optic cables shall be single mode fiber optic cables unless otherwise specified in the Contract. All fiber optic cables shall meet the following requirements:

1. Compliance with the current version of ANSI/ICEA S-87-640. A product data specification sheet clearly identifying compliance or a separate letter from manufacturer to state compliance shall be provided.
2. Cables shall be gel free, loose tube, low water peak, and all dielectric with no metallic component.
3. Cables shall not be armored unless specified in the Contract.
4. Cables shall be approved for mid-span entries and be rated by the manufacturer for outside plant (OSP) use, placement in underground ducts, and aerial installations.
5. Fiber counts shall be as specified in the Contract.
6. Fibers and buffer tubes shall be color coded in accordance with the current version of EIA/TIA-598.
7. Fibers shall not have any factory splices.
8. Outer Jacket shall be Type M (Medium Density Polyethylene). Outer jacket shall be free from holes, splits, blisters, or other imperfections and must be smooth and concentric as is consistent with the best commercial practice.
9. A minimum of one (1) rip cord is required for each cable.
10. Cable markings shall meet the following additional requirements:
    a. Color shall be white or silver.
    b. Markings shall be approximately 3 millimeters (118 mils) in height, and dimensioned and spaced to produce good legibility.
    c. Markings shall include the manufacturer's name, year of manufacture, the number of fibers, the words "OPTICAL CABLE", and sequential length marks.
    d. Sequential length markings shall be in meters or feet, spaced at intervals not more than 1 meter or 2 feet apart, respectively.

e. The actual cable length shall not be shorter than the cable length marking. The actual cable length may be up to 1 percent longer than the cable length marking.

f. Cables with initial markings that do not meet these requirements will not be accepted and may not be re-marked.

11. Short term tensile strength shall be a minimum of 600 pounds (lbs). Long term tensile strength shall be a minimum of 180 pounds (lbs). Tensile strength shall be achieved using a fiberglass reinforced plastic (FRP) central member and / or aramid yarns.

12. All cables shall be new and free of material or manufacturing defects and dimensional non-uniformity that would:

    a. Interfere with the cable installation using accepted cable installation practices;

    b. Degrade the transmission performance or environmental resistance after installation;

    c. Inhibit proper connection to interfacing elements;

    d. Otherwise yield an inferior product.

13. The fiber optic cables shall be shipped on reels with a drum diameter at least 20 times the diameter of the cable, in order to prevent damage to the cable. The reels shall be substantial and constructed so as to prevent damage during shipment and handling. Reels shall be labeled with the same information required for the cable markings, with the exception that the total length of cable shall be marked instead of incremental length marks. Reels shall also be labeled with the type of cable.

9-29.3(1)A Singlemode Fiber Optic Cable

Single-Mode optical fibers shall be EIA/TIA 492-CAAB or ISO/IEC 11801 Type OS2, low water peak zero dispersion fibers, meeting the requirements of ITU-T G.652.D.

9-29.3(1)B Multimode Optical Fibers

Where multimode fiber optic cables are specified in the Contract, the optical fibers shall be one of the following types, as specified in the Contract:

1. Type OM1, meeting the requirements of EIA/TIA 492-AAAA-A or ISO/IEC 11801. The fiber core diameter shall be 62.5 µm.

2. Type OM2, meeting the requirements of EIA/TIA 492-AAAB-A or ISO/IEC 11801. The fiber core diameter shall be 50 µm.

All multimode optical fibers shall have a maximum attenuation of 3.0 dB/km at 850nm and 1.0 dB/km at 1300nm. Completed cable assemblies shall be rated for 1000BaseLX Ethernet communications.

9-29.3(2) Electrical Conductors and Cable

9-29.3(2)A Single Conductor

9-29.3(2)A1 Single Conductor Current Carrying

All current carrying single conductors shall be stranded copper conforming to ASTM B3 and B8. Insulation shall be XLP (cross-linked polyethylene) or EPR (Ethylene Propylene Rubber), Type USE or USE-2, and rated for 600-volts or higher.

9-29.3(2)A2 Grounding Electrode Conductor

Grounding electrode conductor shall be bare or insulated stranded copper. The insulation shall be green or green with a yellow tracer.

9-29.3(2)A3 Equipment Grounding and Bonding Conductors

Equipment grounding and bonding jumper conductors shall be bare or green insulated, stranded copper with cross-linked polyethylene insulation rated USE and 600-volts, with the exception that the equipment grounding and bonding jumper conductors installed between junction box, pull box, or cable vault frame and lids shall be tinned, braided copper.

9-29.3(2)A4 Location Wire

Location wire shall be steel core copper clad minimum size AWG 14 insulated conductor. The insulation shall be orange High Molecular Weight High Density Polyethylene (HMHDPE).

9-29.3(2)B Multi-Conductor Cable

Two-conductor through 10-conductor unshielded signal control cable shall have stranded copper conductors and shall conform to International Municipal Signal Association (IMSA) signal cable 20-1.

9-29.3(2)C Aluminum Cable Steel Reinforced

Triplex or Quadraplex Type ACSR neutral self-supporting aerial conductors of the appropriate size for aluminum conductors shall be used where required in the Contract. The neutral conductor shall be the same size as the insulated conductor. All conductors shall be stranded.

9-29.3(2)D Pole and Bracket

Pole and bracket cable shall be a two-conductor cable rated for 600-volts. The individual conductors shall be one red and one black 19-strand No. 10 AWG copper, assembled parallel. The conductor insulation shall be 45-mil polyvinyl chloride or a 600-volt-rated cross-linked polyethylene. The Jacketing shall be polyethylene or polyvinyl chloride not less than 45 mils thick. If luminaires with remote ballasts are specified in the Contract, this same cable shall be used between luminaire and ballast for both timber and ornamental

pole construction. If the luminaire requires fixture wire temperatures greater than 75°C, the outer jacket shall be stripped for that portion of the cable inside the luminaire. The single conductors shall then be sheathed with braided fiberglass sleeving of the temperature rating recommended by the luminaire manufacturer.

9-29.3(2)E Two-Conductor Shielded

Two-conductor shielded (2CS) cable shall have stranded 14 AWG (minimum) conductors and shall conform to IMSA Specification No. 50-2.

9-29.3(2)F Detector Loop Wire

Detector loop wire may be 12 or 14 AWG stranded copper wire, IMSA 51-3.

9-29.3(2)G Four-Conductor Shielded Cable

Four-conductor shielded cable (4CS) shall consist of a cable with four stranded 18 AWG conductors with polypropylene insulation, an aluminized polyester shield, water-blocking material in the cable interstices, and a 26-mil minimum outer jacket of polyethylene. The four-conductor assembly shall be twisted six turns per foot. Each conductor shall have a different insulation color. Overall cable diameter shall be 0.25 inch maximum. Capacitance between adjacent pairs shall be 18 pf per foot and 15 pf per foot between diagonal pairs. The capacitances shall not vary more than 10 percent after a 10-day immersion test with ends exposed in a saturated brine solution.

9-29.3(2)H Three-Conductor Shielded Cable

Three-conductor shielded cable (3CS) for the detector circuit for optical fire preemption receivers shall consist of three 20 AWG conductors with aluminized mylar shield and one No. 20 drain wire, all enclosed with an outer jacket. All wires shall be 7 by 28 stranded tinned copper material. Conductor insulation shall be rated 75°C, 600 volt. The drain wire shall be uninsulated. Conductor color coding shall be yellow, blue, and orange. DC resistance of any conductor or drain wire shall not exceed 11 ohms per 1,000 feet. Capacitance from one conductor to the other two conductors and shield shall not exceed 48 pf per foot. The jacket shall be rated 80°C, 600 volt, with a minimum average wall thickness of 0.045 inch. The finished outside diameter of the cable shall be 0.3 inch maximum.

9-29.3(2)I Twisted Pair Communications Cable

Twisted Pair Communications Cable shall meet RUS Specification 1755.390 and shall be AWG22 conductor. The cable shall have a petroleum compound completely filling the inside of the cable and rated for OSP (Outside Plant) applications.

9-29.3(3) Wire Marking Sleeves

Wire marking sleeves shall be full-circle in design, non-adhesive, printable using an indelible ink and shall fit snuggly on the wire or cable. Marking sleeves shall be made from a PVC or polyolefin, and provide permanent identification for wires and cables.

9-29.4 Messenger Cable, Fittings

Messenger cable shall be ⅜-inch, 7-wire strand messenger cables conforming to ASTM A475, extra-high-strength grade, 15,400-pound minimum breaking strength, Class A galvanized.

Strain insulators shall be wet process porcelain, conforming to EEI-NEMA Class 54-2 standards for 12,000-pound ultimate strength.

Down guy assembly shall consist of an eight-way steel expanding anchor, having a minimum area of 300 square inches, made of pressed steel, coated with asphalt or similar preservative, and fitted with a ¾-inch minimum guy eye anchor rod 8 feet long. As an alternate to expanding anchors, screw-type anchors with two 8-inch helix, 3½-inch pitch, 1-inch by 7-foot guy anchor rod, and rated for 7,000-pound maximum torque may be installed.

All pole hardware, bolts, plate rods, hangers, clips, wire guards, and pole bands shall be hot-dip galvanized in conformance with the requirements of AASHTO M232.

9-29.5 Vacant

9-29.6 Light and Signal Standards

Light standards (including light standards with Type 1 or Type 2 luminaire arms) and signal standards (including Types I, II, III, IV, V, PPB, PS, RM, FB, and CCTV) shall be in accordance with the details shown in the Plans, as specified in the Special Provisions and as outlined herein, provided that only one luminaire arm type shall be used throughout the project.

Fabrication of light and signal standards shall conform to the applicable requirements of Section 6-03.3(14).

Light standard, signal standards, slip base hardware and foundation hardware shall be hot-dip galvanized in accordance with AASHTO M111 and ASTM F 2329. Where colored standards are required, standards shall be powder-coated after galvanizing in accordance with Section 6-07.3(11). The standard color shall be as specified in the Contract.

Materials for steel light and signal standards, and associated anchorage and fastening hardware, shall conform to Sections 9-29.6(1), 9-29.6(2), and 9-29.6(5) unless otherwise specified in one of the following documents:

1. The steel light and signal standard fabricator's preapproved plan as approved by the Washington State Department of Transportation and as identified in the Special Provisions.
2. The steel light and signal standard fabricator's shop drawing submittal, including supporting design calculations submitted as a Type 2E Working Drawing in accordance with Section 8-20.2(1) and the Special Provisions.

9-29.6(1) Steel Light and Signal Standards

Steel plates and shapes for light and signal standards shall conform to ASTM A36, except that structural shapes may conform to ASTM A992. Shafts for light and signal standards, except Type PPB signal standards, shall conform to ASTM A572 Grade 50. Shafts and caps for Type PPB signal standards, slipfitters for type PS I, FB, and RM signal standards, and all pipes shall conform to ASTM A53 Grade B. Base plates for light standards shall conform to ASTM A572, Grade 50, except as otherwise noted in the *Standard Plans* for fixed base light standards. Base plates for signal standards shall conform to ASTM A36. Connecting bolts shall conform to ASTM F3125 Grade A325. Fasteners for handhole covers, bands on lighting brackets, and connector attachment brackets shall conform to ASTM F593.

Light and signal standards shall be hot-dip galvanized in accordance with ASTM F 2329 and AASHTO M232.

Steel used for light and signal standards shall have a controlled silicon content of either 0.00 to 0.06 percent or 0.15 to 0.25 percent. Mill test certificates verifying the silicon content of the steel shall be submitted to both the galvanizer and the Engineer prior to beginning galvanizing operations.

9-29.6(2) Slip Base Hardware

Slip plates and anchor plates for light standards and for Type FB and RM signal standards shall conform to the requirements of ASTM A572 Grade 50. The keeper plate shall be 28 gage, conforming to ASTM A653 coating designation G 90. Clamping bolts for slip base assemblies and slip base adapters shall conform to ASTM F3125 Grade A325. Studs and bolts for slip base adapters shall conform to ASTM F3125 Grade A325. Nuts shall conform to ASTM A563 Grade DH. Hardened washers shall conform to ASTM F436. Plate washers shall conform to ASTM A36, and also shall conform to the flatness tolerances specified in ASTM F436 for circular washers.

Galvanized bolts shall meet Section 9-06.5(4).

9-29.6(3) Timber Light Standards, Timber Strain Poles, Timber Service Supports

All timber poles used in illumination or traffic signal systems shall be Douglas fir, machine shaved, roof sawed, conforming to the latest ANSI Specifications and Dimensions for Wood Poles.

All timber poles shall be gained according to industry standards. A dated nail or metallic date plate shall be set in the gain evidencing the year of treatment of the timber pole.

All poles shall be treated with pentachlorophenol in accordance with Section 9-09.3(1).

Tops shall be sawed before treatment. Where holes are bored in poles to accommodate hanging bolts for brackets, transformers, guy assemblies, or other accessories, such holes shall be painted with a solution of the above preservative.

9-29.6(4) Welding

Welding of steel structures shall be in accordance with AWS D1.1/D1.1M, latest edition, Structural Welding Code, and Section 6-03.3(25).

9-29.6(5) Foundation Hardware

Anchor bolts for Type PPB, PS, I, FB, and RM signal standards shall conform to the requirements of ASTM F1554, grade 55. Nuts shall meet the requirements of ASTM A563, grade A. Washers shall meet the requirements of ASTM F844 or F436.

Anchor bolts, and associated nuts and washers, for Type CCTV, II, III, IV, and V signal standards and luminaire poles shall conform to Section 9-06.5(4). Anchor rods conforming to ASTM A449 may be substituted, provided that the galvanized ASTM A449 anchor rods having an ultimate tensile strength above 145 ksi shall be tested for embrittlement in accordance with either ASTM A143 (if the rod length is equal to or greater than five times the bolt diameter) or ASTM F606 Section 7 (if the rod length is less than five times the nominal bolt diameter).

All foundation hardware shall be 100 percent hot-dip galvanized in accordance with AASHTO M111 and ASTM F 2329.

9-29.7 Luminaire Fusing and Electrical Connections at Light Standard Bases, Cantilever Bases, and Sign Bridge Bases

9-29.7(1) Unfused Quick-Disconnect Connector Kits

Unfused quick-disconnect connector kits shall conform to the following requirements:

1. The copper pin and copper receptacle shall be a crimped type of connection or a stainless steel set screw and lug connection to the cable. The receptacle shall establish contact pressure with the pin through the use of a tinned copper or copper beryllium sleeve spring and shall be equipped with a disposable mounting pin. The receptacle shall be fully annealed. Both the copper pin and receptacle shall have a centrally located recessed locking area adapted to be complementarily filled and retained by the rubber housing.
2. The plug and receptacle housing shall be made of water-resistant synthetic rubber that is able to be buried in the ground or installed in sunlight. Each housing shall provide a section to form a water-seal around the cable, have an interior arrangement to suitably and complementarily receive and retain the copper pin or receptacle, and a section to provide a water-seal between the two housings at the point of disconnection.
3. The kit shall provide waterproof in-line connector protection with three cutoff sections on both the line and load side to accommodate various wire sizes. All connections shall be as described in item “1” above. Upon disconnect, the connector shall remain in the load side of the kit.

9-29.7(2) Fused Quick-Disconnect Kits

Fused quick-disconnect kits shall provide waterproof in-line fuse protection. The kit shall provide three cutoff sections on both lines and load side to accommodate various wire sizes. All connections shall be as described in item “1” above. Upon disconnect, the fuse shall remain in the load side of the kit.

Fuses furnished for all lighting circuits shall be capable of handling the operating voltage of the circuit involved and shall have the following characteristics:

1. Fuses shall be capable of indefinitely supporting 110 percent of the rated load.
2. Fuses shall be capable of supporting 135 percent of the rated load for approximately 1 hour.
3. A load of 200 percent of rated load shall effectively cause instantaneous blowing of the fuse.
4. Fuses shall be rated as listed below and shall be sized to fit the fuse containers furnished on this project, according to the manufacturer’s recommendations therefore.
5. Fuses shall be listed by a Nationally Recognized Testing Laboratory.

Luminaire Size	Service Voltage		
	480V	240V	120V
1,000W	10A	15A	30A
750W	5A	10A	20A
700W	5A	10A	20A
400W	5A	10A	15A
310W	5A	5A	10A
250W	5A	5A	10A
200W	4A	5A	10A
175W	4A	5A	10A
150W	3A	4A	5A
100W	2A	3A	4A
70W	2A	2A	2A
50W	2A	2A	2A
LED*	10A	10A	20A

*Applies to all LED luminaires, regardless of wattage. Fuses for LED luminaires shall be slow blow.

9-29.8 Vacant

9-29.9 Ballast, Transformers

Heat-generating components shall be mounted to use the portion of the luminaire upon which they are mounted as a heat sink. Capacitors shall be located as far as practicable from heat-generating components or shall be thermally shielded to limit the fixture temperature to 160°F.

Transformers and inductors shall be resin-impregnated for protection against moisture. Capacitors, except those in starting aids, shall be metal cased and hermetically sealed.

No capacitor, transformer, or other device shall employ the class of compounds identified as polychlorinated biphenyls (PCB) as dielectric, coolants, or for any other purpose.

9-29.9(1) Ballast

Each ballast shall have a name plate attached permanently to the case listing all electrical data.

A Manufacturer's Certificate of Compliance, in accordance with Section 1-06.3, meeting the manufacturer's and these Specifications' requirements, shall be submitted by the Contractor with each type of luminaire ballast.

Ballasts shall be designed for continuous operation at ambient air temperatures from 20°F without reduction in ballast life. Ballasts shall have a design life of not less than 100,000 hours. Ballasts shall be designed to operate for at least 180 cycles of 12 hours on and 12 hours off, with the lamp circuit in an open or short-circuited condition and without measurable reduction in the operating requirements. All ballasts shall be high power factor (90 percent).

Ballasts shall be tested in accordance with the requirements of current ANSI C 82.6, Methods of Measurement of High-Intensity-Discharge Lamp Ballasts. Starting aids for ballasts of a given lamp wattage shall be interchangeable between ballasts of the same wattage and manufacturer without adjustment.

Ballast assemblies shall consist of separate components, each of which shall be capable of being easily replaced. A starting aid will be considered as a single component. Each component shall be provided with screw terminals, NEMA tab connectors or a single multi-circuit connector. All conductor terminals shall be identified as to the component terminal to which they connect.

Ballasts for high-pressure sodium lamps shall have a ballast characteristic curve which will intersect both of the lamp-voltage limit lines between the wattage limit lines and remain between the wattage limit lines throughout the full range of lamp voltage. This requirement shall be met not only at the rated input voltage of the ballast, but also the lowest and highest input voltage for which the ballast is rated. Throughout the lifetime of the lamp, the ballast curve shall fall within the specified limits of lamp voltage and wattage.

All luminaires ballasts shall be located within the luminaire housing. The only exception shall be ballasts to be mounted on lowering assemblies and shall be external to, and attached to the fixture assembly.

Ballast Characteristics for High Pressure Sodium (HPS) and Metal Halide (MH) Sources shall be:

Source	Line Volt.	Lamp Wattage	Ballast Type	Input Voltage Variation	Lamp Wattage Variation
HPS	any	70 400	Mag. Reg. Lag	10%	18%
HPS	any	750 1000	Auto Reg. Lead CWA	10%	30%
MH	any	175 400	Mag. Reg. Lag	10%	18%
MH	any	1000	Auto Reg. Lead CWA	10%	30%

9-29.9(2) Transformers

The transformers to be furnished shall be indoor/outdoor dry type transformers rated as shown in the Plans. The transformer coils, buss bar, and all connections shall be copper. Transformers, 7.5 KVA and larger shall be supplied with two full capacity taps, one at 5 percent and one at 10 percent below the normal full capacity.

9-29.10 Luminaires

All luminaires shall have their components secured to the luminaire frame with ANSI 300 series chrome-nickel grade stainless steel, zinc dichromate-coated steel, or ceramic-coated steel hardware. The luminaire slipfitter bolts shall be stainless steel, hot-dip galvanized steel, zinc dichromate-coated steel, or ceramic-coated steel. All internal luminaire assemblies shall be assembled on or fabricated from either stainless steel or galvanized steel. The housing, complete with integral ballast, shall be weathertight.

The temperature rating of all wiring internal to the luminaire housing, excluding the pole and bracket cable, shall equal or exceed 200°F.

All luminaires shall be provided with markers for positive identification of light source type and wattage in accordance with ANSI C136.15-2011, with the exception that LED luminaires shall be labeled with the wattage of their conventional luminaire equivalents – the text “LED” is optional. Legends shall be sealed with transparent film resistant to dust, weather, and ultraviolet exposure.

Legends shall correspond to the following code:

Conventional Lamp Wattage	Conventional Wattage Legend	Equivalent LED Legend
70	7	7E
100	10	10E
150	15	15E
175	17	17E
200	20	20E
250	25	25E
310	31	31E
400	40	40E
700	70	70E
750	75	75E
1,000	X1	X1E

9-29.10(1) Conventional Roadway Luminaires

All conventional roadway luminaires shall meet 3G vibration requirements as described in ANSI C136.31.

All luminaires shall have housings fabricated from aluminum. The housing shall be painted flat gray, SAE AMS Standard 595 color chip No. 26280, unless otherwise specified in the Contract. Painted housings shall withstand a 1,000 hour salt spray test as specified in ASTM B117.

Each housing shall include a four bolt slip-fitter mount capable of accepting a nominal 2” tenon and adjustable within +/- 5 degrees of the axis of the tenon. The clamping bracket(s) and the cap screws shall not bottom out on the housing bosses when adjusted within the +/- 5 degree range. No part of the slipfitter mounting brackets on the luminaires shall develop a permanent set in excess of 0.2 inch when the cap screws used for mounting are tightened to a torque of 32 foot-pounds. Each luminaire shall include leveling reference points for both transverse and longitudinal adjustment.

All luminaires shall include shorting caps when shipped. The caps shall be removed and provided to the Contracting Agency when an alternate control device is required to be installed in the photocell socket. House side shields shall be included when required by the Contract. Order codes shall be modified to the minimum extent necessary to include the option for house side shields.

9-29.10(1)A High Pressure Sodium (HPS) Conventional Roadway Luminaires

HPS conventional roadway luminaires shall meet the following requirements:

1. General shape shall be “cobrahead” style, with flat glass lens and full cutoff optics.
2. Light pattern distribution shall be IES Type III.
3. The reflector of all luminaires shall be of a snap-in design or secured with screws. The reflector shall be polished aluminum or prismatic borosilicate glass.
4. Flat lenses shall be formed from heat resistant, high-impact, molded borosilicate or tempered glass.
5. The lens shall be mounted in a doorframe assembly, which shall be hinged to the luminaire and secured in the closed position to the luminaire by means of an automatic latch. The lens and doorframe assembly, when closed, shall exert pressure against a gasket seat. The lens shall not allow any light output above 90 degrees nadir. Gaskets shall be composed of material capable of withstanding the temperatures involved and shall be securely held in place.
6. The ballast shall be mounted on a separate exterior door, which shall be hinged to the luminaire and secured in the closed position to the luminaire housing by means of an automatic type of latch (a combination hex/slot stainless steel screw fastener may supplement the automatic-type latch).
7. Each luminaire shall be capable of accepting a 150, 200, 250, 310, or 400 watt lamp complete and associated ballast. Lamps shall mount horizontally.

9-29.10(1)B Light Emitting Diode (LED) Conventional Roadway Luminaires

LED Conventional Roadway Luminaires are divided into classes based on their equivalent High Pressure Sodium (HPS) luminaires. Current classes are 200W, 250W, 310W, and 400W. LED luminaires are required to be pre-approved in order to verify their photometric output. To be considered for pre-approval, LED luminaires must meet the requirements of this section.

LED luminaires shall include a removable access door, with tool-less entry, for access to electronic components and the terminal block. The access door shall be removable, but include positive retention such that it can hang freely without disconnecting from the luminaire housing. LED drivers may be mounted either to the interior of the luminaire housing or to the removable door itself.

LED drivers shall be removable for user replacement. All internal modular components shall be connected by means of mechanical plug and socket type quick disconnects. Wire nuts may not be used for any purpose. All external electrical connections to the luminaire shall be made through the terminal block.

LED luminaires shall not include a photocell receptacle. LED output shall have a Correlated Color Temperature (CCT) of 3000K nominal and a Color Rendering Index (CRI) of 70 or greater. LED output shall be a minimum of 85% at 75,000 hours at 25 degrees Celsius.

LED luminaires shall be available for 120V, 240V, and 480V supply voltages. Voltages refer to the supply voltages to the luminaires present in the field. LED power usage shall not exceed the following maximum values for the applicable wattage class:

Class	Max. Wattage
200W	110W
250W	165W
310W	210W
400W	275W

Only one brand of LED conventional roadway luminaire may be used on a Contract. They do not necessarily have to be the same brand as any high-mast, underdeck, or wall-mount luminaires when those types of luminaires are specified in the Contract. LED luminaires shall include a standard 10 year manufacturer warranty.

The list of pre-approved LED Conventional Roadway Luminaires is available at www.wsdot.wa.gov/Design/Traffic/ledluminaires.htm.

9-29.10(2) Vacant

9-29.10(3) Vacant

9-29.10(4) Underdeck and Wall Mount Luminaires

Underdeck luminaires shall be weatherproof and corrosion resistant. Light distribution shall be as shown on the Contract. Each flush-mounted underdeck luminaire shall consist of a metal body, a prismatic refractor mounted in a doorframe, a prismatic glass or specular anodized aluminum reflector, a ballast, and a ceramic lamp socket and be supplied complete with all fasteners. The body shall have provisions for anchoring to concrete. The refractor shall be glass and shall be clearly identified as to “street side”. The doorframe assembly shall be hinged, gasketed and secured to the body.

Each wall-mounted luminaire shall consist of a metal body, a prismatic refractor mounted in a doorframe, an aluminum reflector with a specular anodized finish, an integral ballast and a ceramic lamp socket and supplied with all fasteners. The refractor shall be glass. A gasket shall be provided between the refractor and the body of the fixture.

All lamp sockets shall be positioned to locate the light center of the lamp within ½ inch of the light center location for which the luminaire is designed.

Ballasts for underdeck and wall luminaires shall conform to the provisions in Section 9-29.9. Ballasts for underdeck and wall mount luminaires shall be installed in the luminaire housing.

9-29.11 Control Equipment

Illumination circuits shall be controlled by a combination of photoelectric controls and lighting contactors as noted in the Contract.

9-29.11(1) Time Clock Controls

Time clocks, when specified in the Contract, shall be solid state and shall have a battery backup. The clock shall provide four functions and shall be enclosed within a dust tight mounting case. The unit shall be mounted on vibration dampened fittings.

The unit shall be push button programmable with 15 events per week, selectable by day of week and time of day to the nearest minute.

The clock shall be accurate to plus or minus 15 seconds per month through a humidity variation of 0 to 95 percent and a temperature variation of 0°F to 150°F. The clock shall be within plus or minus 10 seconds after 10 hours of battery backup operation. The backup battery shall operate for 24 hours minimum.

Contacts shall be rated at 5 amps tungsten load for up to 100,000 cycles. Each clock function shall operate a 120 VAC normally open and normally closed set of contacts.

9-29.11(2) Photoelectric Controls

The photoelectric control shall be the twistlock type and the light sensitive element shall be a solid state photo diode. The control shall be designed to turn on at 3 foot-candles (32 lux) and turn off at 1.8 foot-candles (20 lux). The lighting control shall not drift by more than 1 percent over a 10-year period.

The output control relay shall have a 45-second time delay to prevent false turn-off caused by momentary brightness. This output relay shall be rated 1,000 watts incandescent or 15 amps inductive load. The contacts shall be normally closed. The unit shall be designed to not continuously pulse the output relay if the photo control bypass switch is energized.

The lighting control shall have a built in metal oxide varistor (MOV) rated 180 joules for lightning and transient protection. The control shall also have secondary zener diode and transient filter. The printed circuit board shall be coated to prevent corrosion. The normal operating voltage range will be 105 to 285 VAC.

9-29.12 Electrical Splice Materials

Circuit splicing materials shall meet the following specifications.

9-29.12(1) Illumination Circuit Splices

Underground illumination circuit splices shall be solderless crimped connections capable of securely joining the wires, both mechanically and electrically, as defined in Section 8-20.3(8). Aerial illumination splices shall be solderless crimp connectors or split bolt vice-type connectors.

9-29.12(2) Traffic Signal Splice Material

Induction loop splices and magnetometer splices shall use an uninsulated barrel-type crimped connector capable of being soldered.

9-29.12(3) Splice Enclosures

9-29.12(3)A Heat Shrink Splice Enclosure

Heat shrink splice enclosures shall be medium or heavy wall cross-linked polyolefin, meeting the requirements of AMS-DTL-23053/15, with thermoplastic adhesive sealant. Heat shrink splices used for “wye” connections require rubber electrical mastic tape.

9-29.12(3)B Molded Splice Enclosure

Molded splice enclosures shall use epoxy resin in a clear rigid plastic mold. The material used shall be compatible with the insulation material of the insulated conductor or cable. The component materials of the resin insulation shall be packaged ready for convenient mixing without removing from the package.

9-29.12(4) Re-Enterable Splice Enclosure

Re-enterable splice enclosures shall use either dielectric grease or a flexible resin contained in a two-piece plastic mold. The mold shall either snap together or use stainless steel hose clamps.

9-29.12(5) Vinyl Electrical Tape for Splices

Vinyl electrical tape in splicing applications shall meet the requirements of MIL-I-24391C.

9-29.13 Control Cabinet Assemblies

Control cabinet assemblies shall include all necessary equipment and auxiliary equipment for controlling the operation of traffic signals, programmable message signs, illumination systems, ramp meters, data stations, CCTV, and similar systems as required for the specific application. Traffic Signal Controller Cabinet Assemblies shall meet the requirements of the NEMA TS1 and TS2 specification or the California Department of Transportation “Transportation Electrical Equipment Specifications” (TEES) dated March 12, 2009 as defined in this specification.

9-29.13(1) Environmental, Performance, and Test Standards for Solid-State Traffic Controller Assemblies

The scope of this Specification includes the controller of solid-state design installed in a weatherproof controller cabinet. The controller assembly includes the cabinet, controller unit, load switches, signal conflict monitoring circuitry, accessory logic circuitry, AC line filters, vehicle detectors, coordination equipment and interface, and preemption equipment. NEMA control assemblies shall meet or exceed current NEMA TS 1 Environmental Standards. Normal operation will be required while the control assembly is subjected to any combination of high and low environmental limits (such as low voltage

at high temperature with high repetition noise transients). All other control equipment shall meet the environmental requirements of California Department of Transportation "Transportation Electrical Equipment Specifications" (TEES) dated March 12, 2009.

The Contractor shall furnish to the Contracting Agency all guarantees and warranties furnished as a normal trade practice for all control equipment provided.

9-29.13(2) Traffic Signal Controller Assembly Testing

Each traffic signal controller assembly shall be tested as follows. The Contractor shall:

1. Prior to shipping, arrange appointment for testing at the WSDOT Materials Laboratory.
2. Assembly shall be defined as tightening all screws, nuts and bolts, verifying that all wiring is clear of moving parts and properly secured, installing all pluggables, connecting all cables and ensure that all Contract required documents are present, proper documentation is provided, and all equipment required by the Contract is installed.
3. The Contractor shall demonstrate that all of the functions required by the Contract perform as intended. Demonstration shall include energizing the cabinet and verifying that all 8 phases, 4 pedestrian movements and 4 overlaps (as required by the Contract Provisions) operate per Section 9-29.13. The Contractor shall place the controller in minimum recall with interval timing set at convenient value for testing purposes. Upon a satisfactory demonstration the controller assembly will then be accepted by WSDOT for testing.
4. If the assembly and acceptance for testing is not complete within 7 calendar days of delivery, the Engineer may authorize the return of the assembly to the Contractor, with collect freight charges to the Contractor.
5. WSDOT will test each traffic signal control assembly in accordance with the following test methods, WSDOT T 421, T 422, T 423, T 424, T 425, T 427, and T 428.
6. If the traffic signal control assembly passes all testing, the Contractor will be notified where the assembly is to be picked-up for delivery to the project. The Contractor shall pick-up the assembly within 7 calendar days of notification.
7. If the traffic signal control assembly fails testing, the Contractor has 7 calendar days to repair or replace any components that fail during the testing process at no cost to the Contracting Agency. All repairs shall be completed during normal business hours for the State Materials Lab. A failure shall be defined as a component that no longer functions as intended under the conditions required or does not meet the requirements of the Contract and is at the sole discretion of WSDOT. Once all repairs and replacement of components is complete WSDOT will retest the traffic controller as specified in step 6 and all costs for retesting will be deducted from monies due or that may become due the Contractor.

9-29.13(3) Traffic Signal Controller

The traffic signal controller shall conform to the Contract requirements and the applicable Specifications as listed below: All solid-state electronic traffic-actuated controllers and their supplemental devices shall employ digital timing methods.

1. NEMA control and all auxiliary equipment shall conform to current NEMA TS1 or TS2 Specification. Every pin of every connecting plug shall be utilized as described within the NEMA requirement, except that those pins identified as “spare” or “future” shall remain unused.
2. Type 170E controllers shall conform to the TEES. The 170E controller shall be provided with a program card, one blank ROM chip, and two 64K non-volatile memory chips.
3. Type 170E/HC-11 controllers shall conform to the current Oregon Department of Transportation Specification for model 170E/HC-11 controller. The 170E controller with the HC11 chip shall be compatible with the software specified in the Contract. The controller shall be provided with one ROM chip and one 64K non-volatile memory chip.
4. Type 2070 controllers shall conform to the TEES. The standard 2070 controller shall consist of the following:

2070	X	X
2070-5 VME cage	2070E	2070N1
2070-1E CPU Card	2070-1E CPU Card	2070-1E CPU Card
2070-3B Front Panel	2070-3B Front Panel	2070-3B Front Panel
2070-4 Power Supply	2070-4 Power Supply	2070-4 Power Supply
2070-2A Field I/O	2070-2A Field I/O	2070-2B Field I/O
		2070-8 Interface

9-29.13(4) Traffic-Signal Controller Software

All traffic signal controllers shall operate with software specified in the contract.

Traffic-actuated controllers shall be electronic devices which, when connected to traffic detectors or other means of actuation, or both, shall operate the electrical traffic signal system at one or more intersections.

If the complete traffic controller defined in the Special Provision requires NTCIP compliance the following are the minimum requirements for NTCIP operation.

Communication

The traffic controller hardware and software shall communicate with the central computer in a polled multi-drop operation. In the polled multi-drop operation, several traffic controllers shall share the same communication channel, with each controller assigned a unique ID number. Controller ID numbers shall conform to the NTCIP requirements for address numbers. A traffic controller shall only reply

to messages labeled with its ID. In polled multi-drop mode, traffic controllers never initiate communication, but merely transmit their responses to messages from the central computer.

A laptop computer connected to the traffic controller's local communication port shall have the same control and diagnostic capabilities as the central computer. However, local laptop control capability shall be limited to that traffic controller.

NTCIP Requirements

The traffic controller software shall comply with the National Transportation Communications for ITS Protocol (NTCIP) documents and all related errata sheets published before July 1, 1999 and as referenced herein.

The traffic controller software shall support the following standards:

1. NTCIP 1101, Simple Transportation Management Framework (STMF), Conformance Level 1 (Simple Network Management Protocol (SNMP))
2. NTCIP 2001, Class B Profile. All serial ports on the device shall support communications according to these standards.
3. NTCIP 2101, SP-PMPP/RS232 Point-to-Multi-Point Protocol (PMPP)
4. NTCIP 2201, NTCIP TP-Null Transport Profile Null (TP-NULL)

The traffic controller software shall implement all mandatory objects of all mandatory conformance groups as defined in NTCIP 1201, Global Object Definitions, and NTCIP 1202, Object Definitions for Actuated Traffic Signal Controller Units. Software shall implement the following conformance groups:

NTCIP 1202, Object Definitions for ASC

Conformance Group	Reference
Configuration	1201 2.2
Time Management	
Time Base Event Schedule	
Report	2.5
Phase	1202 2.2
Rings	2.8
Detector	2.3
Unit	2.4
Preempt	2.7
Time Base	2.6
Coordination	2.5
Channel	2.9
Overlaps	2.10

The software shall implement the following optional objects:

Objects required by these specifications shall support all values within its standardized range. The standardized range is defined by a size, range, or enumerated listing indicated in the object's SYNTAX field and/or through descriptive text in the object's description field. The following list indicates the modified object requirements for these objects.

Object Name	Object ID	
Global Configuration	moduleType	Value 3
Database Management	dBCreateTransaction	All Values
	dBErrorType	All values
Time Management	globslDaylightSavings	Values 2 and 3
Timebase Events Schedule	maxTimeBaseScheduleEntries	16
	MaxDayPlans	15
	MaxDayEvents	10
Report	maxEventLogCongifs	50
	MventConfigMode	Values 2 thru 5
	mventConfigAction	Values 2 and 3
	MaxEventLogSize	255
	MaxEventClasses	7
PMPP	maxGroupAddress	2
ASC Phase	maxPhases	8
	pPhaseStartp	Values 2 thru 6
	phaseOptions	All Values
	maxPhaseGroups	1
Rings	maxRings	2
	maxSequences	16
Detector	maxVehicleDetectors	64
	vehicleDetectorOptions	All Values
	maxPedestrianDetector	8
Unit	unitAutoPedestrianClear	All Values
	unitControlStatus	All Values
	unitFlashStatus	All Values
	unitControl	All Values
	maxAlarmGroups	1
Special Function	maxSpecialFunctionsOutputs	8

Object Name	Object ID	
Coordination	coordCorrectionMode	Values 2 thru 4
	coordMaximumMode	Values 2 thru4
	coordForceMode	Values 2 and 3
	maxPatterns	48
	patternTableType	Either 2,3 or 4
	maxSplits	16
	splitMode	Values 2 thru 7
	localFreeStatus	Values 2 thru 11
Time Base	maxTimebaseAscAction	48
Preempt	maxPreempts	4
	preemptControl	All Values
	preemptState	Values 2 thru 9
Overlaps	maxOverlaps	4
	overlapType	Value 2 and 3
	maxOverlapstatusGroup	1
Channels	maxChannels	16
	channelControlGroup	Values 2 thru 4
	channelFlash	Value 0,2,4,6,8,10,12 and 14
	channelDim	Values 0 thru 15
	maxChannelStatusGroup	2
TS 2 Port 1	maxPortAddresses	18
	port1Table	Values 2 and 3

*Values in excess of the minimum requirement are considered to meet the specification.

Documentation

Software shall be supplied with all documentation on a CD. ASCII versions of the following Management Information Base (MIB) files in Abstract Syntax Notation 1 (ASN.1) format shall be provided on CD-ROM:

1. The official MIB Module referenced by the device functionality.
2. A manufacturer-specific version of the official MIB Module with the non-standardized range indicated in the SYNTAX field. The filename shall match the official MIB Module, with the extension “spc”.
3. A MIB Module of all manufacturer-specific objects supported by the device with accurate and meaningful DESCRIPTION fields and the supported ranges indicated in the SYNTAX field.

9-29.13(5) Flashing Operations

All traffic signals shall be equipped for flashing operation of signal displays. Controllers and cabinets shall be programmed for flashing red displays for all approaches. During flashing operation, all pedestrian circuits shall be de-energized.

Actuated traffic signal control mechanisms shall be capable of entry into flash operation and return to stop-and-go operation as follows:

1. Terminal Strip Input (Remote Flash). When called as a function of a terminal strip input, the controller shall provide both sequenced entry into flash and sequenced return to normal operation consistent with the requirements of the latest edition of the *Manual on Uniform Traffic Control Devices*.
2. Police Panel Switch. When the flash-automatic switch located behind the police panel door is turned to the flash position, the signals shall immediately revert to flash; and, the controller shall have a stop time input applied. When the switch is placed on automatic, the controller shall immediately time an 6 second all red period then resume stop-and-go operations at the beginning of major street green.
3. Controller Cabinet Switches. When the flash-automatic switch located inside the controller cabinet is placed in the flash position, the signals shall immediately revert to flash; however, the controller shall not have a stop time input applied. When the flash-automatic switch is placed in the automatic position, the controller shall immediately time a 6 second all red period, then resume stop-and-go operation at the beginning of the major green.
4. Power Interruption. On “NEMA” controllers any power interruption longer than 475 plus or minus 25 milliseconds, signals shall re-energize consistent with No. 2 above to ensure an 6-second flash period prior to the start of major street green. A power interruption of less than 475 plus or minus 25 milliseconds shall not cause resequencing of the controller and the signal displays shall re-energize without change. Type 170 controllers shall re-energize consistent with No. 2 above after a power interruption of 1.75 plus or minus 0.25 seconds. The 6-second flash period will not be required. Any power interruption to a 2070 type controller shall result in a 6 second flash period once power is restored.
5. Conflict Monitor. Upon detecting a fault condition the conflict monitor shall immediately cause the signal to revert to flash and the controller to stop time. After the conflict monitor has been reset, the controller shall immediately take command of the signal displays at the beginning of major street green.

9-29.13(6) Emergency Preemption

Immediately after a valid call has been received, the preemption equipment shall cause the controller to terminate the appropriate phases as necessary with the required clearance intervals and enter any programed subsequent preemption sequence. Preemption sequences shall be as noted in the Contract.

9-29.13(7) Wiring Diagrams

Schematic wiring diagrams of the controllers, cabinets and auxiliary equipment shall be submitted when the assemblies are delivered. The diagram shall show in detail all circuits and parts. The parts shall be identified by name or number in a manner readily interpreted. Two hard copies of the cabinet wiring diagram and component wiring diagrams shall be furnished with each cabinet and a pdf file of the cabinet wiring and component drawings. The schematic drawing shall consist of a single sheet, detailing all circuits and parts, not to exceed 52-inches by 72-inches. The cabinet wiring diagram shall indicate and identify all wire terminations, all plug connectors, and the locations of all equipment in the cabinet. Included in the diagram shall be an intersection sketch identifying all heads, detectors, and push buttons and a phase diagram.

9-29.13(8) Generator Transfer Switch

When specified in the contract, a generator transfer switch shall be included. The Generator Transfer Switch shall be capable of switching power from a utility power source to an external generator power source.

The Transfer Switch enclosure shall be of identical materials and dimensions and installation methods as the Police Panel type enclosure specified in the first paragraph of Special Provision 9-29.13(10)D except that the enclosure door shall include a spring loaded construction core lock capable of accepting a Best 6-pin CX series core. The core lock shall be installed with a green construction core. Upon contract completion, two master keys for the construction core shall be delivered to the Engineer.

The enclosure shall include the following Transfer Switch equipment:

1. One Nema L5-30P Flanged Inlet generator connector
2. One Utility power indicator light
3. One generator indicator light
4. Two 30 amp, 120 volt, single pole, single phase, circuit breakers. One circuit breaker shall be labeled “Generator” and the other circuit breaker shall be labeled “Utility”. Both labels shall be engraved phenolic name plates.
5. A mechanical lock out feature that prevents the Utility circuit breaker and the Generator circuit breaker from being in the ON position at the same time. The circuit breakers shall be capable of being independently switched.
6. The conductors from the Generator Transfer Switch enclosure to the cabinet circuit breaker shall be enclosed in nylon mesh sleeve.
7. The enclosure door shall be labeled with the letters “GTS”.

9-29.13(9) Vacant

9-29.13(10) NEMA, Type 170E, 2070 Controllers and Cabinets

9-29.13(10)A Auxiliary Equipment for NEMA Controllers

The following auxiliary equipment shall be furnished and installed in each cabinet for NEMA traffic-actuated controllers:

1. A solid-state Type 3 NEMA flasher with flash-transfer relay which will cut in the flasher and isolate the controller from light circuits. See Section 9-29.13(5) for operational requirements.
2. Modular solid state relay load switches of sufficient number to provide for each vehicle phase (including future phases if shown in the Plans), each pedestrian phase and preemption sequence indicated in the Contract. Type P & R cabinets shall include a fully wired 16-position back panel. Solid-state load switches shall conform to NEMA standards except only optically isolated load switches will be allowed. Load switches shall include indicator lights on the input and output circuits. The controller cabinet shall have all cabinet wiring installed for eight vehicle phases, four pedestrian phases, four emergency pre-empts, four overlaps (OL A, B, C, D).
3. A power panel with:
   a. A control-display breaker sized to provide 125 percent overload protection for all control equipment and signal displays, 20 ampere minimum.
   b. A 15 ampere accessory breaker wired parallel to the control display breaker. The breaker will carry accessory loads, including vent fan, cabinet light, plug receptacle, etc.
   c. A busbar isolated from ground and unfused for the neutral side of power supply.
   d. A radio interference suppresser installed at the input power point. Interference suppressers shall be of a design which will minimize interference in both broadcast and aircraft frequencies, and shall provide a minimum attenuation of 50 decibels over a frequency range of 200 kilohertz to 75 megahertz when used in connection with normal installations. The interference filters furnished shall be hermetically sealed in a substantial case filled with a suitable insulating compound. Terminals shall be nickel plated, 10-24 brass studs of sufficient external length to provide space to connect two 8 AWG wires, and shall be so mounted that they cannot be turned in the case.

      Ungrounded terminals shall be insulated from each other and shall maintain a surface leakage distance of not less than ½-inch between any exposed current conductor and any other metallic parts with an insulation factor of 100-200 megohms dependent on external circuit conditions.

      Suppressers shall be designed for operations on 50 amperes, 125 volts, 60 cycles, single wire circuits, and shall meet standards of the Underwriters' Laboratories and the Radio Manufacturers Association.

e. A Surge Protection Device connected to the controller power circuit for protection against voltage abnormalities of 1 cycle or less duration. The Surge Protection Device shall be a solid state high energy circuit containing no spark gap, gas tube, or crow bar component. The device shall provide transient protection between neutral and ground, line and ground, as well as line and neutral. If the protection circuits fail, they shall fail to an open circuit condition. The minimum interrupting capacity shall be 10,000 Amps. The Voltage Protection Rating shall be 600 volts or less when subjected to an impulse of 6,000 volts, 3,000 amp source impedance, 8.0/20 microsecond waveform as described in UL 1449. In addition, the device shall dissipate a 13,000 Amp or greater repeated single peak 8/20 microsecond current impulse, and withstand, without failure or permanent damage, one full cycle at 264 volts RMS. The device shall contain circuitry to prevent self-induced regenerative ringing. There shall be a failure warning indictor which shall illuminate a red light or extinguish a green light when the device has failed and is no longer operable.

f. Cabinet ground busbar independent (150K ohms minimum) of neutral.

4. A police panel located behind the police panel door with a flash automatic switch and a control-display power line on-off switch. See Section 9-29.13(5) for operational requirements.

5. An auxiliary control panel located inside the controller cabinet with a flash-automatic switch and a controller on-off switch. See Section 9-29.13(5) for operational requirements. A three wire 15 ampere plug receptacle with grounding contact and 15 ampere ground fault interrupter shall also be provided on the panel.

6. A conflict monitor conforming to NEMA standards. See Section 9-29.13(5) for operational requirements. The unit shall monitor conflicting signal indications at the field connection terminals. The unit shall be wired in a manner such that the signal will revert to flash if the conflict monitor is removed from service.

   Supplemental loads not to exceed 10 watts per monitored circuit or other means, shall be provided to prevent conflict monitor actuation caused by dimming or lamp burn-out. Supplemental loads shall be installed on the control side of the field terminals. Conflict monitors shall include a minimum of one indicator light for each phase used. The monitoring capacity of the unit shall be compatible with the controller frame size. Conflict monitors shall include a program card.

7. A “Detector Panel”, as specified in Section 9-29.13(10)B, shall be installed. The panel shall be mounted on the inside of the front cabinet door. The detector panel shall be constructed as a single unit. Detector switches with separate operate, test, and off positions shall be provided for each field detector input circuit. A high intensity light emitting diode (LED) shall be provided for each switch. The lamp shall energize upon vehicle, pedestrian or test switch actuation. The test switch shall provide a spring loaded momentary contact that will place a call into the controller. When in the OFF position, respective detector circuits will be disconnected. In the operate position, each respective detector circuit shall operate normally. Switches shall be provided on the panel with labels and functions as follows:

a. Display On — Detector indicator lights shall operate consistent with their respective switches.

b. Display Off — Detector indicator lights shall be de-energized.

A means of disconnecting all wiring entering the panel shall be provided. The disconnect shall include a means to jumper detection calls when the display panel is disconnected. All switches on the panel shall be marked with its associated Plan detector number. All markers shall be permanent.

8. Insulated terminal blocks of sufficient number to provide a termination for all field wiring. A minimum of 12 spare terminals shall be provided. Field wire connection terminal blocks shall be 600 volt, heavy duty, barrier type, except loop detector lead-ins, which may be 300 volt. The 600 volt type terminal strips shall be provided with a field-side and a control-side connector separated by a marker strip. The 300 volt type shall have a marker strip, installed on the right side of vertical terminal strips or below horizontal terminal strips. The marker strip shall bear the circuit number indicated in the Plans and shall be engraved. Each connector shall be a screw type with No. 8 post capable of accepting no less than three 12 AWG wires fitted with spade tips.

9. A vent fan with adjustable thermostat. The minimum CFM rating of the fan shall exceed three times the cabinet volume.

10. All wiring within the cabinet, exclusive of wiring installed by the signal controller manufacturer, shall have insulation conforming to the requirements of Section 9-29.3. Cabinet wiring shall be trimmed to eliminate all slack and shall be laced or bound together with nylon wraps or equivalent. All terminals, shall be numbered and permanently identified with PVC or polyolefin wire marking sleeve consistent with the cabinet wiring diagram provided by the signal controller manufacturer and the Contract. The cabinet will be completely wired so that the only requirement to make a field location completely operational is to attach field power and ground wiring. Internal cabinet wiring shall not utilize the field side connections of the terminal strip intended for termination of field wires.

11. Cabinet wiring diagram and component wiring diagrams meeting the requirements of Section 9-29.13(7) shall be furnished with each cabinet. Each cabinet shall be equipped with a, shelf mounted roll out drawer mounted directly below the controller to house one or more cabinet wiring diagrams. The cabinet wiring diagram shall indicate and identify all wire terminations, all plug connectors, and the locations of all equipment in the cabinet. Included in the diagram shall be an intersection sketch identifying all heads, detectors, and push buttons; and a phase diagram.

12. Each vehicle detector amplifier, video detection output channel pedestrian call isolation unit, phase selector, discriminator, and load switch shall be identified with semi-permanent stick-on type label. The following information shall be included:
    a. Vehicle Detector Amplifier Channel
        i. Loop number
        ii. Assigned phase(s)
    b. Ped Call Isolation Unit
        i. Push button number
        ii. Assigned phase(s)
    c. Load Switches
        i. Signal head number
        ii. Assigned phase(s)
    d. Phase Selectors
        i. Circuit Letter
        ii. Phase(s) called

The label shall be placed on the face of the unit. It shall not block any switch, light, or operational words on the unit. The lettering on this label shall be neat, legible, and easily read from a distance of approximately 6-feet.

9-29.13(10)B Auxiliary Equipment for Type 170E, 2070 Assemblies

The following requirements apply to required auxiliary equipment furnished with Type 170E, 170E-HC-11 and 2070 controllers:

1. Flashers, flash transfer relays, conflict monitor, AC isolators, DC isolators, discriminator modules, program modules, modem modules, breakers, buses, police panel switches, receptacle requirement, vent fan and auxiliary control panel switches shall conform to the requirements noted in the TEES.
2. Flashing operation shall conform to Section 9-29.13(5), except the 6-second flash period described in Item 2 of that section will not be required. Emergency preemption shall conform to Section 9-29.13(6).
3. Input and output terminals shall be installed with a marking strip with field wire numbers noted in the Contract embossed on the strip. All cabinet and field conductor shall have a PVC or polyolefin wire marking sleeve installed, matching the input and output terminals above. Marking on sleeves shall be embossed or type written.
4. The input panel terminal blocks TB 2 through TB 9 and associated cable to the input files as described in the TEES shall be provided in all control assemblies.

5. Supplemental load resistor, not less than 2000 ohms and not greater than 5000 ohms not to exceed 10 watts per monitored circuit, shall be provided to prevent conflict monitor actuation caused by dimming or lamp burn-out.

   An individual supplemental load resistor shall be installed within the output file, and shall be installed on each of the following terminal circuits:

FT1-105 (SP 4P-Y)	FT2-114 (SP 2P-Y)
FT2-117 (SP 3-Y)	FT2-123 (SP 7-Y)
FT3-126 (SP 1-Y)	FT3-132 (SP 5-Y)
FT1-111 (SP 8P-Y)	FT2-120 (SP 6P-Y)
FT2-118 (SP 3-G)	FT2-124 (SP 7-G)
FT3-127 (SP 1-G)	FT3-133 (SP 5-G)

6. Load switches of sufficient quantity to fully populate the output files shall conform to TEES and shall have indicator lights on input and output circuits.

7. A detection panel, which shall be constructed as a single unit. Detector switches with separate operate, test, and off positions shall be provided for each field detector input circuit. A high intensity light emitting diode (LED) shall be provided for each switch. The lamp shall energize upon vehicle, pedestrian or test switch actuation. The test switch shall provide a spring loaded momentary contact that will place a call into the controller. When in the OFF position, respective detector circuits will be disconnected. In the operate position, each respective detector circuit shall operate normally. Switches shall be provided on the panel with labels and functions as follows:

   a. Display On – Detector indicator lights shall operate consistent with their respective switches.

   b. Display Off – Detector indicator lights shall be de-energized.

   A means of disconnecting all wiring entering the panel shall be provided. The disconnect shall include a means to jumper detection calls when the display panel is disconnected. All switches on the panel shall be marked with its associated Plan detector number. All markers shall be permanent.

8. A “Detector Termination and Interface Panel” shall be provided. When viewing the cabinet from the back, the panel shall be located on the upper left hand side of the cabinet. The panel shall be electrically located between the “detection Panel” and the C-1 connector. The panel shall utilize insulated terminal blocks and each connector shall be a screw type with post.

9. Each switchpack socket shall have pin 11 common to Neutral.

10. The AC input Service Panel Assembly (SPA), line voltage filter, transient surge protection and all neutral bus bars and equipment ground bus bars shall be on the right side of the cabinet, mounted no more that 18 inches from the bottom of the cabinet when viewed from the rear, and meet the requirements described in TEES.

11. The PED yellow terminals on the CMU edge connector shall be extended with a 2 foot wire, coiled, heat shrink tipped and labeled for the correct corresponding terminal as CH-13Y/CMU-8, CH-14Y/CMU-11, CH-15Y/CMU-K, CH-16Y/CMU-N.

12. An “Absence of Red Programming Assembly” shall be provided. There shall be provided on the back panel of the output file, 17 accessible jumper plug attachment areas, made up of three male pins per position (one, for each conflict monitor channel and one for red enable function). Each jumper plug shall be a two position connector, It shall be possible, by inserting and positioning one of the 16 connectors on the right two pins on the monitor board, to apply 120 VAC into a corresponding channel of the conflict monitor red channels. The connection between the red monitor board and the conflict monitor shall be accomplished via a 20 pin ribbon cable and the industry standard P-20 connector that attaches on the front panel of the monitor. It shall be possible, by inserting and positioning one of the 16 jumper plugs on the two left pins on the monitor board, to enable the corresponding channel to monitor for red fault by the conflict monitor. There shall be installed on the red monitor board a red fail monitor disable function that controls the 120 VAC red enable signal into the conflict monitor. During stop-and –go operation, 120VAC is sent via pin #20 on the P20 connector to enable red failure monitoring on the conflict monitor by having the connector moved to the side labeled “Red Enable”. If this is disengaged by moving the connector to the side labeled “Red Relay”, then 120VAC is removed from pin #20, and the conflict monitor will no longer monitor for red fail faults. The red enable function will also be wired such that if the traffic signal is in cabinet flash, then there will be no voltage on pin #20, and the conflict monitor will not monitor for red fail faults.
13. Each cabinet shall be provided with at least 20 empty neutral connections to accommodate field wiring. The neutral bus bars shall be of the style in which a lug is not needed to be applied to the neutral field wire(s). All of the neutral bars shall be secured in accordance with the TEES. All neutral bars shall be at the same electrical potential.
14. The main breaker on the SPA shall be provided with a cover to prevent accidental tripping. The cover shall be removable and replaceable without the use of tools.
15. Equipment Branch Breaker –The duplex receptacle on the rear of either PDA #2L or 3L shall be wired in parallel with the ground fault current interrupt receptacle on the front of the power supply. The ground fault current interrupt receptacle being in the “Test” mode shall not remove power to the rear receptacle.

9-29.13(10)C NEMA Controller Cabinets

Each NEMA traffic controller shall be housed in a weatherproof cabinet conforming to the following requirements:

1. Construction shall be of 0.073-inch minimum thickness series 300 stainless steel or 0.125 minimum thickness 5052 H32 ASTM B209 alloy aluminum. The stainless steel shall be annealed or one-quarter-hardness complying with ASTM A666 stainless steel sheet. Cabinets may be finished inside with an approved finish coat of exterior white enamel. If no other coating is specified in the Contract Provisions the exterior of all cabinets shall be bare metal. All controller cabinets shall be furnished with front and rear doors.

2. The cabinet shall contain shelving, brackets, racks, etc., to support the controller and auxiliary equipment. All equipment shall set squarely on shelves or be mounted in racks and shall be removable without turning, tilting, or rotating or relocating one device to remove another. A 24 slot rack or racks shall be installed. The rack(s) shall be wired for 2 channel loop detectors and as follows. Slots 1 & 2 phase 1 loop detectors. Slots 3, 4, & 5 phase 2 loop detectors. Slots 6 & 7 phase 3 loop detectors. Slots 8, 9, & 10 phase 4 loop detectors. Slots 11 & 12 phase 5 loop detectors. Slots 13, 14, & 15 phase 6 loop detectors. Slots 16 & 17 phase 7 loop detectors. Slots 18, 19 & 20 phase 8 loop detectors. Slot 21 upper phase 1 loop detector. Slot 21 lower phase 5 detector. Slot 22 wired for a 2 channel discriminator channels A, C. Slot 23 wired for a 2 channel discriminator, channels B, D. Slot 24 wired for a 4 channel discriminator, wired for channel A, B, C, and D. All loop detector slots shall be wired for presence/pulse detection/extension. If an external power supply is required in order for the entire racks(s) to be powered it shall be installed. All rack(s) slots shall be labeled with engraved identification strips.

3. Additional detection utilizing the “D” connector shall be installed in accordance with the Contract. The cabinet shall be of adequate size to properly house the controller and all required appurtenances and auxiliary equipment in an upright position with a clearance of at least 3-inches from the vent fan and filter to allow for proper air flow. In no case shall more than 70 percent of the cabinet volume be used. There shall be at least a 2-inch clearance between shelf mounted equipment and the cabinet wall or equipment mounted on the cabinet wall.

4. The cabinet shall have an air intake vent on the lower half of the front door, with a 12-inch by 16-inch by 1-inch removable throw away filter, secured in place with a spring-loaded framework.

5. The cabinet door(s) shall be provided with:

    a. Cabinet doors shall each have a three point latch system. Locks shall be spring loaded construction locks capable of accepting a Best 6 pin core. A 6 pin construction core of type (blue, green, or Red) specified in the contract shall be installed in each core lock. One core removal key and two standard keys shall be included with each cabinet and delivered to the Engineer.

    b. A police panel assembly shall be installed in the front door and shall have a stainless steel hinge pin and a police panel lock. Two police keys with shafts a minimum of 1¾-inches long shall be provided with each cabinet.

    c. All doors and police panel door shall have one piece, closed cell, neoprene gaskets.

    d. A two position doorstop assembly.

6. LED light strips shall be provided for cabinet lighting. Each LED light strip shall be approximately 12 inches long, have a minimum output of 320 lumens, and have a color temperature of 4100K (cool white) or higher. Two light strips shall be provided. One light strip shall be ceiling mounted and oriented parallel to the door face. The second light strip shall be mounted under the lower shelf, such that the output terminal landings are illuminated. Lighting shall not interfere with the proper operation of any other ceiling or shelf mounted equipment. All lighting fixtures shall energize automatically when any door is opened. Each door switch shall be labeled "Light".

9-29.13(10)D Cabinets for Type 170E and 2070 Controllers

Type 170E and 2070 controllers shall be housed in a model 332L cabinet unless specified otherwise in the contract. Type 332L cabinets shall be constructed in accordance with TEES with the following modifications:

1. Each door shall be furnished with the equipment listed in Section 9-29.13(10)C item 5 above.
2. The cabinet shall be furnished with auxiliary equipment described in Section 9-29.13(10)B.
3. The cabinet shall be fabricated of stainless steel or sheet aluminum in accordance with Section 9-29.13(10)C, Item 1 above. Painted steel, painted or anodized aluminum is not allowed.
4. A disposable paper filter element with dimensions of 12" × 16" × 1" shall be provided in lieu of a metal filter. The filter shall be secured in the filter holder with a louvered aluminum cover. The maximum depth of the cover shall not be more than 0.5″ inch to provide the filter to be flush against the door. No incoming air shall bypass the filter element.
5. Field wire terminals shall be labeled in accordance with the Field Wiring Chart.
6. LED light strips shall be provided for cabinet lighting, powered from the Equipment breaker on the Power Distribution Assembly. Each LED light strip shall be approximately 12 inches long, have a minimum output of 320 lumens, and have a color temperature of 4100K (cool white) or higher. There shall be three light strips for each rack within the cabinet. Lighting shall be ceiling mounted – rack mounted lighting is not permitted. Light strips shall be installed in the locations shown in the Standard Plans. Lighting shall not interfere with the proper operation of any other ceiling mounted equipment. All lighting fixtures above a rack shall energize automatically when either door to that respective rack is opened. Each door switch shall be labeled "Light".
7. Rack mounted equipment shall be as shown in the Standard Plans. The cabinet shall use PDA #2LX and Output File #1LX. Where an Auxiliary Output File is required, Output File #2LX shall also be included.

8. 332D Controller Cabinet

   a. The 332D Controller cabinet shall have the appearance of two Type 332 controller cabinets joined at opposing sides. The outside Dimensions of the cabinet shall be 67″ High × 48½″ Wide × 30¼″ Deep.

   b. The right side of the cabinet, as viewed from the front, shall be considered the Signal Control side. The left side of the cabinet, when viewed from the front, shall be considered the ITS/COMM side.

   c. One police access panel shall be installed on the right side of the cabinet, as viewed from the front.

   d. Two cabinet lights shall be provided one on each side and as described in Section 9-29.13(10)D6.

   e. The Traffic Signal Control side of the cabinet shall contain the Traffic Signal Controller assembly and shall be furnished with equipment as described in the contract specifications. The Traffic Signal Control side of the cabinet shall also meet all the additional equipment requirements of the Type 332 Signal Controller cabinet as indicated in the contract specifications.

   f. The ITS/COMM side of the cabinet shall contain ITS and Communication equipment and shall be furnished with the following:

      1. One controller shelf unit, mounted 36 inches from the bottom of the cabinet opening to the front of the cabinet and attaching to the front rails of the EIA rack, shall be provided. The shelf shall be fabricated from aluminum and shall contain a rollout flip-top drawer for storage of wiring diagrams and manuals.

      2. One aluminum sheet metal panel, ⅛″ × 15″ × 54″, shall be installed to the rear of the cabinet on the right hand (when facing the front) side railing.

      3. Additional ITS and Communication equipment as described in the Contract Plans and the ITS section of the Contract Special Provisions.

9. The PCB connectors for Field Terminal Blocks FT1 through FT6 on Output Files #1LX and #2LX shall be capable of accepting minimum 14 AWG field wiring, have a pitch of 5.08 mm, and use screw flange type locking to secure the plug and socket connection. The sockets on the Field Terminal Panel shall be secured to the panel such that unplugging a connector will not result in the socket moving or separating from the panel.

9-29.13(11) Traffic Data Accumulator and Ramp Meters

All cabinets designated for use as a traffic data or ramp meter shall be Type 334L cabinets furnished to meet the TEES with the modifications listed in Section 9-29.13(10)D and include the following accessories:

1. Each cabinet shall be equipped with a fully operable controller equipped as specified in the Contract Provisions.
2. Rack mounted equipment shall be as shown in the *Standard Plans*.
3. PDA #3LX shall be furnished with three Model 200 Load Switches installed. PDA #3LX shall be modified to include a second Model 430 transfer relay, mounted on the rear of the PDA and wired as shown in the Standard Plans.
4. Police Panel shall contain only one DPDT toggle switch. The switch shall be labeled POLICE CONTROL, ON-OFF.
5. Display Panel

   a. General

   Each cabinet shall be furnished with a display panel. The panel shall be mounted, showing and providing detection for inputs and specified controller outputs, at the top of the front rack above the controller unit. The display panel shall be fabricated from brushed aluminum and constructed according to the detail in the Plans.

   b. Text

   All text on the detector panel shall be black in color and silk screened directly to the panel except the Phenolic detector and cabinet nameplates.

   A nameplate for each loop shall be engraved with a ¼-inch nominal text according to the ITS Field Wiring Charts. The nameplates shall be permanently affixed to the detector panel.

   c. LEDs

   The LEDs for the display panel shall meet the following Specifications:

Case size	T 1-¾
Viewing angle	50° minimum
Brightness	8 Milli candelas

   LEDs with RED, YELLOW or GREEN as part of their labels shall be red, yellow or green in color. All other LEDs shall be red. All LEDs shall have tinted diffused lenses.

d. Detector panel Control Switch

Each display panel shall be equipped with one detector display control switch on the panel with labels and functions as follows:

ON
Detector panel LEDs shall operate consistent with their separate switches.

OFF
All detector indicator LEDs shall be de-energized. Detector calls shall continue to reach the controller.

TEST
All detector indicator LEDs shall illuminate and no calls shall be placed to the controller.

e. Advance Warning Sign Control Switch

Each display panel shall be equipped with one advance warning sign control switch on the panel with labels and functions as follows:

AUTOMATIC
Sign Relay shall energize upon ground true call from controller.

SIGN OFF
Sign Relay shall de-energize.

SIGN ON
Sign Relay shall energize.

f. Sign Relay

The sign relay shall be plugged into a socket installed on the rear of the display panel. The relay shall be wired as shown in the Plans. The relay coil shall draw (or sink) 50 milliamperes ± 10 percent from the 170E/HC11 controller and have a DPDT contact rating not less than 10 amperes. A 1N4004 diode shall be placed across the relay coil to suppress voltage spikes. The anode terminal shall be connected to terminal #7 of the relay as labeled in the plans. The relay shall energize when the METERING indicator LED is lit.

g. Detector Input Indicators

One LED and one spring-loaded two-position SPST toggle switch shall be provided for each of the 40 detection inputs. These LEDs and switches shall function as follows:

TEST
When the switch is in the test position, a call shall be placed to the controller and energize the associated LED. The switch shall automatically return to the run position when it is released.

RUN
In the run position the LEDs shall illuminate for the duration of each call to the controller.

h. Controller Output Indicators

The display panel shall contain a series of output indicator LEDs mounted below the detection indicators. The layout shall be according to the detail in the Plans. These LEDs shall illuminate upon a ground true output from the controller via the C5 connector.

The output indicator LEDs shall have resistors in series to drop the voltage from 24 volts DC to their rated voltage and limit current below their rated current. The anode connection of each LED to +24 VDC shall be wired through the resistor.

i. Connectors

Connection to the display panel shall be made by three connectors, one pin (labeled P2) and one socket (labeled P1) and one labeled C5. The P1 and P2 connectors shall be 50-pin cannon D series, or equivalent 50 pin connectors and shall be compatible such that the two connectors can be connected directly to one another to bypass the input detection. Wiring for the P1, P2 and C5 connectors shall be as shown in the Plans.

The Contractor shall install wire connectors P1, P2, C1P, C2, C4, C5 and C6 according to the pin assignments shown in the Plans.

6. Model 204 Flasher Unit

Each Model 334 ramp meter cabinet shall be supplied with one Model 204 sign flasher unit mounted on the right rear side panel. The flasher shall be powered from T1-2. The outputs from the flasher shall be wired to T1-5 and T1-6.

7. Fiber Optic Patch Panel

   The Contractor shall provide and install a rack-mounted fiber optic patch panel as identified in the Plans.

   Cabinet Wiring
   Terminal blocks TB1 through TB9 shall be installed on the Input Panel. Layout and position assignment of the terminal blocks shall be as noted in the Plans.

   Terminals for field wiring in traffic data and/or ramp metering controller cabinet shall be labeled, numbered and connected in accordance with the following:

Terminal Block Pos.	Terminal and Wire Numbers	Connection Identification
TBS	501-502	AC Power, Neutral
T1-2	641	Sign on
T1-4	643	Sign off
T1-5	644	Flasher Output NC
T1-6	645	Flasher Output NO
T4-1	631	Lane 3 – Red
T4-2	632	Lane 3 – Yellow
T4-3	633	Lane 3 – Green
T4-4	621	Lane 2 – Red
T4-5	622	Lane 2 – Yellow
T4-6	623	Lane 2 – Green
T4-7	611	Lane 1 – Red
T4-8	612	Lane 1 – Yellow
T4-9	613	Lane 1 – Green

   Loop lead-in cables shall be labeled and connected to cabinet terminals according to the ITS Field Wiring Chart. This chart will be provided by the Engineer within 20 days of the Contractor's request.

9-29.13(12) Type 331L ITS Cabinet

Basic ITS cabinets shall be Model 331L Cabinets, unless otherwise specified in the Contract. Type 331L Cabinets shall be constructed in accordance with the TEES, with the following modifications:

1. The basic cabinet shall be furnished with only Housing 1 B, Mounting Cage 1, Service Panel #1, a Drawer Shelf, and Controller Unit Supports. Additional equipment may be specified as part of the cabinet function-specific standards.
2. Housing aluminum shall be 5052 alloy with mill finish. Painted or anodized aluminum is not allowed.
3. The door air filter shall be a disposable paper filter element of at least 180 square inches.

4. Locks shall be spring loaded construction core locks capable of accepting a Best 6-pin core. A 6-pin construction core of the type (Blue, Green, or Red) specified in the Contract shall be installed in each core lock. One core removal key and two standard keys (properly marked) shall be included with each cabinet and delivered to the Engineer upon Contract completion.

5. Each cabinet shall include a 120VAC electric strip heater with a rating of 100 watts, which shall be thermostat controlled. The heater strip shall be fed by wire with a temperature rating of 400°F or higher, and shall be shielded to prevent contact with wiring, equipment, or personnel. If the heater thermostat is separate from the fan thermostat, the heater thermostat must meet the same requirements as the fan thermostat as defined in TEES.

6. LED light strips shall be provided for cabinet lighting, powered from the Equipment breaker on the Power Distribution Assembly. Each LED light strip shall be approximately 12 inches long, have a minimum output of 320 lumens, and have a color temperature of 4100K (cool white) or higher. There shall be three light strips for each rack within the cabinet. Lighting shall be ceiling mounted – rack mounted lighting is not permitted. Light strips shall be installed in the locations shown in the Standard Plans. Lighting shall not interfere with the proper operation of any other ceiling mounted equipment. All lighting fixtures above a rack shall energize automatically when either door to that respective rack is opened. Each door switch shall be labeled "Light".

7. Each cabinet shall be equipped with a power distribution assembly (PDA) mounted in a standard EIA 19-inch (ANSI/EIA RS-310-C) rack utilizing no more than five Rack Mounting Units (RMU) (8.75 inches). The PDA shall include the following equipment:

   a. One duplex NEMA 5-15R GFCI receptacle on the front of the PDA.

   b. Four duplex NEMA 5-15R receptacles on the rear of the PDA. These receptacles shall remain energized on a trip or failure of the GFCI receptacle.

   c. Four 1P-15A, 120VAC Equipment/Field Circuit Breakers.

   d. Line filter meeting the requirements of Section 9-29.13(10)A.4.

   PDA components shall be mounted in or on the PDA such that they are readily accessible, provide dead front safety, and all hazardous voltage points are protected to prevent inadvertent contact.

8. Service Panel #1 shall include a service terminal block labeled "TBS", a Tesco TES-10B or equivalent surge suppressor connected to provide power in line surge suppression, and a 1P-30A Main Breaker. The Service Panel Assembly (SPA) shown in the TEES shall not be included.

9. Each cabinet shall include a rack mounted fiber optic patch panel of the type specified in the Contract.

Cabinet drawings and wiring diagrams shall be provided in the drawer shelf. Additionally, an electronic (PDF format) copy of all drawings and wiring diagrams shall be provided.

9-29.14 Vacant

9-29.15 Flashing Beacon Control

Line Voltage flashers shall conform to the latest NEMA publication, and shall be solid state. When used as a beacon control, they shall be jack mounted and installed in raintight aluminum or hot-dipped galvanized steel cabinet.

9-29.16 Vehicular Signal Heads, Displays, and Housing

Each signal head shall be of the adjustable, vertical type with the number and type of displays detailed in the Contract; shall provide an indication in one direction only; shall be adjustable through 360 degrees about a vertical axis; and shall be mounted at the location and in the manner shown in the Plans. Except for optically programmed signal heads, all vehicular signal heads at any one intersection shall be of the same make and type.

Backplates shall be constructed of 5-inch-wide, .050-inch-thick corrosion-resistant flat black finish, louvered aluminum, or Polycarbonate attached with stainless steel hardware. A 1-inch-wide strip of yellow retro-reflective, type IV prismatic sheeting (tape), conforming to the requirements of Section 9-28.12, shall be applied around the perimeter of each backplate for displays used in conventional traffic signal systems and overhead intersection control beacons. Retro-reflective tape shall not be installed on backplates for other flashing beacon systems (ground or overhead) or for systems where all sections of the display will be dark as part of normal operation such as ramp meters, hawk signals and tunnels.

9-29.16(1) Optically Programmed, Adjustable Face, and Programmable Array 12-Inch Traffic Signal

The signal shall permit the visibility zone of the indication to be determined optically and require no hoods or louvers. The projected indication may be selectively visible or veiled anywhere within the optical axis. No indication shall result from external illumination, nor shall one light unit illuminate a second. The display shall operate from 85 VAC to 130 VAC.

9-29.16(1)A Optical System

9-29.16(1)A1 Non-LED Optical System

The components of the optical system shall comprise:

1. Lamp,
2. Lamp Collar,
3. Optical Limiter-Diffuser, and
4. Objective Lens.

The lamp shall be nominal 150 watt, 120 volt AC, three prong, sealed beam having an integral reflector with stippled cover and an average rated life of at least 6,000 hours.

The lamp shall be coupled to the diffusing element with a collar including a specular inner surface. The diffusing element may be discrete or integral with the convex surface of the optical limiter.

The optical limiter shall provide an accessible imaging surface at focus on the optical axis for objects 900 to 1,200 feet distant, and permit an effective veiling mask to be variously applied as determined by the desired visibility zone. The optical limiter shall be provided with positive indexing means and composed of heat-resistant glass.

The objective lens shall be a high resolution planar incremental lens hermetically sealed within a flat laminant of weather resistant acrylic or approved equal. The lens shall be symmetrical in outline and may be rotated to any 90 degree orientation about the optical axis without displacing the primary image.

The optical system shall accommodate projection of diverse, selected indicia to separate portions of the roadway such that only one indication will be simultaneously apparent to any viewer after optically limiting procedures have been accomplished. The projected indication shall conform to ITE transmittance and chromaticity standards.

9-29.16(1)A2 LED Programmable Array

1. LED array shall have a programmable visibility from a portable hand-held device from ground level.
2. Lens shall be clear unless color lenses are specified.

The LED array shall be 22 watt maximum and shall operate directly from 120-volt AC.

The LED array shall provide an accessible imaging surface at focus on the optical axis for objects 900 to 1,200 feet distant, and permit an effective veiling mask to be variously applied as determined by the desired visibility zone.

The optical system shall accommodate projection of diverse selected indicia to separate portions of the roadway such that only one indication will be simultaneously apparent to any viewer after optically limiting procedures have been accomplished. The projected indication shall conform to ITE transmittance and chromaticity standards.

9-29.16(1)B Housing Construction

Die cast aluminum parts shall conform to ITE alloy and tensile requirements and have a chromate preparatory treatment. The exterior of the signal case, lamp housing, and mounting flanges shall be finished with a high quality, baked enamel prime and finish paint.

The lens holder and interior of the case shall be optical black.

Signal case and lens holder shall be predrilled for backplates and visors. Hinge and latch pins shall be stainless steel. All access openings shall be sealed with weather resistant rubber gaskets.

9-29.16(1)C Mounting

The signal shall mount to standard 1½-inch fittings as a single section, as a multiple section face, or in combination with other signals. The signal section shall be provided with an adjustable connection that permits incremental tilting of at least 0 to 10 degree above or below the horizontal while maintaining a common vertical axis through couplers and mounting. Terminal connection shall permit external adjustment about the mounting axis in five degree increments. The signal shall be mountable with ordinary tools and capable of being serviced with no tools.

Attachments such as visors, backplates, or adapters shall conform and readily fasten to existing mounting surfaces without affecting water and light integrity of the signal.

9-29.16(1)D Housing Electrical

9-29.16(1)D1 Electrical – Non-LED

The lamp fixture shall be comprised of a separately accessible housing and integral lamp support, indexed ceramic socket, and self-aligning, quick release lamp retainer. The electrical connection between case and lamphousing shall be accomplished with an interlock assembly which disconnects lamp holder when opened. Each signal section shall include a covered terminal block for clip or screw attachment of lead wires. Concealed 18 AWG-AWM, stranded and coded wires shall interconnect all sections to permit field connection within any section.

9-29.16(1)D2 Electrical – LED

The Light Emitting Diode (LED) array shall be accessible from the front of the housing. Each multi-section assembly shall include a terminal block for clip or screw attachment of lead wires.

9-29.16(1)E Photo Controls

9-29.16(1)E1 Conventional Photo Controls

Each signal section shall include integral means for regulating its intensity between limits as a function of individual background illumination. Lamp intensity shall not be less than 97 percent of uncontrolled intensity at 1,000 ft-c ambient and shall reduce to 15 plus or minus 2 percent of maximum at less than 1 ft-c ambient. Response shall be proportional and essentially instantaneous to any detectable increase of illumination from darkness to 1,000 ft-c ambient and damped for any decrease from 100 ft-c ambient.

The intensity controller shall comprise an integrated, directional light, sensing and regulating device interposed between lamp and line wires. It shall be compatible with 60 Hz input and responsive within the range 105 VAC to 135 VAC. Output may be phase controlled, but the device shall provide a nominal terminal impedance of 1,200 ohms open circuit and a corresponding holding current.

9-29.16(1)E2 LED Photo Controls

Each signal section shall include an integral means to automatically regulate the display intensity for day and night operation.

9-29.16(1)F Installation

The signal shall be installed, directed, and veiled in accordance with published instructions and the project visibility requirement. Each section of the signal shall be masked with prescribed materials in an acceptable and workmanlike manner.

9-29.16(2) Conventional Traffic Signal Heads

9-29.16(2)A Optical Units

LED light sources are required for all displays. The Contractor shall provide test results from a Nationally Recognized Testing Laboratory documenting that the LED display conforms to the current ITE Specification for Vehicle Traffic Control Signal Heads, Light Emitting Diode Circular Signal Supplement VTCSH ST-052 or Vehicle Traffic Signal Heads, Light Emitting Diode Vehicle Arrow Traffic Signal Supplement ITE VTCSH ST-054, and the following requirements:

1. The LED traffic signal module shall be operationally compatible with controllers and conflict monitors on this project, and the LED lamp unit shall contain a disconnect that will show an open switch to the conflict monitor when less than 60 percent of the LEDs in the unit are operational.
2. LEDs shall have a 50-degree minimum viewing angle.
3. **Wattage (Maximum)** – 12 inch red, yellow, and green ball displays – 25 W
   12 inch red, yellow, and green arrow displays – 15 W
   8 inch red, yellow, and green ball displays – 15 W
4. **Voltage** – The operation voltages shall be between 85 VAC and 130 VAC.
5. The LED display shall be a module type and shall replace the lens, socket, bail, and reflector and be directly connected to the terminal strip in the signal head.
6. **Label** – Each optical unit shall be listed by and bear the label of a Nationally Recognized Testing Laboratory. In addition, the manufacturer's name, trademark, serial number, and other necessary identification shall be permanently marked on the back side of the LED signal module, and the installation date shall be indicated on a separate label with an indelible ink marker.
7. LED ball displays shall have a uniform "incandescent" appearance. Individual LEDs or pixels shall not be visible.

9-29.16(2)B Signal Housing

The signal head housing, or case, shall consist of an assembly of separate sections, expandable type for vertical mounting, substantially secured together in a weathertight manner. Each section shall house an individual optical unit.

Each section shall be complete with a one-piece, corrosion-resistant aluminum alloy die cast door and shall have a nominal 8- or 12-inch diameter opening for the lens. Each door shall be of the hinged type having two integrally cast hinge lugs and latch jaw. The door shall be attached to the housing by means of two noncorrosive, stainless steel hinge pins that are removable without the use of a special press or tool. A noncorrosive, stainless steel, threaded latch bolt and matching wing nut shall provide for opening and closing the door without the use of any special tools. Each door shall have a cellular neoprene gasket around the entire outer edge of the door, which, when the door is closed, shall make a positive weather and dust-tight seal. Each door shall have four tapped holes spaced about the circumference of the lens opening with four noncorrosive screws to accommodate the signal head visors. Each door shall have some device such as washers, clips, or keys, or be constructed so as to keep it from dismounting from the housing accidentally when it is open.

The body of each signal section shall consist of a one piece corrosion resistant, die cast aluminum alloy. Each section shall have serrated rings top and bottom so when used with proper brackets, each section may be adjustable in respect to an adjoining section, and the hangers shall be locked securely to prevent moving. Cast integrally with the housing shall be two hinge lugs and one latch jaw. The top and bottom of the housing shall have an opening to accommodate standard 1½-inch pipe brackets. The sections shall be so designed that when assembled, they interlock with one another forming one continuous weathertight unit. The sections shall be interchangeable and shall be dust and weathertight when assembled with the door and appropriate furnished hardware.

A terminal block of an approved type shall be mounted inside at the back of the housing. All sockets shall be so wired that a white wire will be connected to the shell of the socket and a wire, the color of the lens, to the bottom, or end terminal of the socket. These wires shall in turn be connected to the terminal block mounted in the housing, in the proper manner. The terminal block shall have sufficient studs to terminate all field wires and lamp wires independently to the block with separate screws. The terminals to which field wires are attached shall be permanently identified to facilitate field work.

Each face shall be protected with a removable visor. The visor shall be tunnel type unless noted otherwise in the Contract. Tunnel, cap, and cut away type visors shall be molded using ultraviolet and heat stabilized polycarbonate plastic or be constructed of 0.050-inch corrosion resistant aluminum material throughout as specified in the Contract, or as ordered by the Engineer in accordance with Section 1-04.4. Visors shall be flat black in color inside and shall be flat black or dark green on the outside. Visors shall have attaching ears for installation to the housing door. The signal display shall have square doors. End caps shall be made from aluminum or plastic material and shall be installed with fittings to provide a watertight seal. A bead of silicone sealant shall be applied around the perimeter of all top end cap openings prior to installation of the end cap assembly. Plastic end caps shall utilize a threaded stud with seal and wing nut. Plastic end caps utilizing a metal screw that may damage the cap if overtightened will not be allowed. Plastic end caps shall have the same color as the signal housing.

9-29.16(2)C Louvered Visors

Where noted in the Contract, louvered tunnel visors shall be furnished and installed. Directional, Geometrically Programmed louvers shall be constructed to have a snug fit in the signal visor. Louvers shall be flat black, constructed of aluminum or ABS and polycarbonate plastic. Dimensions and arrangement of louvers shall be as shown in the Contract.

9-29.16(2)D Vacant

9-29.16(2)E Painting Signal Heads

Traffic signal heads shall be finished with two coats of factory applied traffic signal green baked enamel or shall be finished with a dark green oven baked powder coating comprised of resins and pigments. Aluminum end caps shall be painted to match the color of the signal housing.

9-29.16(3) Polycarbonate Traffic Signal Heads

Polycarbonate signal heads shall be provided only when specifically identified in the Contract. With the exception of top and bottom bracket mountings, polycarbonate signal heads shall be installed with approved reinforcing plates located in signal sections adjacent to the mounting hardware.

Polycarbonate employed in traffic signal fabrication shall tolerate an elongation prior to break in excess of 90 percent. The green color shall be molded throughout the head assembly. The optical system shall be Light Emitting Diodes as defined in Section 9-29.16(2)A. The entire optical system shall be sealed by a single neoprene gasket. The signal head shall be formed to be used with standard signal head mounting accessories as shown in Section 9-29.17. All hinge pins, latch assemblies, and reflector assemblies shall conform to Section 9-29.16(2)B.

9-29.16(4) Traffic Signal Cover

Traffic signal display covers shall be manufactured from a durable fabric material with a mesh front. Plastic bags, plastic sheeting, burlap, or similar makeshift covers are not allowed. The covers shall have an attachment method that will hold the cover securely to the signal in heavy wind, such as straps, buckles, or elastic drawstrings – no adhesives may be used. The covers shall be provided with a drain to expel any accumulated water.

One cover shall cover an entire signal display – separate covers for each lens are not allowed. For vehicle displays, if the cover is not designed to go over the backplate, the backplate shall be removed until the display is placed into service.

At any intersection where there is a combination of operational and covered signal heads, signal head covers shall be yellow or orange in color. At an intersection where there are no existing operational signal displays, the covers may be black in color. The text “Not in Service”, “Out of Service”, or similar may be included on the cover, but it is not required.

9-29.17 Signal Head Mounting Brackets and Fittings

Vehicle and pedestrian signal head mountings shall be as detailed in the *Standard Plans*. Material requirements for signal head mounts are as follows:

Aluminum

1. Hinge fittings for Type E mount.
2. Arms and slotted tube fittings for Type N mount.
3. Tube clamp and female clamp assembly for Type N mount.

Bronze

1. Terminal compartments for Type A, B, C, F, H, and K mounts.
2. Collars for Type C, D, and F mounts.
3. Ell fittings for Type L and LE mounts.
4. Plumbizer for type M mounts.
5. Messenger hanger and wire entrance fittings for Type P, Q, R, and S mounts.
6. Balance adjuster for Type Q, R, and S mounts.

Galvanized Steel

1. Washers for Type A, B, C, D, F, H, and K mounts.
2. Fasteners for Type A, B, E, H, and K mounts.

Stainless Steel

1. All set screws and cotter Keys.
2. Bands or cables for Type N mount.
3. Hinge pins for Type E mount.
4. Bolts, nuts and washers for Type M mount.
5. Bolt, nut and washers for Type L mount.
6. Bolts, nuts, washers, and screw buckle swivels.

Steel

1. Center pipes, nipples, elbow, and tee fittings for Type A, B, C, F, H, and K mounts.
2. Multi-head mounting assemblies and spider assemblies for Type Q, R, and S mounts.
3. Nipples for Type L, LE, P, Q, R, and S mounts.

Fittings for Type N mounts shall be installed unpainted. All other hardware for other mounts shall be painted with two coats of factory applied traffic signal green baked enamel.

Pins for messenger hanger fittings shall be a minimum of ½ inch in diameter.

Terminal compartments for Type A, B, C, F, H, and K mounts shall contain a 12 section terminal block.

9-29.18 Vehicle Detector

Induction loop detectors and magnetometer detectors shall comply with current NEMA Specifications when installed with NEMA control assemblies and shall comply with the current California Department of Transportation document entitled "Transportation Electrical Equipment Specifications", specified in Section 9-29.13(7) when installed with Type 170, Type 2070, or NEMA control assemblies.

9-29.18(1) Induction Loop Detectors

When required in the Contract, amplifier units shall be provided with supplemental timing features identified as follows:

1. **Delay Timing** – When delay timing is required, the unit shall delay detector output for up to 15 seconds minimum, settable in one second maximum intervals.
2. **Delay Timing With Gate** – When delay timing with gate is required, the unit shall provide delay timing features as noted above with the additional capability of inhibiting delay timing when an external signal is applied.
3. **Extension Timing** – When extension timing is required, the unit shall extend the detector output for up to 7 seconds minimum, settable in 0.5 second minimum intervals.
4. **Delay and Extension Timing With Gate** – When delay and extension timing with gate is required, the unit shall provide both delay and extension timing features as noted above with the additional capability of inhibiting delay while enabling extension upon application of an external signal. Without external signal, the unit shall inhibit extension and enable delay.

9-29.18(2) Magnetometer Detectors

Magnetometer detector units and sensors shall conform to the following Specifications:

1. **Operation** – The magnetometer detector unit shall respond to changes in the earth's local magnetic field caused by the passage of a vehicle containing iron or steel over the sensor unit.
2. **Environmental Requirements** – Satisfactory operation shall be attained over the ambient temperature range from -30°F to 160°F. Operation shall be unaffected by temperature change, water, ice, pavement deterioration, or electromagnetic noise.
3. **Modes of Operation** – Each detector channel shall be capable of functioning in any of four front-panel selectable modes:
    a. **Presence** – Time of detection shall be unlimited.
    b. **Extended Presence** – The detection output shall extend for a timer set value of up to 5 seconds after the detection zone has cleared.

c. **Pulse** – A single 30- to 50-millisecond pulse will be generated per detection actuation.

d. **Inhibited Pulse** – The detection output will be inhibited for a time set value of up to 5 seconds after the detection zone has cleared.

4. Response Time. Pick up and drop out times shall be consistently within 10 milliseconds.

5. Approach Speed. The unit shall be capable of detecting vehicles traveling from 0 to 80 mph.

6. Sensor Probes. Each channel of the detector unit shall be capable of operating up to three sensing probes.

9-29.19 Pedestrian Push Buttons

Where noted in the Contract, pedestrian push buttons of tamper-resistant construction shall be furnished and installed. They shall consist of a 2-inch nominal diameter plunger. The switch shall be a three-bladed beryllium copper spring, rated at 10 amperes, 125 volts.

The pedestrian push-button assembly shall be constructed and mounted as detailed in the Contract.

9-29.20 Pedestrian Signals

Pedestrian signals shall be Light Emitting Diodes (LED) type.

The LED pedestrian signal module shall be operationally compatible with controllers and conflict monitors. The LED lamp unit shall contain a disconnect that will show an open switch to the conflict monitor when less than 60 percent of the LEDs in the unit are operational.

The Pedestrian signal heads shall be on the QPL or Contractor shall submit a Manufacturer's Certificate of Compliance, in accordance with Section 1-06.3, with each type of signal head. The certificate shall state that the lot of pedestrian signal heads meet the following requirements:

1. All pedestrian signal heads shall be a Walk/Don't Walk module with a countdown display.

2. All pedestrian displays shall comply with the MUTCD and ITE publication ST 011B, VTCSH2 or current ITE Specification and shall have an incandescent appearance. The Contractor shall provide test results from a Nationally Recognized Testing Laboratory documenting that the LED display conforms to the current ITE and the following requirements:

a. All pedestrian signals supplied to any one project shall be from the same manufacturer and type but need not be from the same manufacturer as the vehicle heads.

b. Each pedestrian signal face shall be a single unit housing with the signal indication size, a nominal 16 inch × 18 inch with side by side symbol messages with countdown display.

c. Housings shall be green polycarbonate or die-cast aluminum and the aluminum housings shall be painted with two coats of factory applied traffic signal baked green enamel. All hinges and latches and interior hardware shall be stainless steel.

3. Optical units for traffic signal displays shall conform to the following:

a. Pedestrian "RAISED HAND" and "WALKING PERSON" modules shall be the countdown display type showing the time remaining in the pedestrian change interval. When the pedestrian change interval is reduced due to a programming change, the display may continue to show the previous pedestrian change interval for one signal cycle. During the following pedestrian change interval the countdown shall show the revised time, or shall be blank. In the event of an emergency vehicle preemption, during the following two cycles, the display shall show the programmed pedestrian change interval or be blank. In the event the controller is put in stop time during the pedestrian change interval, during the following two cycles the display shall show the programmed clearance or be blank. In the event there is railroad preempt during the pedestrian change interval, during the following two cycles the display shall show the programmed clearance or be blank. Light emitting diode (LED) light sources having the incandescent appearance are required for Portland Orange Raised Hand and the Lunar White Walking Person.

4. LED displays shall conform to the following:

a. Wattage (Maximum) – Portland Orange Raised Hand, 15 watts: Lunar White Walking Person, 15 watts.

b. Voltage – The operating voltages shall be between 85 VAC and 135 VAC.

c. Temperature – Temperature range shall be -35°F to +165°F.

d. LED pedestrian heads shall be supplied with Z crate visors. Z crate visors shall have 21 members at 45 degrees and 20 horizontal members.

e. LED pedestrian displays shall have a uniform "incandescent" appearance. Individual LEDs or pixels shall not be visible.

9-29.21 Flashing Beacon

Flashing beacons shall be installed as detailed in the Plans, as specified in the Special Provisions, and as described below:

Controllers for flashing beacons shall be as specified in Section 9-29.15.

Beacons shall consist of single section, 8 or 12-inch traffic signal heads, three or four-way adjustable, meeting all of the applicable requirements of Section 9-29.16. Displays (red or yellow) may be either LED type or incandescent. Twelve-inch yellow displays shall be dimmed 50 percent after dark.

Mounting brackets, mountings, and installation shall meet all applicable requirements of Section 9-29.17.

Lenses shall be either red or amber, glass or polycarbonate as noted in the Plans.

9-29.22 Vacant

9-29.23 Vacant

9-29.24 Service Cabinets

In addition to the requirements for service cabinets indicated in the Contract, the following requirements shall apply:

1 Display an arc flash and shock hazard warning label that meets the requirements of NFPA 70E Article 130.5(H) and ANSI Z535, with the following information:

a. Nominal System Voltage

b. Arc Flash Boundary (in inches)

c. Available Incident Energy (in cal/cm^2)

d. Working Distance (in inches)

e. Minimum arc rating of clothing (in cal/cm^2)

f. Shock Hazard Limited Approach Distance (in inches)

g. Shock Hazard Restricted Approach Distance (in inches)

h. Date of calculation.

The top of the tag shall normally include the word “WARNING” in black text on an orange background. For systems over 600 volts or where the incident energy exceeds 40 cal/cm^2, the word “DANGER” shall be used with a red background instead.

2. All electrical conductors, buss bars, and conductor terminals shall be copper. Conductor insulation shall be either THW, XHHW, USE, or SIS.

3. If field wiring larger than that which the contactors or breakers will accommodate is required by the Contract, a terminal board shall be supplied for use as a splicing block.

4. The minimum size of all other load carrying conductors used within the service cabinets shall be based on the National Electrical Code ampacity tables for not more than three conductors in a raceway or cable.

5. Type B, B Modified, C, D, and E Cabinets shall have ventilation louvers on the lower sides complete with screens. Type D and E shall also have rain-tight cabinet vents with screens at the top. Cabinet vents shall be gasketed.

6. The Type B modified cabinets shall have one future use double pole circuit breaker. Type D and E cabinets shall have two future use double pole circuit breakers. The dead front cover shall have cutouts with for the entire breaker array, with blank covers where no circuit breakers are installed. The receptacle shall be ground fault interrupter equipped.

7. The minimum size of control circuit conductors used in service cabinets shall be 14 AWG stranded copper.

   All electrical contactors shall have the loadside terminals toward the front (door side) of the service cabinet.

8. Lighting contactors shall meet the requirements of Section 9-29.24(2).

9. All service enclosures shall be fabricated from steel or aluminum. If aluminum, they shall be fabricated from 0.125 inch (minimum) 5052 H 32 ASTM designator or B209 aluminum. If steel, they shall be fabricated from 12-gage (minimum) steel, hot-dipped galvanized per AASHTO M111.

10. All doors and dead front panels installed in service cabinets shall incorporate a hinge placed in a vertical plane. Service doors shall be sealed with closed cell gasket material. The side opposite the hinge shall be secured with quarter turn screws or slide latch. No electrical devices shall be connected to the dead front panel. However, every switch serviced through the dead front panel shall be appropriately identified with its respective circuit designation by means of a screwed or riveted engraved name plate. Such circuit identification shall be submitted for approval together with the appropriate fabrication drawings. Dead front panels shall prevent access to any exposed, live components, and shall cover all equipment except for circuit breakers (including blank covers), the photocell test/bypass switch, and the GFCI receptacle.

11. A typed index of all circuits shall be mounted on the cabinet door. Each index shall show an entire panel section without folding. Index holders shall have metal returns on the sides and bottom. A schematic of the main panel, any subpanels, circuits, and control circuits shall be provided. The schematic shall be plastic coated and secured in a metal holder.

9-29.24(1) Vacant

9-29.24(2) Electrical Circuit Breakers and Contactors

All circuit breakers shall be bolt-on type, with the RMS-symmetrical interrupting capacity described in this Section. Circuit breakers for 120/240/277 volt circuits shall be rated at 240 or 277 volts, as applicable, with an interrupting capacity of not less than 10,000 amperes. Circuit breakers for 480 volt circuits shall be rated at 480 volts, and shall have an interrupting capacity of not less than 14,000 amperes.

Lighting contactors shall be rated for tungsten or ballasted (such as sodium vapor, mercury vapor, metal halide, and fluorescent) lamp loads. Contactors for 120/240/277 volt circuits shall be rated at 240 volts maximum line to line voltage, or 277 volts maximum line to neutral voltage, as applicable. Contactors for 480 volt circuits shall be rated at 480 volt maximum line to line voltage.

9-29.25 Amplifier, Transformer, and Terminal Cabinets

Amplifier, Terminal, and Transformer cabinets shall be NEMA 3R and the following:

1. All cabinets shall be constructed of welded 14 gage (minimum) hot-dipped galvanized sheet steel, 14-gage, minimum type 316 stainless steel or 0.125 inch, minimum 5052 alloy aluminum H32 ASTM designator minimum.
2. Nominal cabinet dimensions shall be:

		Depth	Height	Width
a.	Terminal	8″	16″	12″
b.	Terminal	8″	24″	18″
c.	Transformer up to 12.5 KVA	20″	48″	24″
	Transformer 12.6 to 35 KVA	30″	60″	32″

3. Cabinet doors shall have a stainless steel piano hinge or shall meet the requirements for the alternate hinge detailed for type B modified service cabinets. Doors less than 3 feet in height shall have two hinges. Doors from 3 feet to 4′ 8″ in height shall have three hinges. Spacing of hinges for doors greater than 4′ 8″ in height shall not exceed 14 inches center to center. The door shall also be provided with a three-point latch and a spring loaded construction core lock capable of accepting a Best six pin CX series core. The locking mechanism shall provide a tapered bolt. The Contractor shall supply construction cores with two master keys. The keys shall be delivered to the Engineer. Three-point latches are not required for terminal cabinets.
4. All seams shall be continuously welded.
5. All cabinets shall provide a gasketed door flange.
6. Transformer cabinets shall provide a 9-square-inch minimum louvered vent.
7. Insulated terminal blocks shall be 600 volt, heavy-duty, barrier type. The terminal blocks shall be provided with a field-side and a control-side connector separated by a marker strip. One spare 12-position insulated terminal block shall be installed in each terminal cabinet and amplifier cabinet.

8. Each non-pad mounted Terminal, Amplifier and Transformer cabinet shall have ¼ inch drain holes in back corners. Each pad mounted Terminal, Amplifier and Transformer cabinet shall drain to a sump and through a ⅜ inch diameter drain pipe to grade as detailed in the *Standard Plans*.
9. Mounting shall be as noted in the Contract.
10. Transformer cabinets shall have two separate compartments, one for the transformer and one for the power distribution circuit breakers. Each compartment shall be enclosed with a dead front. There shall be an isolation breaker on the input (line) side of the transformer, and a breaker array on the output (load) side. Each breaker shall be labeled with the device name by means of a screwed or riveted engraved name plate.

9-30 Water Distribution Materials

This Specification addresses pipe and appurtenances 16 inches in diameter and smaller. Water distribution material incorporated in the Work shall be new.

The Contractor shall provide to the Engineer the names of the manufacturer(s) of the water distribution materials proposed for inclusion in the Work, which materials shall conform in every respect to these Specifications. If so required by the Special Provisions, the Contractor shall provide to the Engineer in addition to the names of the manufacturer(s) of the water distribution materials, a Manufacturer's Certificate of Compliance meeting the provisions of Section 1-06.3, for the materials proposed for inclusion in the Work. As used in this Specification, the term "lot of material delivered to the Work" shall mean a shipment of the water distribution materials as it is delivered to the Work.

The Engineer shall have free access to all testing and records pertaining to material to be delivered to the job site. The Engineer may elect to be present at any or all material testing operations.

9-30.1 Pipe

All pipe shall be clearly marked with the manufacturer's name, type, class, and thickness as applicable. Lettering shall be legible and permanent under normal conditions of handling and storage.

9-30.1(1) Ductile Iron Pipe

1. Ductile iron pipe shall meet the requirements of AWWA C151. Ductile iron pipe shall have a cement mortar lining and a 1-mil thick seal coat meeting the requirements of AWWA C104. Ductile iron pipe to be joined using bolted flanged joints shall be Special Thickness Class 53. All other ductile iron pipe shall be Special Thickness Class 50, minimum Pressure Class 350, or the class indicated in the Plans or the Special Provisions.
2. Nonrestrained joints shall be either rubber gasket type, push on type, or mechanical type meeting the requirements of AWWA C111.
3. Restrained joints shall be as specified in Section 9-30.2(6).

9-30.1(2) Polyethylene Encasement

Polyethylene encasement shall be tube-form high-density cross-laminated polyethylene film or linear low-density polyethylene film meeting the requirements of ANSI/AWWA C105. Color shall be natural or black.

9-30.1(3) Vacant

9-30.1(4) Steel Pipe

9-30.1(4)A Steel Pipe (6 inches and Over)

Steel pipe 6 inches in diameter and larger shall conform to AWWA C200. The type of protective coating and lining and other supplementary information required by AWWA C200 shall be included in the Special Provisions.

9-30.1(4)B Steel Pipe (4 inches and Under)

Steel pipe 4 inches in diameter and smaller shall be hot-dip galvanized inside and out and meet the requirements of ASTM A53.

9-30.1(5) Polyvinyl Chloride (PVC)

9-30.1(5)A Polyvinyl Chloride (PVC) Pipe (4 inches and Over)

PVC pipe for water mains shall meet the requirements of ANSI/AWWA C900 or ANSI/AWWA C905. PVC pipe shall have the same outside dimensions as ductile iron pipe. PVC pipe for distribution pipelines shall be a minimum of SDR 18. Pipe shall be listed by Underwriters' Laboratories, Inc.

PVC pipe shall be considered flexible conduit. Joints shall meet the requirements of ASTM D3139 using a restrained rubber gasket conforming to ASTM F477. Solvent welded pipe joints are not permitted.

9-30.1(5)B Polyvinyl Chloride (PVC) Pipe (Under 4 inches)

Polyvinyl chloride (PVC) under 4 inches shall meet the requirements of ASTM D2241. Pipe material shall be PVC 1120, PVC 1220, or PVC 2120, and shall have minimum wall thickness equal or greater than a standard dimension ratio (SDR) of 21. Pipe shall bear the National Sanitation Foundation Seal for use to transport potable water. Pipe shall be considered flexible conduit. Joints shall meet the requirements of ASTM D3139 using a restrained rubber gasket meeting the requirements of ASTM F477.

9-30.1(6) Polyethylene (PE) Pressure Pipe (4 inches and Over)

PE pressure pipe for water mains shall meet the requirements of ANSI/AWWA C906. Pipe materials shall be high-density polyethylene PE 4710 conforming to a minimum cell class 345464 C, D or E in accordance with ASTM D3350. Pipe diameter shall be either iron pipe size in accordance with Table 3 and Table 4 of ANSI/AWWA C906. Pipe pressure class shall be as listed in Table 5 of ANSI/AWWA C906 for DR 9 PE 4710 material.

9-30.2 Fittings

Bolts, nuts, and washers used for securing fittings shall be of similar materials. Steel bolts shall meet the requirements of ASTM A307 or ASTM F568 for carbon steel or ASTM F593 or ASTM F738 for stainless steel. Nuts shall meet the requirements of ASTM A563 for carbon steel or ASTM F594 or ASTM F836 for stainless steel. Iron bolts and nuts shall meet the requirements of ASTM A536, grade 65-45-12.

9-30.2(1) Ductile Iron Pipe

Fittings for ductile iron pipe shall meet the requirements of AWWA C110 or AWWA C153. Joints shall meet the requirements of AWWA C111. Fittings shall be cement mortar lined, meeting the requirements of AWWA C104. Gaskets for flat faced or raised faced flanges shall be ⅛-inch-thick neoprene having a durometer of 60 plus or minus 5 or 1/16 cloth inserted. The type, material, and identification mark for bolts and nuts shall be provided.

9-30.2(2) Vacant

9-30.2(3) Vacant

9-30.2(4) Steel Pipe

9-30.2(4)A Steel Pipe (6 inches and Over)

Fittings for steel pipe 6 inches and larger shall be bell and spigot or welded to match the pipe joints. Welded joints shall conform to AWWA C206. Field couplings shall be bolted, sleeve-type for plain-end pipe conforming to AWWA C219. Expansion joints shall be fabricated steel mechanical slip-type conforming to AWWA C221.

When flanges are required, they shall conform to AWWA C207. Linings and coatings for fittings shall be the same as specified for the adjacent pipe.

9-30.2(4)B Steel Pipe (4 inches and Under)

Fittings for steel pipe 4 inches and under shall be malleable iron threaded type with a pressure rating of 150 psi. Dimensions shall meet the requirements of ANSI B16.3. Threading shall meet the requirements of ANSI B2.1. Material shall meet requirements of ASTM A47M, Grade 32510. Fittings shall be banded and hot-dip galvanized inside and out.

9-30.2(5) Polyvinyl Chloride (PVC) Pipe

9-30.2(5)A Polyvinyl Chloride (PVC) Pipe (4 inches and Over)

Fittings for PVC pipe shall be the same as specified for ductile iron pipe.

9-30.2(5)B Polyvinyl Chloride (PVC) Pipe (Under 4 inches)

Fittings for PVC pipe under 4 inches shall meet the requirements of ASTM D2466.

9-30.2(6) Restrained Joints

The restraining of ductile iron pipe, fittings, and valves shall be accomplished by the use of either a bolted or boltless system. Any device utilizing round point set screws shall not be permitted.

All couplings installed underground to connect ductile iron or PVC pipe shall be manufactured of ductile iron.

9-30.2(7) Bolted, Sleeve-Type Couplings for Plain End Pipe

Bolted, sleeve-type couplings, reducing or transition couplings, and flanged coupling adapters used to join plain-end pipe shall meet the requirements of AWWA C219. Buried couplings to connect ductile iron, gray cast iron, or PVC pipe shall be ductile iron. Buried couplings for connecting steel pipe to steel pipe shall be steel.

9-30.2(8) Restrained Flexible Couplings

Restrained flexible couplings shall be locking type couplings in accordance with the Plans or Special Provisions. Any couplings that utilize set screws tightened against the outside pipe wall are not acceptable. Coupling shall be epoxy coated.

9-30.2(9) Grooved and Shouldered Joints

Grooved and shouldered joints shall conform to AWWA C606. Rigid or flexible grooved or shouldered joints shall be as specified in the Special Provisions.

9-30.2(10) Polyethylene (PE) Pipe (4 inches and Over)

Fittings for PE pipe shall meet the requirement of ANSI/AWWA C906. Pipe material shall be high-density polyethylene PE3408 conforming to minimum cell class 345464 C, D or E per ASTM D3350. Pipe diameter shall be either iron pipe size per Table 3 and Table 5 of ANSI/AWWA C906 or ductile iron pipe size per Table 7 and Table 8 of ANSI/AWWA C 906. Pipe pressure class shall be as listed in Table 9 of ANSI/AWWA C 906 for DR 9 PE3408 material.

9-30.2(11) Fabricated Steel Mechanical Slip-Type Expansion Joints

Fabricated steel mechanical slip-type expansion joints shall meet the requirements of ANSI/AWWA C 221. Buried Expansion joints to connect ductile iron or PVC pipe shall be ductile iron. Buried expansion joints for connecting steel pipe to steel pipe shall be steel.

9-30.3 Valves

Valves shall be provided with hand wheels or operating nuts as designated. Where operating nuts are called for, a standard 2-inch operating nut shall be furnished. Valves shall be nonrising stem type, open counterclockwise, and be equipped with an O ring stuffing box.

9-30.3(1) Gate Valves (3 to 16 inches)

Gate valves shall meet the requirements of AWWA C509 or AWWA C515. Gate valves 16 inches in size shall be arranged for operation in the horizontal position by enclosed bevel gearing.

The Contractor shall provide an affidavit of compliance stating that the valve furnished fully complies with AWWA C509 or AWWA C515.

9-30.3(2) Vacant

9-30.3(3) Butterfly Valves

Butterfly valves shall be rubber seated and shall meet the requirements of AWWA C504, Class 150B. Butterfly valves shall be suitable for direct burial.

Valve operators shall be of the traveling nut or worm gear type, sealed, gasketed, and permanently lubricated for underground service. Valve operators shall be constructed to the standard of the valve manufacturer to withstand all anticipated operating torques and designed to resist submergence in ground water.

The Contractor shall provide an affidavit of compliance stating that the valve furnished fully complies with AWWA C504.

9-30.3(4) Valve Boxes

Valve boxes shall be installed on all buried valves. The box shall be of cast iron, two piece slip type standard design with a base corresponding to the size of the valve. The box shall be coal tar painted by the manufacturer using its standard. The cover shall have the word “WATER” cast in it.

9-30.3(5) Valve Marker Posts

Posts shall have a 4-inch minimum square section and a minimum length of 42 inches, with beveled edges and shall contain at least one No. 3 bar reinforcing steel.

The exposed portion of the marker posts shall be coated with two coats of concrete paint in a color selected by the Contracting Agency.

The size of the valve and the distance in feet and inches to the valve shall be stenciled on the face of the post, using black paint and a stencil which will produce letters 2 inches high.

9-30.3(6) Valve Stem Extensions

Valve stem extensions shall have a 2-inch-square operating nut and self-centering rockplate support. Valves with an operating nut more than 4 feet below grade shall have a valve stem extension to raise the operating nut to within 36 inches of the ground surface.

9-30.3(7) Combination Air Release/Air Vacuum Valves

Combination air release/air vacuum valves shall be designed to operate with potable water under pressure to permit discharging a surge of air from an empty line when filling and relieve the vacuum when draining the system. The valves shall also release an accumulation of air when the system is under pressure. This shall be accomplished in a single valve body designed to withstand 300 psi.

The body and cover shall be cast iron conforming to ASTM A48, Class 30. Floats shall be stainless steel conforming to ASTM A240 and designed to withstand 1,000 psi. Seats shall be Buna N rubber. Internal parts shall be stainless steel or bronze.

9-30.3(8) Tapping Sleeve and Valve Assembly

Tapping valves shall be furnished with flanged inlet end connections. The outlet ends shall conform in dimensions to the AWWA Standards for hub or mechanical joint connections, except that the outside of the hub shall have a large flange for attaching a drilling machine. The seat opening of the valve must permit a diameter cut no less than ½ inch smaller than the valve size. Valves specifically designed for tapping meeting the requirements of AWWA C500, and valves meeting the requirements of AWWA C509, will be permitted. Tapping valves shall be of the same type as other valves on the project. Tapping sleeves shall be cast iron, ductile iron, stainless steel, epoxy-coated steel, or other approved material.

9-30.4 Vacant

9-30.5 Hydrants

Fire hydrants shall conform to AWWA C502 and shall be of standard manufacture and of a pattern approved by the Contracting Agency.

9-30.5(1) End Connections

The end connections shall be mechanical joint or flanged, meeting the requirements of AWWA C110 and C111.

9-30.5(2) Hydrant Dimensions

Hydrant connection pipes shall be 6 inches inside diameter with 6-inch auxiliary gate valves. Barrels shall have a 7-inch minimum inside diameter. Hydrant length, measured from the bottom of the hydrant to the sidewalk ring, shall provide proper cover at each installed location. Valve openings shall be 5¼ inches minimum diameter. Hydrants shall have two 2½-inch hose nozzles and one pumper nozzle to match Contracting Agency's connection requirements.

Nozzles shall be fitted with cast iron threaded caps with operating nuts of the same design and proportions as the hydrant stem nuts. Caps shall be threaded to fit the corresponding nozzles and shall be fitted with suitable neoprene gaskets of positive water tightness under test pressures. The direction of opening shall be counterclockwise and shall be clearly marked on the operating nut or hydrant top. Hydrants shall be with O ring stem seals. The hydrant shall be painted with two coats of paint to match the owner's existing hydrants.

9-30.5(3) Hydrant Extensions

Hydrant extensions shall have a 6¾-inch minimum inside diameter and shall be gray cast iron or ductile iron and shall conform to the AWWA Standards for such castings. The drillings of the connecting flanges on the extensions shall match the drillings of the flanges on the hydrant.

Hydrant extensions shall also include the necessary hydrant operating stem extensions.

9-30.5(4) Hydrant Restraints

Shackle rods shall be ¾-inch diameter with threaded ends, and shall be ASTM A36 steel. Shackle rods shall be coated with two coats of asphalt varnish. If a restrained joint system is used, it shall meet the requirements of Section 9-30.2(6).

9-30.5(5) Traffic Flange

Hydrants shall be provided with a traffic flange and shall be equipped with breaking devices at the traffic flange which will allow the hydrant barrel to separate at this point with a minimum breakage of hydrant parts in case of damage. There shall also be provided at this point, a safety stem coupling on the operating stem that will shear at the time of impact.

9-30.5(6) Guard Posts

Guard posts for hydrants shall be provided where shown in the Plans. Guard posts shall be reinforced concrete having a compressive strength of 3,500 psi and shall be 6 feet in length by 9 inches in diameter. Reinforcing shall consist of a minimum of five No. 3 deformed steel bars.

9-30.6 Water Service Connections (2 inches and Smaller)

9-30.6(1) Saddles

Saddles shall be ductile iron, bronze, brass, or stainless steel.

Saddles used for ¾- and 1-inch services shall be single strap and may be either AWWA tapered thread or female iron pipe thread outlet. Saddles used for 1½- and 2-inch services shall be double strap and shall be female iron pipe thread outlet. Saddles used on PVC pipe shall be formed for PVC pipe and have flat, stainless steel straps.

9-30.6(2) Corporation Stops

Corporation stops shall be made of bronze or brass alloy.

Corporation stops for direct tapping shall have AWWA tapered thread inlet and an outlet connections compatible with either copper or polyethylene tubing.

Corporation stops used with ¾- and 1-inch outlet saddles shall have either AWWA tapered thread or male iron pipe thread inlets and outlet connections compatible with either copper or polyethylene tubing. Thread patterns for the saddle outlet and corporation stop inlet shall be the same.

Corporation stops used with 1½- and 2-inch outlet saddles shall have male iron pipe thread inlets and outlet connections compatible to connecting service pipes or have male iron pipe thread outlets.

9-30.6(3) Service Pipes

9-30.6(3)A Copper Tubing

Copper pipe or tubing shall be annealed, seamless, and conform to the requirements of ASTM B88, Type K rating.

9-30.6(3)B Polyethylene Tubing

Polyethylene tubing shall meet the requirements of AWWA C901. Tubing shall be high molecular mass with a 200 psi rating. Tubing used for ¾ and 1 inch shall be either SIDR 7 (iron pipe size) or SDR 9 (copper tube size). Tubing used for 1½ and 2 inches shall be SDR 9 (copper tube size).

9-30.6(3)C PEX-a Tubing

PEX-a tubing shall be a minimum of ¾ inch or a maximum 2-inch in diameter and shall be manufactured in accordance with AWWA C904 and ASTM F876. The tubing shall have a minimum materials designation code of 3306 in accordance with ASTM F876, a pressure rating of 200 psi at 73.4 degrees using a design factor of 0.63 as outlined in PPI TR-3, Part F-7, and shall have a minimum SDR of 9. Tubing color shall be blue in accordance with APWA Uniform color standards.

[redacted]

9-31 Fabricated Bridge Bearing Assemblies

9-31.1 Steel Plates and Bars

Steel plates and bars, including anchor array templates, shall conform to ASTM A 36.

Recessed steel surfaces retaining PTFE shall have an average surface roughness of 250-microinches or less.

Steel surfaces in contact with pre-formed fabric pad or polyether urethane disc shall have an average surface roughness of 250-microinches or less.

Steel surfaces in contact with stainless steel sheet, or with the bearing block of a pin bearing assembly, shall have an average surface roughness of 125-microinches or less.

All other steel surfaces in contact with other fabricated bridge bearing assembly components shall have an average surface roughness of 250-microinches or less.

9-31.2 Stainless Steel

Stainless steel sheet shall conform to ASTM A 240 Type 304L. Stainless steel in contact with PTFE shall be polished to a Number 8 mirror finish. Stainless steel sheet for fabric pad bearing assemblies shall have a thickness greater than or equal to 14-gage.

Stainless steel countersunk screws shall be hexagon socket type conforming to the geometric requirements of ANSI B 18.3 and shall conform to ASTM F 593 Type 304L.

9-31.3 Bearing Blocks and Keeper Rings

Bearing block forgings for pin bearing assemblies shall conform to Section 9-06.11, including AASHTO M 102 Supplemental Requirement S4. The grade shall be Grade F. The bearing block forging surfaces in contact with other pin bearing assembly components shall have an average surface roughness of 63-microinches or less. All other bearing block forging surfaces shall have an average surface roughness of 250-microinches or less.

Keeper ring forgings for pin bearing assemblies shall conform to Section 9-06.11, and the grade shall be Grade H. All keeper ring surfaces shall have an average surface roughness of 125-microinches or less.

9-31.4 Pin Assembly

Pins shall conform to ASTM A 276 UNS Designation 21800. The pin surfaces in contact with the bearing block shall have an average surface roughness of 63-microinches or less.

Nuts shall conform to ASTM A 563 Grade DH. Nuts with a thread diameter equal to or less than six-inches shall have a minimum Rockwell Hardness of HRc 24. Nuts with a thread diameter greater than six-inches shall have a Rockwell Hardness between HRc 20 and HRc 30.

Washers shall conform to ASTM A 572 Grade 50.

Cotter pins shall be stainless steel.

9-31.5 Welded Shear Connectors

Welded shear connectors shall conform to Section 9-06.15.

9-31.6 Bolts, Nuts and Washers

Bolts, nuts and washers shall conform to Section 9-06.5(3).

9-31.7 Anchor Array Rods, Nuts and Washers

Anchor array rods, nuts and washers shall conform to Section 9-06.5(4). The top 1'-0", minimum, of the exposed end of the anchor rods, and the associated nuts and washers, shall be galvanized in accordance with AASHTO M 232 or ASTM F 2329 as applicable.

Pipe sleeves for anchor array templates shall conform to ASTM A 53 Grade B Type E or S, black.

9-31.8 Bearing Pads

9-31.8(1) Elastomeric Pads

Elastomeric pads shall conform to the requirements of AASHTO M251 unless otherwise specified in the Plans or Special Provisions. The elastomer shall be low-temperature Grade 3 and shall not contain any form of wax. Unless otherwise specified in the Plans or Special Provisions, the elastomer shall have a shear modulus of elasticity of 165 psi at 73°F.

All elastomeric pads with steel laminates shall be cast as units in separate molds and bonded and vulcanized under heat and pressure. Corners and edges of molded pads may be rounded at the option of the Contractor. Radius at corners shall not exceed ⅜ inch, and radius of edges shall not exceed ⅛ inch. Elastomeric pads shall be fabricated to meet the tolerances specified in AASHTO M251.

Shims contained in laminated elastomeric pads shall be mill rolled steel sheets not less than 20 gage in thickness with a minimum cover of elastomer on all edges of:

¼ inch for pads less than or equal to 5 inches thick and,

½ inch for pads greater than 5 inches thick.

Steel shims shall conform to ASTM A1011, Grade 36, unless otherwise noted. All shim edges shall be ground or otherwise treated so that no sharp edges remain.

9-31.8(2) Polytetrafluoroethylene (PTFE)

PTFE shall be unfilled (100-percent virgin) PTFE or fiberglass fiber filled PTFE (or woven fabric PTFE for disc or spherical bearing assemblies) conforming to Section 18.8 of the AASHTO *LRFD Bridge Construction Specifications*, and the following additional requirements:

1. PTFE shall be unfilled (100-percent virgin) PTFE except where filled PTFE is specified in the Plans.
2. Filled PTFE shall be composed of PTFE resin uniformly blended with 15-percent maximum fiberglass fiber.
3. The substrate shall limit the flow (elongation) of the confined PTFE to not more than 0.009-inch under a pressure of 2,000 psi for 15-minutes at 78°F for a two-inch by three-inch test sample.
4. Unfilled PTFE shall have a hardness of 50 to 65 Durometer D, at 78°F, in accordance with ASTM D 2240.
5. The PTFE may be dimpled.

9-31.8(3) Pre-formed Fabric Pad

Pre-formed fabric pads shall be composed of multiple layers of duck, impregnated and bound with high-quality oil resistant synthetic rubber, compressed into resilient pads. The pre-formed fabric pads shall conform to MIL C 882 and the following additional requirements:

1. The pre-formed fabric pad shall have a shore A hardness of 90 ± 5 in accordance with ASTM D 2240.
2. The number of plies shall be as required to produce the specified thickness after compression and vulcanization.

9-31.9 Polyether Urethane

Polyether urethane shall be a molded polyether urethane compound conforming to the following properties:

Physical Properties	Specification			
Hardness, Type D durometer	ASTM D 2240	45	55	65
Minimum tensile stress, ksi	ASTM D 412			
At 100-percent elongation		1.5	1.9	2.3
At 200-percent elongation		2.8	3.4	4.0
Minimum tensile strength, ksi	ASTM D 412	4.0	5.0	6.0
Minimum ultimate elongation, percent	ASTM D 412	350	285	220
Maximum compression set (22 hours at 158°F) Method B, percent	ASTM D 395	40	40	40

Required minimums for tensile stress at specific elongations, tensile strength, ultimate elongation, and compression set may be interpolated for durometer hardness values between 45 and 55, and 55 and 65.

9-31.10 Silicone Grease

Silicone grease for use with dimpled PTFE shall conform to SAE AS 8660.

9-31.11 Epoxy Gel

Epoxy gel shall be Type 1, Grade 3, Class A, B, or C, conforming to Section 9-26.1.

9-31.12 Resin Filler

Resin filler shall be a two-component, resin and catalyst, liquid thermoset material, with the following properties:

1. The viscosity of the resin-catalyst mixture shall be 35,000 ± 5,000cP at 75°F immediately after mixing.
2. The flash point shall be 100°F minimum.
3. After mixing, the resin-catalyst mixture shall be pourable for a minimum of 8-minutes at 60°F and shall harden in 15-minutes maximum. Heating of the mixture to a maximum temperature of 250°F after placement is permissible to obtain a full cure.

The properties of the cured resin-catalyst mixture shall be:

1. The fully cured compressive strength shall be 12,000 psi, minimum.
2. The maximum allowable shrinkage shall be 2-percent. To control shrinkage, an inert filler may be used in the resin provided the specified viscosity requirements are met.
3. The hardness shall be between 40 and 55 in accordance with ASTM D 2583.

The resin and catalyst components shall be supplied in separate containers.

9-32 Mailbox Support

9-32.1 Steel Posts

The post shall be 2 inches outside diameter, 14-gage, mechanical tubing, and shall conform to ASTM A513. Galvanizing shall conform to G 90 coating as defined in ASTM A653, or an approved equal.

Any damage to galvanized paint surfaces shall be treated with two coats of paint conforming to Section 9-08.1(2)B.

9-32.2 Bracket, Platform, and Anti-Twist Plate

The bracket, platform, and anti-twist plate shall be 16-gage sheet steel, conforming to ASTM A1011 or ASTM A1008.

9-32.3 Vacant

9-32.4 Wood Posts

Wood posts shall meet the requirements of Section 9-28.14(1) or Western Red Cedar.

9-32.5 Fasteners

Unless otherwise specified, bolts and nuts shall be commercial bolt stock, galvanized in accordance with ASTM A153. Washers, unless otherwise specified, shall be malleable iron, or cut from medium steel or wrought iron plate. Washers and other hardware shall be galvanized in accordance with AASHTO M111.

9-32.6 Snow Guard

Snow guard shall be fabricated in accordance with ASTM F1071 for expanded metal bulkhead panel, to the dimensioning shown on the *Standard Plans*. After fabrication, the snow guard shall be galvanized in accordance with AASHTO M111.

9-32.7 Type 2 Mailbox Support

Type 2 mailbox supports shall be 2-inch 14-gage steel tube and shall meet the NCHRP 350 or the Manual for Assessing Safety Hardware (MASH) crash test criteria. Type 2 mailbox supports shall be installed in accordance with the manufacturer's recommendations.

9-32.8 Concrete Base

The concrete in the concrete base shall meet or exceed the requirements of Section 6-02.3(2)B.

9-32.9 Steel Pipe

The requirements for commercially available, Schedule 40, galvanized steel pipe, elbows, and couplings shall be met for all parts not intended to be bent or welded. Welded and bent parts shall be galvanized after fabrication in accordance with AASHTO M 111.

9-32.10 U-Channel Post

U-channel posts shall meet the requirements of ASTM A29, weigh a minimum of 3 pounds per linear foot, and shall be galvanized according to AASHTO M 111.

9-33 Construction Geosynthetic

9-33.1 Geosynthetic Material Requirements

The term geosynthetic shall be considered to be inclusive of geotextiles, geogrids, and prefabricated drainage mats.

Geotextiles, including geotextiles attached to prefabricated drainage core to form a prefabricated drainage mat, shall consist only of long chain polymeric fibers or yarns formed into a stable network such that the fibers or yarns retain their position relative to each other during handling, placement, and design service life. At least 95 percent by weight of the material shall be polyolefins or polyesters. The material shall be free from defects or tears. The geotextile shall also be free of any treatment or coating which might adversely alter its hydraulic or physical properties after installation.

Geogrids shall consist of a regular network of integrally connected polymer tensile elements with an aperture geometry sufficient to permit mechanical interlock with the surrounding backfill. The long chain polymers in the geogrid tensile elements, not including coatings, shall consist of at least 95 percent by mass of the material of polyolefins or polyesters. The material shall be free of defects, cuts, and tears.

Prefabricated drainage core shall consist of a three dimensional polymeric material with a structure that permits flow along the core laterally, and which provides support to the geotextiles attached to it.

The geosynthetic shall conform to the properties as indicated in Tables 1 through 8 in Section 9-33.2, and additional tables as required in the *Standard Plans* and Special Provisions for each use specified in the Plans. Specifically, the geosynthetic uses included in this section and their associated tables of properties are as follows:

Geotextile Geosynthetic Application	Applicable Property Tables
Underground Drainage, Low and Moderate Survivability, Classes A, B, and C	Tables 1 and 2
Separation	Table 3
Soil Stabilization	Table 3
Permanent Erosion Control, Moderate and High Survivability, Classes A, B, and C	Tables 4 and 5
Ditch Lining	Table 4
Temporary Silt Fence	Table 6
Permanent Geosynthetic Retaining Wall	Table 7 and Std. Plans
Temporary Geosynthetic Retaining Wall	Tables 7 and 10
Prefabricated Drainage Mat	Table 8
Table 10 will be included in the Special Provisions.	

Geogrid and geotextile reinforcement in geosynthetic retaining walls shall conform to the properties specified in the *Standard Plans* for permanent walls, and Table 10 for temporary walls.

For geosynthetic retaining walls that use geogrid reinforcement, the geotextile material placed at the wall face to retain the backfill material as shown in the Plans shall conform to the properties for Construction Geotextile for Underground Drainage, Moderate Survivability, Class A.

Thread used for sewing geotextiles shall consist of high-strength polypropylene, polyester, or polyamide. Nylon threads will not be allowed. The thread used to sew permanent erosion control geotextiles, and to sew geotextile seams in exposed faces of temporary or permanent geosynthetic retaining walls, shall also be resistant to ultraviolet radiation. The thread shall be of contrasting color to that of the geotextile itself.

9-33.2 Geosynthetic Properties

9-33.2(1) Geotextile Properties

Table 1 Geotextile for Underground Drainage Strength Properties for Survivability

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]			
		Low Survivability		Moderate Survivability	
		Woven	Nonwoven	Woven	Nonwoven
Grab Tensile Strength, in machine and x-machine direction	D4632	180 lb min.	115 lb min.	250 lb min.	160 lb min.
Grab Failure Strain, in machine and x-machine direction	D4632	< 50%	≥ 50%	< 50%	≥ 50%
Seam Breaking Strength	D4632[3]	160 lb min.	100 lb min.	220 lb min.	140 lb min.
Puncture Resistance	D6241	370 lb min.	220 lb min.	495 lb min.	310 lb min.
Tear Strength, in machine and x-machine direction	D4533	67 lb min.	40 lb min.	80 lb min.	50 lb min.
Ultraviolet (UV) Radiation Stability	D4355	50% strength retained min., after 500 hours in a xenon arc device			

Notes in Section 9-33.2(3), Table 8.

Table 2 Geotextile for Underground Drainage Filtration Properties

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]		
		Class A	Class B	Class C
AOS	D4751	No. 40 max.	No. 60 max.	No. 80 max.
Water Permittivity	D4491	0.5 sec^{-1} min.	0.4 sec^{-1} min.	0.3 sec^{-1} min.

Notes in Section 9-33.2(3), Table 8.

Table 3 Geotextile for Separation or Soil Stabilization

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]			
		Separation		Soil Stabilization	
		Woven	Nonwoven	Woven	Nonwoven
AOS	D4751	No. 30 max.		No. 40 max.	
Water Permittivity	D4491	0.02 sec^{-1} min.		0.10 sec^{-1} min.	
Grab Tensile Strength, in machine and x-machine direction	D4632	250 lb min.	160 lb min.	315 lb min.	200 lb min.
Grab Failure Strain, in machine and x-machine direction	D4632	< 50%	≥ 50%	< 50%	≥ 50%
Seam Breaking Strength	D4632[3]	220 lb min.	140 lb min.	270 lb min.	180 lb min.
Puncture Resistance	D6241	495 lb min.	310 lb min.	620 lb min.	430 lb min.
Tear Strength, in machine and x-machine direction	D4533	80 lb min.	50 lb min.	112 lb min.	79 lb min.
Ultraviolet (UV) Radiation Stability	D4355	50% strength retained min., after 500 hours in xenon arc device			

Notes in Section 9-33.2(3), Table 8.

Table 4 Geotextile for Permanent Erosion Control and Ditch Lining

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]					
		Permanent Erosion Control				Ditch Lining	
		Moderate Survivability		High Survivability			
		Woven	Non Woven	Woven	Non Woven	Woven	Non Woven
AOS	D4751	See Table 5		See Table 5		No. 30 max.	
Water Permittivity	D4491	See Table 5		See Table 5		0.02 sec^{-1} min.	
Grab Tensile Strength, in machine and x-machine direction	D4632	250 lb min.	160 lb min.	315 lb min.	200 lb min.	250 lb min.	160 lb min.
Grab Failure Strain, in machine and x-machine direction	D4632	15% -50%	≥ 50%	15% - 50%	≥ 50%	< 50%	≥ 50%
Seam Breaking Strength	D4632[3]	220 lb min.	140 lb min.	270 lb min.	180 lb min.	220 lb min.	140 lb min.
Puncture Resistance	D6241	495 lb min.	310 lb min.	620 lb min.	430 lb min.	495 lb min.	310 lb min.
Tear Strength, in machine and x-machine direction	D4533	80 lb min.	50 lb min.	112 lb min.	79 lb min.	80 lb min.	50 lb min.
Ultraviolet (UV) Radiation Stability	D4355	70% strength retained min., after 500 hours in xenon arc device					

Notes in Section 9-33.2(3), Table 8.

Table 5 Filtration Properties for Geotextile for Permanent Erosion Control

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]		
		Class A	Class B	Class C
AOS	D4751	No. 40 max.	No. 60 max.	No. 70 max.
Water Permittivity	D4491	0.7 sec^{-1} min.	0.4 sec^{-1} min.	0.2 sec^{-1} min.

Notes in Section 9-33.2(3), Table 8.

Table 6 Geotextile for Temporary Silt Fence

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]	
		Unsupported Between Posts	Supported Between Posts With Wire or Polymeric Mesh
AOS	D4751	No. 30 max. for slit wovens, No. 50 for all other geotextile types, No. 100 min.	
Water Permittivity	D4491	0.02 sec^{-1} min.	
Grab Tensile Strength, in machine and x-machine direction	D4632	180 lb min. in machine direction, 100 lb min. in x-machine direction	100 lb min.
Grab Failure Strain, in machine and x-machine direction	D4632	30% max. at 180 lb or more	
Ultraviolet (UV) Radiation Stability	D4355	70% strength retained min., after 500 hours in xenon arc device	

Notes in Section 9-33.2(3), Table 8.

9-33.2(2) Geotextile Properties for Retaining Walls and Reinforced Slopes

Table 7 Minimum Properties Required for Geotextile Reinforcement Used in Geosynthetic Reinforced Slopes and Retaining Walls

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]	
		Woven	Nonwoven
AOS	D4751	No. 20 max.	
Water Permittivity	D4491	0.02 sec^{-1} min.	
Grab Tensile Strength, in machine and x-machine direction	D4632	200 lb min.	120 lb min.
Grab Failure Strain, in machine and x-machine direction	D4632	< 50%	≥ 50%
Seam Breaking Strength	D4632[3,4]	160 lb min.	100 lb min.
Puncture Resistance	D6241	370 lb min.	220 lb min.
Tear Strength, in machine and x-machine direction	D4533	63 lb min.	50 lb min.
Ultraviolet (UV) Radiation Stability	D4355	70% (for polypropylene and polyethylene) and 50% (for polyester) Strength Retained min., after 500 hours in a xenon arc device	

Notes in Section 9-33.2(3), Table 8.

9-33.2(3) Prefabricated Drainage Mat

Prefabricated drainage mat shall have a single or double dimpled polymeric core with a geotextile attached and shall meet the following requirements:

Table 8 Minimum Properties Required for Prefabricated Drainage Mats

Geotextile Property	ASTM Test Method[2]	Geotextile Property Requirements[1]
AOS	D4751	No. 60 max.
Water Permittivity	D4491	0.4 sec^{-1} min.
Grab Tensile Strength, in machine and x-machine direction	D4632	Nonwoven – 100 lb min.
Width Thickness	D1777	12 inch min. 0.4 inch min.
Compressive Strength at Yield	D1621	100 psi min.
In Plan Flow Rate Gradient = 0.1, Pressure = 5.5 psi Gradient = 1.0, Pressure = 14.5 psi	D4716	5.0 gal./min./ft. min. 15.0 gal/min./ft. min.

[1]All geotextile properties in Tables 1 through 8 are minimum average roll values (i.e., the test results for any sampled roll in a lot shall meet or exceed the values shown in the table).

[2]The test procedures used are essentially in conformance with the most recently approved ASTM geotextile test procedures, except for geotextile sampling and specimen conditioning, which are in accordance with WSDOT T 914, Practice for Sampling of Geotextiles for Testing, and T 915, Practice for Conditioning of Geotextiles for Testing, respectively. Copies of these test methods are available at the State Materials Laboratory, PO Box 47365, Olympia, WA 98504-7365.

[3]With seam located in the center of 8-inch-long specimen oriented parallel to grip faces.

[4]Applies only to seams perpendicular to the wall face.

9-33.3 Aggregate Cushion of Permanent Erosion Control Geotextile

Aggregate cushion for permanent erosion control geotextile, Class A shall meet the requirements of Section 9-03.9(2). Aggregate cushion for permanent erosion control geotextile, Class B or C shall meet the requirements of Sections 9-03.9(3) and 9-03.9(2).

9-33.4 Geosynthetic Material Approval and Acceptance

9-33.4(1) Geosynthetic Material Approval

Geosynthetics listed in the WSDOT Qualified Products List (QPL) are approved for use. If the geosynthetics material is not listed in the current WSDOT QPL, a Manufacturer's Certificate of Compliance including Certified Test Reports of each proposed geosynthetic shall be submitted to the State Materials Laboratory in Tumwater for evaluation. Geosynthetic material approval will be based on conformance to the applicable properties from the Tables in Section 9-33.2 or in the *Standard Plans* or Special Provisions. Approval/Disapproval information will be provided within 30 calendar days after the sample and required information for each geosynthetic type have been received at the State Materials Laboratory in Tumwater.

The Contractor shall submit to the Engineer the following information regarding each geosynthetic material proposed for use:

Manufacturer's name and current address,

Full product name,

Geosynthetic structure, including fiber/yarn type,

Geosynthetic polymer type(s) (for permanent geosynthetic retaining walls, reinforced slopes, reinforced embankments, and other geosynthetic reinforcement applications),

Geosynthetic roll number(s),

Geosynthetic lot number(s),

Proposed geosynthetic use(s), and

Certified test results for minimum average roll values.

Geosynthetics used as reinforcement in permanent geosynthetic retaining walls, reinforced slopes, reinforced embankments, and other geosynthetic reinforcement applications require proof of compliance with the National Transportation Product Evaluation Program (NTPEP) in accordance with AASHTO Standard Practice R 69, Standard Practice for Determination of Long-Term Strength for Geosynthetic Reinforcement.

9-33.4(2) Vacant

9-33.4(3) Acceptance Samples

A satisfactory test report is required when the quantities of geosynthetic materials proposed for use in the following geosynthetic applications are greater than the following amounts:

Application	Geosynthetic Quantity
Underground Drainage	100 sq. yd.
Permanent Geosynthetic Reinforced Slopes, Retaining Walls, Reinforced Embankments, and other Geosynthetic Reinforcement Applications	All quantities

The samples for acceptance testing shall include the information about each geosynthetic roll to be used as stated in Section 9-33.4(4).

Samples from the geosynthetic roll will be taken to confirm that the material meets the property values specified. Samples will be randomly taken at the job site by the Contractor in accordance with WSDOT T 914 in the presence of the Engineer.

Acceptance will be based on testing of samples from each lot. A "lot" shall be defined for the purposes of this Specification as all geosynthetic rolls within the consignment (i.e., all rolls sent to the project site) that were produced by the same manufacturer during a continuous period of production at the same manufacturing plant and have the same product name. Test results from Section 9-33.4(1) Geosynthetic Material Approval testing may be used for acceptance provided the tested roll(s) are part of the "lot" as defined above.

Acceptance testing information will be provided within 30 calendar days after the sample and the required information for each geosynthetic type have been received at the State Materials Laboratory in Tumwater.

If the results of the testing show that a geosynthetic lot, as defined, does not meet the properties required for the specified use as indicated in Tables 1 through 8 in Section 9-33.2, and additional tables as specified in the Special Provisions, the roll or rolls which were sampled will be rejected. Geogrids and geotextiles for temporary geosynthetic retaining walls shall meet the requirements of Table 7, and Table 10 in the Special Provisions. Geogrids and geotextiles for permanent geosynthetic retaining wall shall meet the requirements of Table 7, and Table 9 in the Special Provisions, and both geotextile and geogrid acceptance testing shall meet the required ultimate tensile strength T_{ult} as provided in the current QPL for the selected product(s). If the selected product(s) are not listed in the current QPL, the result of the testing for T_{ult} shall be greater than or equal to T_{ult} as determined from the product data submitted and approved by the State Materials Laboratory during source material approval.

For each geosynthetic roll that is tested and fails, the Engineer will select two additional rolls from the same lot for sampling and retesting. The Contractor shall sample the rolls in accordance with WSDOT T 914 in the presence of the Engineer. If the retesting shows that any of the additional rolls tested do not meet the required properties, the entire lot will be rejected. If the test results from all the rolls retested meet the required properties,

the entire lot minus the roll(s) that failed will be accepted. All geosynthetic that has defects, deterioration, or damage, as determined by the Engineer, will also be rejected. All rejected geosynthetic shall be replaced at no additional expense to the Contracting Agency.

9-33.4(4) Acceptance by Certificate of Compliance

When the quantities of geosynthetic proposed for use in each geosynthetic application are less than or equal to the following amounts, acceptance shall be by Manufacturer's Certificate of Compliance:

Application	Geosynthetic Quantity
Underground Drainage	100 sq. yd.
Soil Stabilization and Separation	All quantities
Permanent Erosion Control	All quantities
Prefabricated Drainage Mat	All quantities

The Manufacturer's Certificate of Compliance shall include the following information about each geosynthetic roll to be used:

- Manufacturer's name and current address,
- Full product name,
- Geosynthetic structure, including fiber/yarn type,
- Geosynthetic Polymer type (for all temporary and permanent geosynthetic retaining walls only),
- Geosynthetic roll number(s),
- Geosynthetic lot number(s),
- Proposed geosynthetic use(s), and
- Certified test results.

9-33.4(5) Approval of Seams

If the geotextile seams are to be sewn in the field, the Contractor shall provide a section of sewn seam that can be sampled by the Engineer before the geotextile is installed. The seam sewn for sampling shall be sewn using the same equipment and procedures as will be used to sew the production seams. If production seams will be sewn in both the machine and cross-machine directions, the Contractor must provide sewn seams for sampling which are oriented in both the machine and cross-machine directions.

The seam sewn for sampling must be at least 2 yards in length in each geotextile direction. If the seams are sewn in the factory, the Engineer will obtain samples of the factory seam at random from any of the rolls to be used. The seam assembly description shall be submitted by the Contractor to the Engineer and will be included with the seam sample obtained for testing. This description shall include the seam type, stitch type, sewing thread type(s), and stitch density.

9-34 Pavement Marking Material

9-34.1 General

Pavement marking materials in this section consist of paint, plastic, tape or raised pavement markers as described in Sections 8-22 and 8-23 as listed below:

Low VOC Solvent Based Paint

Low VOC Waterborne Paint

Temporary Pavement Marking Paint

Type A – Liquid Hot Applied Thermoplastic

Type B – Pre-Formed Fused Thermoplastic

Type C – Cold Applied Pre-Formed Tape

Type D – Liquid Cold Applied Methyl Methacrylate

Glass Beads

Temporary Pavement Marking Tape

Temporary Raised Pavement Markings

9-34.2 Paint

White and yellow paint shall comply with the Specifications for low VOC (volatile organic compound) solvent-based paint or low VOC waterborne paint. Blue paint for "Access Parking Space Symbol with Background" and black paint for contrast markings shall be chosen from a WSDOT QPL-listed manufacturer for white and yellow paint.

Blue and black paint shall comply with the requirements of yellow paint in Section 9-34.2(4) and Section 9-34.2(5), with the exception that blue and black paints do not need to meet the requirements for titanium dioxide, directional reflectance, and contrast ratio.

9-34.2(1) Vacant

9-34.2(2) Color

Paint draw-downs shall be prepared according to ASTM D823. For white, the color shall closely match SAE AMS Standard 595, color number 37875. For yellow, the color shall closely match SAE AMS Standard 595, color number 33538. For blue, the color shall closely match SAE AMS Standard 595, color number 35180. For black, the color shall closely match SAE AMS Standard 595, color number 37038.

9-34.2(3) Prohibited Materials

Traffic paint shall not contain mercury, lead, chromium, diarylide pigments, toluene, chlorinated solvents, hydrolysable chlorine derivatives, ethylene-based glycol ethers and their acetates, nor any other EPA hazardous waste material over the regulatory levels per CFR 40 Part 261.24.

9-34.2(4) Low VOC Solvent Based Paint

Paint Properties	Test Method	Low VOC Solvent-Based Paint			
		White		Yellow	
		Min.	Max.	Min.	Max.
Density of Paint (lb/gal)	ASTM D1475	11.8		11.8	
Viscosity, KU	ASTM D562				
@35°F					
@50°F			105		105
@77°F		75	85	75	85
@90°F					
@120°F		65		65	
Nonvolatile Content, % by weight	ASTM D2369	65		65	
Pigment Content, % by weight	ASTM D2698		53		53
Titanium Dioxide Content (lb/gal), Rutile Type II	ASTM D5381	1.0			0.2
Volatile Organic Content (VOC) lbs/gal	ASTM D3960		1.25		1.25
Directional Reflectance %, @ 15 mils wet	WSDOT T 314	80		50	
Package Stability	ASTM D1849	6		6	
Bleeding, %	ASTM D868[1]	90		90	
Flexibility	ASTM D522[2]	No cracking, flaking, or loss of adhesion			
Settling Properties during Storage, inch	ASTM D1309[3]		8		8
Skinning	ASTM D154	The paint shall not skin within 48 hours in a ¾ filled, tightly closed container			

[1]The reflectance of the paint over asphalt paper shall be a minimum of 90 percent of the reflectance measurement of the paint over a taped (nonbleeding) surface.

[2]The paint shall be applied at a wet film thickness of 6 mils to a 3 by 5 inch panel that has been solvent cleaned and lightly buffed with steel wool. With the panel kept in a horizontal position, the paint shall be allowed to dry for 18 hours at 77° ± 2°F, and then baked for 3 hours at 140° ± 2°F. The panel shall be cooled to 77° ± 2°F for at least 30 minutes, bent over a 0.25 inch mandrel, and then examined without magnification. The paint shall show no cracking, flaking, or loss of adhesion.

[3]The sample shall show no more than 0.5 inch of clear material over the opaque portion of the paint and there shall be no settling below a rating of eight.

9-34.2(5) Low VOC Waterborne Paint

Paint Properties	Test Method	Standard Waterborne Paint Type 1 and 2				Semi-Durable Waterborne Paint Type 3				High-Build Waterborne Paint Type 4				Cold Weather Waterborne Paint Type 5			
		White		Yellow		White		Yellow		White		Yellow		White		Yellow	
		Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Density of Paint (lb/gal)	ASTM D1475	Within ± 0.3 of qualification sample				Within ± 0.3 of qualification sample				Within ± 0.3 of qualification sample				12.5		12.5	
Viscosity, KU	ASTM D562																
@35°F															95		95
@77°F		80	95	80	95	80	95	80	95	80	95	80	95		87		87
@90°F		60		60		60		60		60		60		60		60	
Nonvolatile Content, % by weight	ASTM D2369	75		75		77		77		77		77		70		70	
Pigment Content, % by weight	ASTM D3723		68		68		65		65								
Nonvolatile Vehicle (NVV), % by weight	ASTM D2369 ASTM D3723[1]	40		40		43		43		43		43		40		40	
Volatile Organic Content (VOC) lbs/gal	ASTM D3960		1.25		1.25		1.25		1.25		1.25		1.25		1.25		1.25
Fineness of Grind, (Hegman Scale)	ASTM D1210	3		3		3		3		3		3		3		3	
Contrast Ratio, @ 15 mils wet	ASTM D2805	0.98		0.96		0.98		0.96		0.98		0.96		0.99		0.98	
Directional Reflectance %, @ 15 mils wet	WSDOT T 314	88		50		88		50		90		50		87		50	
Flash Point, °F	ASTM D93	100°		100°		100°		100°									
pH	ASTM E70	9.5		9.5		9.5		9.5		9.5		9.5		9.5		9.5	
Laboratory Dry Time (Minutes)	ASTM D711		10		10		10		10						10		10
Vehicle Composition	ASTM D2621	100% acrylic emulsion				100% acrylic emulsion				100% cross-linking acrylic[4]				100% acrylic emulsion			

Paint Properties	Test Method	Standard Waterborne Paint Type 1 and 2				Semi-Durable Waterborne Paint Type 3				High-Build Waterborne Paint Type 4				Cold Weather Waterborne Paint Type 5			
		White		Yellow		White		Yellow		White		Yellow		White		Yellow	
		Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Freeze-Thaw Stability, KU	ASTM D2243 and D562	@ 5 cycles show no coagulation or change in viscosity greater than ± 10 KU				@ 5 cycles show no coagulation or change in viscosity greater than ± 10 KU				@ 5 cycles show no coagulation or change in viscosity greater than ± 10 KU				@ 3 cycles show no coagulation or change in viscosity greater than ± 10 KU			
Heat Stability	ASTM D562[2]	± 10 KU from the initial viscosity				± 10 KU from the initial viscosity				± 10 KU from the initial viscosity				± 10 KU from the initial Viscosity			
Low Temperature Film Formation	ASTM D2805[3]	No Cracks				No Cracks								No Cracks			
Cold Flexibility[5]	ASTM D522	Pass at 0.5 in mandrel*				Pass at 0.25 in mandrel											
Test Deck Durability[6]	ASTM D913	≥70% paint retention in wheel track*				≥70% paint retention in wheel track											
Mud Cracking	See note 7	No Cracks				No Cracks				No Cracks							

[1]Use the following formula for calculating nonvolatile in vehicle (NVV): NVV = (N-P/100-P)×100. Where: N= % of nonvolatile content as determined by ASTM D2369 and P= % of pigment content as determined by ASTM D3723.

[2]Put approximately 15-fluid ounces of paint in a 1-pint lined container, close the container, seal it with tape, and put it an oven maintained at 140° ± 2°F for 7 days. Equilibrate the paint at 77° ± 2°F and mix thoroughly with gentle stirring. Perform consistency test as specified in ASTM D562. Consistency shall not vary by ±10 KU from the initial viscosity.

[3]Apply paint at 15 mils wet per ASTM D2805 over a 2A Leneta Chart. Immediately and carefully lay the applied film horizontally in a refrigerator that maintains a temperature of 35°F. After 24 hours, remove the applied film and inspect. Paint film should show no cracks when held at arm's length and observed by the naked eye.

[4]Cross-linking acrylic shall meet the requirements of federal specification TT-P-1952F Section 3.1.1.

[5]Cold Flexibility: The paint shall be applied to an aluminum panel at a wet film thickness of 15 mils and allowed to dry under ambient conditions (50±10% RH and 72±5 ˚F) for 24 hours. A cylindrical mandrel apparatus (in accordance with ASTM D522 method B) shall be put in a 40°F refrigerator when the paint is drawn down. After 24 hours, the aluminum panel with dry paint shall be put in the 40°F refrigerator with the mandrel apparatus for 2 hours. After 2 hours, the panel and test apparatus shall be removed and immediately tested to according to ASTM D522 to evaluate cold flexibility. Paint must show no evidence of cracking, chipping or flaking when bent 180 degrees over a mandrel bar of specified diameter.

[6]NTPEP test deck, or a test deck conforming to ASTM D713, shall be conducted for a minimum of six months with the following additional requirements: it shall be applied at 15 wet mils to a test deck that is located at 40N latitude or higher with at least 10,000 ADT and which was applied during the months of September through November.

[7]Paint is applied to an approximately 4"×12" aluminum panel using a drawdown bar with a 50 mil gap. The coated panel is allowed to dry under ambient conditions (50±10% RH and 72±5 ˚F) for 24 hours. Visual evaluation of the dry film shall reveal no cracks.

9-34.2(6) Temporary Pavement Marking Paint

Paint used for temporary pavement marking shall conform to the requirements of Section 9-34.2.

9-34.3 Plastic

White and yellow plastic pavement marking materials shall comply with the Specifications for:

Type A – Liquid hot applied thermoplastic

Type B – Pre-formed fused thermoplastic

Type C – Cold applied pre-formed tape

Type D – Liquid cold applied methyl methacrylate

For black, the color shall closely match SAE AMS Standard 595, color number 37038, and shall be chosen from a WSDOT QPL-listed manufacturer for white or yellow plastic. Black plastic shall comply with Sections 9-34.3(2), 9-34.3(3), and 9-34.3(4) for yellow, except for retroreflectance.

9-34.3(1) Type A – Liquid Hot Applied Thermoplastic

Type A material consists of a mixture of pigment, fillers, resins and glass beads that is applied to the pavement in the molten state by extrusion or by spraying. The material can be applied at a continuously uniform thickness or it can be applied with a profiled pattern. Glass beads, intermixed and top dress, shall conform to the manufacturer's recommendations necessary to meet the retroreflectance requirements. Type A material shall conform to the requirements of AASHTO M 249 and the following:

Resin – The resin shall be alkyd or hydrocarbon.

Retroreflectance – ASTM E1710

Newly applied pavement markings shall have a minimum initial coefficient of retroreflective luminance of 250 $mcd \cdot m^{-2} \cdot lx^{-1}$ for white and 175 $mcd \cdot m^{-2} \cdot lx^{-1}$ for yellow in accordance with ASTM E1710 when measured with a 30-meter retroreflectometer. WSDOT will measure retroreflectivity for compliance with a Delta LTL-X retroreflectometer.

Skid Resistance – ASTM E303

45 BPN units minimum

9-34.3(2) Type B – Pre-Formed Fused Thermoplastic

Type B material consists of a mixture of pigment, fillers, resins and glass beads that is factory produced in sheet form. The material is applied by heating the pavement and top heating the material. The material shall contain intermixed glass beads. The material shall conform to AASHTO M 249, with the exception of the relevant differences for the materials being applied in the pre-formed state and the following:

Resin – The resin shall be alkyd or hydrocarbon.

The sample material submitted for approval shall be fused to a suitable substrate prior to performing the following tests.

Retroreflectance – ASTM E1710

The fused samples shall have a minimum initial coefficient of retroreflective luminance of 250 $mcd \cdot m^{-2} \cdot lx^{-1}$ for white and 175 $mcd \cdot m^{-2} \cdot lx^{-1}$ for yellow in accordance with ASTM E1710 when measured with a 30-meter retroreflectometer. WSDOT will measure retroreflectivity for compliance with a Delta LTL-X retroreflectometer.

Skid Resistance – ASTM E303

45 BPN units minimum

The blue color shall match SAE AMS Standard 595, color number 35180, and the tolerance of variation shall match that shown in the FHWA “Highway Blue Color Tolerance Chart”.

The red color shall match SAE AMS Standard 595, color number 11136, and the tolerance of variation shall match that shown in the FHWA “Highway Red Color Tolerance Chart”.

9-34.3(3) Type C – Cold Applied Pre-Formed Tape

Type C material consists of plastic pre-formed tape that is applied cold to the pavement. The tape shall be capable of adhering to new and existing hot mix asphalt or cement concrete pavement. If the tape manufacturer recommends the use of a surface primer or adhesive, use a type approved by the pavement marking manufacturer. The tape shall also be capable of being inlaid into fresh hot mix asphalt during the final rolling process. The material is identified by the following designations: Type C-1 tape has a surface pattern with retroreflective elements exposed on the raised areas and faces and intermixed within its body and shall conform to ASTM D4505, Reflectivity Level I, Class 2 or 3, Skid Resistance Level A. Type C-2 tape has retroreflective elements exposed on its surface and intermixed within its body and shall conform to the requirements of ASTM D4505, Reflectivity Level II, Class 2 or 3, Skid Resistance Level A.

9-34.3(4) Type D – Liquid Cold Applied Methyl Methacrylate

Type D material consists of a two-part mixture of methyl methacrylate and a catalyst that is applied cold to the pavement. The material can be applied at a continuously uniform thickness or it can be applied with profiles (bumps). The material is classified by Type designation, depending upon the method of application.

Glass beads shall conform to the manufacturer's recommendations necessary to meet the retroreflectance requirements. Type D-1, D-2, D-3, D-4, and D-6 material shall have intermixed glass beads in the material prior to application.

Type D-5 material shall have glass beads injected into the material at application and a second coating of top dressing beads applied immediately after material application. Type D materials shall conform to the following:

Type D – Liquid Cold Applied Methyl Methacrylate Properties					
		White		Yellow	
Property	Test Method	Min.	Max.	Min.	Max.
Adhesion to PCC or HMA, psi	ASTM D4541[1]	200 or substrate failure		200 or substrate failure	
Chemical Resistance	[2]	No Effect		No Effect	
Hardness	ASTM D2240[3]	50		50	
No Track Time	ASTM D711[4]		30		30
Skid Resistance, BPN	ASTM E303	45		45	
Tensile Strength, psi	ASTM D638	125		125	

[1]Part A and B mixed, applied at 60 mils thickness.
[2]Cured markings shall be resistant to calcium chloride, sodium chloride, fuels, oils, and UV effects. Cure three days for motor oil, gas, diesel, ATF, salt, and anti-freeze.
[3]Shore Durometer Type D and measurement made after 24 hours.
[4]Sample applied at 40 mils.

Type D liquid cold-applied methyl methacrylate shall meet the following formulations:

4:1 Formulation Type D – Liquid Cold Applied Methyl Methacrylate

Type D-1 – One-gallon of methyl methacrylate and 3-fluid ounces of benzoyl peroxide powder (by weight).

Type D-2, D-3, D-4, and D-5 – Four parts methyl methacrylate and one part liquid benzoyl peroxide (by volume).

98:2 Formulation Type D – Liquid Cold Applied Methyl Methacrylate

Type D-1– One-gallon of methyl methacrylate and 3-fluid ounces of benzoyl peroxide powder (by weight).

Type D-2, D-3, D-4, D-5, and D-6 – Ninety-eight parts methyl methacrylate and two parts liquid benzoyl peroxide (by volume).

D liquid cold applied methyl methacrylate shall meet the following requirements for viscosity:

4:1 Formulations Type D – Liquid Cold Applied Methyl Methacrylate													
		D-1		D-2		D-3		D-4		D-5 White		D-5 Yellow	
Property	Test Method	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Viscosity cP @ 77°F, 50-rpm, spindle #7	ASTM D2196 Method B, LV Model	11,000	15,000	26,000	28,000	17,000	21,000						
Viscosity cP @ 77°F, 50-rpm, spindle #4	ASTM D2196 Method B, LV Model							8,000	10,000	5,000	8,000	7,000	11,000

98:2 Formulations Type D – Liquid Cold Applied Methyl Methacrylate													
		D-1		D-2		D-3		D-4		D-5		D-6	
Property	Test Method	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Viscosity Daniel Scale	Daniel Method[1]	12	14	6	12	12	14	13	15				
Viscosity cP @ 77°F, 50-rpm, spindle #4	ASTM D2196 Method B, LV Model									100	118		

[1]Follow Daniel Gauge method; measure flow at 60-seconds.

9-34.4 Glass Beads for Pavement Marking Materials

Glass beads for traffic marking paint shall be coated with silicone for moisture resistance and a silane to promote adhesion. The beads shall be transparent, clean, colorless glass; smooth and spherically shaped; and free from milkiness, pits, or excessive air bubbles.

Glass beads used with plastic traffic markings shall be per the manufacturer's recommendations.

The glass beads for paint and plastic traffic markings shall not contain any metals in excess of the following established total concentration limits when tested in accordance with the listed test methodology:

Metal Concentration Limits		
Element	Test Method	Max. Parts Per Million (ppm)
Arsenic	EPA 3052 SW-846 6010D	10.0
Barium	EPA 3052 SW-846 6010D	100.0
Cadmium	EPA 3052 SW-846 6010D	1.0
Chromium	EPA 3052 SW-846 6010D	5.0
Lead	EPA 3052 SW-846 6010D	50.0
Silver	EPA 3052 SW-846 6010D	5.0
Mercury	EPA 3052 SW-846 7471B	4.0

Glass beads for traffic marking paint shall meet the following requirements for quality:

Glass Bead Property	Test Method	Type A		Type B[1]	
		Min.	Max.	Min.	Max.
Refractive Index @ 77 ± 9°F	AASHTO M 247 Section 5.2.3	1.50	1.55	1.50	1.55
Moisture Resistances	AASHTO M 247 Section 5.3.2	Flow Without Stopping		Flow Without Stopping	
Adherence	AASHTO M 247 Section 5.3.4	Pass		Pass	
Roundness, %	ASTM D1155	70		80[2]	
	FLHT 520			80[3]	
Appearance	TT-B-1325D Section 4.3.1			Beads shall be transparent, clean, dry, and free from bubbles and foreign matter.	
Resistance to Acid	TT-B-1325D Section 4.3.6			Beads shall not develop any surface haze or dulling.	
Resistance to Calcium Chloride	TT-B-1325D Section 4.3.7			Beads shall not develop any surface haze or dulling.	
Resistance to Sodium Sulfide	TT-B-1325D Section 4.3.8			Sodium sulfide should not darken the beads.	
Water Resistance	TT-B-1325D Section 4.3.9			Water shall not produce haze or dulling of the beads.	

[1]WSDOT Type B Glass Beads are high-performance glass beads for improved retroreflectivity and durability for high-performance pavement markings. A minimum of 50 percent of the glass beads shall be made from the direct-melt molten kiln process.

[2]Roundness will be determined on material < No. 30 sieve.

[3]Roundness will be determined on material ≥ No. 30 sieve.

Glass beads for traffic marking paint shall meet the following requirements for grading when tested in accordance with ASTM D1214:

Percent Passing				
Sieve Size	Type A[1]		Type B	
	Min.	Max.	Min.	Max.
No. 14			100	
No. 16	100			
No. 18			65	80
No. 20	95	100		
No. 30	75	95	30	50
No. 50	15	35	0	5
No. 100	0	5		

[1]Same gradation as AASHTO M 247 Type 1.

9-34.5 Temporary Pavement Marking Tape

Biodegradable tape with paper backing is not allowed.

9-34.5(1) Temporary Pavement Marking Tape – Short Duration (Removable)

Temporary pavement marking tape for short duration (usage is for up to two months) shall conform to ASTM D4592 Type I except that black tape, black mask tape and the black portion of the contrast removable tape, shall be non-reflective.

9-34.5(2) Temporary Pavement Marking Tape – Long Duration (Non-Removable)

Temporary pavement marking tape for long duration (usage is for greater than two months and less than one year) shall conform to ASTM D4592 Type II. Temporary pavement marking tape for long duration, except for black tape, shall have a minimum initial coefficient of retroreflective luminance of 200 mcd*m-2*lx-1 when measured in accordance with ASTM E2832. Black tape, black mask tape and the black portion of the contrast removable tape, shall be non-reflective.

9-34.6 Temporary Flexible Raised Pavement Markers

Temporary flexible raised pavement markers shall consist of an L-shaped body with retroreflective tape on the top of one face for one-way traffic and reflective tape on the top of both faces for two-way traffic. The marker body shall be made from 0.060-inch minimum thick polyurethane. The top of the vertical leg shall be between 1.75 and 2.0 inches high and shall be approximately 4 inches wide. The base width shall be approximately 1.125 inches wide. The base shall have a pressure sensitive adhesive material, a minimum of 0.125 inch thick with release paper. The reflective tape shall be a minimum of 0.25 inch high by 4 inches wide. The reflective tape shall have a minimum reflectance of 3.5 candlepower per foot-candle for white and 2.5 candlepower per foot-candle for yellow measured at 0.2-degree observation angle and 0-degree entrance angle.

9-34.7 Field Testing

9-34.7(1) Requirements

Field performance evaluation is required for low VOC solvent-based paint per Section 9-34.2(4), Type A – liquid hot applied thermoplastic per Section 9-34.3(1), Type B – preformed fused thermoplastic per Section 9-34.3(2), Type C – cold applied preformed tape per Section 9-34.3(3), and Type D – liquid applied methyl methacrylate per Section 9-34.3(4).

Testing on a northern AASHTO National Transportation Product Evaluation Program (NTPEP) pavement marking test deck is recommended. Test decks conducted by other public entities may be considered provided they produce data similar to a northern NTPEP test deck. Retroreflectivity, Durability, and Auto No-Track shall conform to the following requirements after being installed on a northern NTPEP test deck for a minimum of 12 months.

Successful use of a product in five other States may be considered in lieu of the field test requirement.

9-34.7(1)A Retroreflectivity

Retroreflectivity is measured as a coefficient of retroreflective luminance (RL) in accordance with the requirements of ASTM E1710 for 30-meter geometry. The minimum initial retroreflectivity is 250 $mcd \cdot m^{-2} \cdot lx^{-1}$ for white and 175 $mcd \cdot m^{-2} \cdot lx^{-1}$ for yellow, except Type C preformed tape shall meet the minimum initial values in ASTM D4505. The minimum retroreflectivity after 12 months is 150 $mcd \cdot m^{-2} \cdot lx^{-1}$ for white and 100 $mcd \cdot m^{-2} \cdot lx^{-1}$ for yellow, when measured in the skip line area. However, the Department will review the results of each test deck to determine the minimum value in effect for that deck, in order to approve only the better-performing materials.

9-34.7(1)B Durability

Durability rating shall be a minimum of seven in the skip line area and six in the wheel paths after 12 months. The rating system used will be as indicated by NTPEP procedures. However, the department will review the results for each test deck to determine the minimum value in effect for that deck, in order to approve only the better-performing materials.

9-34.7(1)C Auto No-Track Time

Auto No-Track Time will only be required for low VOC solvent-based paint in accordance with Section 9-34.2(4).

No-track time shall be determined in accordance with NTPEP procedures by passing over an applied test line with a standard size passenger car without tracking of the line when viewed from a distance of 50 feet. The maximum no-track time shall not be exceeded when the pavement temperature is between 50°F and 120°F, with relative humidity less than 85 percent, and the pavement is dry.

9-34.7(1)D Approval

The Department will evaluate the results of laboratory and test deck data. This information will be reviewed for each material by color and roadway surface to determine compliance with this Specification. Approved product formulas will remain active for a period of approximately 5 years after completion of the NTPEP evaluation; afterwards, the product will need to be reevaluated.

9-35 Temporary Traffic Control Materials

9-35.0 General Requirements

Temporary traffic control materials in this section consist of various traffic communication, channelization and protection items described in Section 1-10 and listed below:

Stop/Slow Paddles
Construction Signs
Wood Sign Posts
Sequential Arrow Signs
Portable Changeable Message Signs
Barricades
Traffic Safety Drums
Traffic Cones
Tubular Markers
Warning Lights and Flashers
Transportable Attenuator
Portable Temporary Traffic Control Signal
Tall Channelizing Devices

The basis for acceptance of temporary traffic control devices and materials shall be visual inspection by the Engineer's representative. No sampling or testing will be done except that deemed necessary to support the visual inspection. Unless otherwise noted, requests for Approval of Material (RAM) and Qualified Products List (QPL) submittals are not required. Certification for crashworthiness according to NCHRP 350 or the Manual for Assessing Safety Hardware (MASH) will be required as described in Section 1-10.2(3).

"MUTCD", as used in this section, shall refer to the latest WSDOT adopted edition of the *Manual on Uniform Traffic Control Devices for Streets and Highways*. In the event of conflicts between the MUTCD and the Contract provisions, then the provisions shall govern.

9-35.1 Stop/Slow Paddles

Paddles shall conform to the requirements of the MUTCD, except that the minimum width shall be 24 inches.

9-35.2 Construction Signs

Construction signs shall conform to the requirements of the MUTCD and shall meet the requirements of NCHRP Report 350 for Category 2 devices or MASH. Except as noted below, any sign/sign stand combination that satisfies these requirements will be acceptable. Post mounted Class A construction signs shall conform to the requirements of this section and additionally shall conform to the requirements stated in Section 9-28.

Aluminum sheeting shall be used to fabricate all construction signs. The signs shall have a minimum thickness of 0.080 inches and a maximum thickness of 0.125 inches.

All orange background signs shall be fabricated with Type X reflective sheeting. All post-mounted signs with Type X sheeting shall use a nylon washer between the twist fasteners (screw heads, bolts or nuts) and the reflective sheeting.

The use of plywood, fiberglass reinforced plastic, fabric rollup signs, and any other previously approved sign materials except aluminum or aluminum composite is prohibited.

All Class A and Class B signs shall utilize materials and be fabricated in accordance with Section 9-28 and the Washington State *Sign Fabrication Manual* M 55-05. A fabrication decal as stated in Section 9-28.1 is not required for construction signs. All regulatory signs having a red background (i.e., Stop, Yield) shall be fabricated with Type III or IV sign sheeting. All other regulatory information signs (i.e., Speed Limit, Traffic Fines Double in Work Zones) shall have Type II sheeting in rural areas and Type III or IV sheeting in urban areas. All signs having a green background (i.e., Exit arrow) shall have Type II sheeting for the background and Type III or IV sheeting for the letters, border, and symbols.

9-35.3 Wood Sign Posts

Post sizes for construction signs shall be as follows:

One Post Installation

Post Size	Min. Sign Sq. Ft.	Max. Sign Sq. Ft.
4x4		16.0
4x6	17.0	20.0
6x6	21.0	25.0
6x8	26.0	31.0

Two Post Installation
(For signs 5 feet or greater in width)

Post Size	Min. Sign Sq. Ft.	Max. Sign Sq. Ft.
4x4		16.0
4x6	17.0	36.0
6x6	37.0	46.0
6x8	47.0	75.0*

*The Engineer shall determine post size for signs greater than 75 square feet.

Sign posts shall conform to the grades and usage listed below. Grades shall be determined by the current standards of the West Coast Lumber Inspection Bureau (WCLIB) or the Western Wood Products Association (WWPA).

4 × 4	Construction grade (Light Framing, Section 122-b WCLIB) or (Section 40.11 WWPA)
4 × 6	No. 1 and better, grade (Structural Joists and Planks, Section 123-b WCLIB) or (Section 62.11 WWPA)
6 × 6, 6 × 8, 8 × 10	No. 1 and better, grade (Posts and Timbers, Section 131-b WCLIB) or (Section 80.11 WWPA)
6 × 10, 6 × 12	No. 1 and better, grade (Beams and Stringers, Section 130-b WCLIB) or (Section 70.11 WWPA)

9-35.4 Sequential Arrow Signs

Sequential Arrow Signs shall meet the requirements of the MUTCD supplemented with the following:

Sequential arrow signs furnished for stationary lane closures on this project shall be Type C.

The color of the light emitted shall be yellow.

The dimming feature shall be automatic, reacting to changes in light without a requirement for manual adjustment.

9-35.5 Portable Changeable Message Signs

Portable Changeable Message Signs (PCMS) shall meet the requirements of the MUTCD and the following:

The PCMS shall employ one of the following technologies:

1. Fiber optic/shutter
2. Light emitting diode
3. Light emitting diode/shutter
4. Flip disk

Regardless of the technology, the PCMS shall meet the following general requirements:

1. Be light emitting and must not rely solely on reflected light. The emitted light shall be generated using fiber optic or LED technology.
2. Have a display consisting of individually controlled pixels no larger than 2½ by 2½ inch. If the display is composed of individual character modules, the space between modules must be minimized so alphanumeric characters of any size specified below can be displayed at any location within the matrix.

3. When activated, the pixels shall display a yellow or orange image. When not activated, the pixels shall display a flat black image that matches the background of the sign face.
4. Be capable of displaying alphanumeric characters that are a minimum of 18 inches in height. The width of alphanumeric characters shall be appropriate for the font. The PCMS shall be capable of displaying three lines of eight characters per line with a minimum of one pixel separation between each line.
5. The PCMS message, using 18-inch characters, shall be legible by a person with 20/20 corrected vision from a distance of not less than 800 feet centered on an axis perpendicular to the sign face.
6. The sign display shall be covered by a stable, impact resistant polycarbonate face. The sign face shall be non-glare from all angles and shall not degrade due to exposure to ultraviolet light.
7. Be capable of simultaneously activating all pixels for the purpose of pixel diagnostics. Any sign that employs flip disk or shutter technology shall be programmable to activate the disks/shutters once a day to clean the electrical components. This feature shall not occur when the sign is displaying an active message.
8. The light source shall be energized only when the sign is displaying an active message.
9. Primary source of power shall be solar power with a battery backup to provide continuous operation when failure of the primary power source occurs.
10. The sign controller software shall be NTCIP compliant.

The PCMS panels and related equipment shall be permanently mounted on a trailer with all controls and power generating equipment.

The PCMS shall be operated by a controller that provides the following functions:

1. Select any preprogrammed message by entering a code.
2. Sequence the display of at least five messages.
3. Blank the sign.
4. Program a new message, which may include animated arrows and chevrons.
5. Mirror the message currently being displayed or programmed.

9-35.6 Barricades

Barricades shall conform to the requirements of the MUTCD supplemented by the further requirements of the *Standard Plans*.

9-35.7 Traffic Safety Drums

Traffic safety drums shall conform to the requirements of the MUTCD and shall have the following additional physical characteristics:

Material requirements	Fabricated from low-density polyethylene that meets the of ASTM D4976 and is UV stabilized.
Overall Width	18-inch minimum regardless of orientation.
Shape	Rectangular, hexagonal, circular, or flat-sided semi-circular.
Color	The base color of the drum shall be fade resistant safety orange.

The traffic safety drums shall be designed to accommodate at least one portable light unit. The method of attachment shall ensure that the light does not separate from the drum upon impact.

Drums and light units shall meet the crashworthiness requirements of NCHRP 350 or MASH as described in Section 1-10.2(3).

When recommended by the manufacturer, drums shall be treated to ensure proper adhesion of the reflective sheeting. Retroreflective bands shall be fabricated from Type III or Type IV reflective sheeting as described in Section 9-28.12.

9-35.8 Vacant

9-35.9 Traffic Cones

Cones shall conform to the requirements of the MUTCD, except that the minimum height shall be 28 inches.

Retroreflective bands shall be fabricated from Type III or Type IV reflective sheeting as described in Section 9-28.12.

9-35.10 Tubular Markers

Tubular markers shall conform to the requirements of the MUTCD, except that the minimum height shall be 28 inches.

The devices shall be stabilized by affixing them to the pavement by using either weighted bases or adhesive. Adhesive used to glue the device to the pavement shall meet the requirements of Sections 9-02.1(8) or 9-26.2. Retroreflective bands shall be fabricated from Type III or Type IV reflective sheeting as described in Section 9-28.12.

9-35.11 Warning Lights and Flashers

Warning lights and flashers shall conform to the requirements of the MUTCD.

9-35.12 Transportable Attenuator

Transportable attenuators are Truck-Mounted Attenuators (TMA) or Trailer-Mounted Attenuators (TMA-trailer). The transportable attenuator shall be mounted on, or attached to, a host vehicle that complies with the manufacturer's recommended weight range. Ballast used to obtain the minimum weight requirement, or any other object that is placed on the vehicle, shall be securely anchored such that it will be retained on the vehicle during an impact. The Contractor shall provide certification that the transportable attenuator complies with NCHRP 350 Test level 3 or MASH Test Level 3 requirements. Lighter host vehicles proposed by the Contractor are subject to the approval of the Engineer. The Contractor shall provide the Engineer with roll-ahead distance calculations and crash test reports illustrating that the proposed host vehicle is appropriate for the attenuator and the site conditions.

The transportable attenuator shall have a chevron pattern on the rear of the unit. The standard chevron pattern shall consist of 4-inch yellow stripes, alternating nonreflective black and retroreflective yellow sheeting, slanted at 45 degrees in an inverted "V" with the "V" at the center of the unit.

9-35.12(1) Truck-Mounted Attenuator

The TMA may be selected from the approved units listed on the QPL or submitted using a RAM.

The TMA shall have an adjustable height so that it can be placed at the correct elevation during usage and to a safe height for transporting. If needed, the Contractor shall install additional lights to provide fully visible brake lights at all times.

9-35.12(2) Trailer-Mounted Attenuator

The TMA-trailer may be selected from the approved units listed on the QPL or submitted using a RAM.

If needed, the Contractor shall install additional lights to provide fully visible brake lights at all times.

9-35.12(3) Submittal Requirements

For transportable attenuators listed on the QPL, the Contractor shall submit the QPL printed page or a QPL Acceptance Code entered on the RAM (WSDOT Form 350-071) for the product proposed for use to the Engineer for approval. The Contractor shall submit a RAM for transportable attenuators not listed on the QPL.

9-35.13 Tall Channelizing Devices

Tall channelizing devices shall meet the requirements of the MUTCD Part VI for channelizing devices and shall conform to these general Specifications:

Fabricated of fade resistant, safety orange color, low-density polyethylene that is resistant to deformation upon impact and meets the requirements of ASTM D4976 and is UV stabilized.

Forty-two inches in height minimum, using a tapered cone type shape of consistent dimensions regardless of orientation to traffic.

Four inches in width minimum at the top and 8 inches in width minimum at the base, which incorporates a separate ballast that is designed to resist overturning or other movement from wind gusts or other external forces.

Four retroreflective 6-inch-wide horizontal bands, alternating orange and white beginning 6 inches from the top of the device. Retroreflective bands shall be fabricated from Type III or Type IV reflective sheeting as described in Section 9-28.12.

Warning lights are not required unless specifically shown on the traffic control Plan but provisions for securely attaching a warning light are required. The method of attachment must ensure that the light does not separate from the device upon impact and light units shall meet the crashworthiness requirements of NCHRP 350 or MASH as described in Section 1-10.2(3).

Devices shall be regularly maintained to ensure that they are clean and the reflective sheeting is in good condition.

Except for the Specifications and requirements specifically listed above, Tall Channelizing Devices are defined to be Traffic Cones. All non-conflicting Contract provisions related to “Cones” shall apply to Tall Channelizing Devices.

9-35.14 Portable Temporary Traffic Control Signal

Portable traffic control signals shall meet the requirements of the MUTCD and these specifications.

The portable temporary traffic control signal shall be fully operational for two-phase traffic actuated, pre-timed, or manual control. The portable temporary traffic control signal shall conform to the following requirements:

Controllers shall demonstrate conflict-monitoring capability, consistent with the requirements of Section 9-29.13(2) item number 5, with a flashing red display in both directions. The portable traffic control signal shall be capable of terminating the movement one (1) or movement two (2) all red clearance, in order to repeat the previous movements operation.

Signal head displays shall be either hard wired or controlled by radio signal. Manual operation will not require hardwiring or radio control except for the use of two-way radio communication by manufacturer trained qualified operators.

The system shall be equipped with a means of informing the operator of signal indications, such as a light on the back of each signal head that illuminates when the signal displays a red indication, during manual operation.

A vehicle detection system is required. The system shall be capable of operating either as fixed time or traffic actuated controller. The detection system shall provide presence detection (continuous call to the controller) while there is a vehicle in the detection zone.

Signal supports used with portable traffic control signals shall provide a minimum of two signal displays, spaced a minimum of 8 feet apart. When trailer-mounted portable traffic signals are used to provide alternating one-way control, a minimum of one of the signal displays shall be suspended over the traveled way. The minimum vertical clearance to the traveled way for this signal display is 16.5 feet. Vehicular signal heads shall be of the conventional type with standard ITE approved, 12-inch ball LED display. Tunnel visors shall be provided for all indications.

Back plates shall be furnished and attached to the signal heads. Back plates shall be constructed of 5-inch-wide .050-inch-thick corrosion resistant louvered aluminum, with a flat black finish. A highly retroreflective yellow strip, 1 inch wide, shall be placed around the perimeter of the face of all vehicle signal backplates to project a rectangular image at night toward oncoming traffic.

Trailers shall have a leveling jack installed at all four corners. The crank for the leveling jacks and trailer hitch shall be locked. The signal pole and mast arm assemblies shall be of the collapsible type, which can be erected and extended at the job site. The mast arm assemblies shall be firmly attached to the trailer to form a stable unit, which can withstand an 80 mph design wind speed with a 1.3 gust factor.

The portable temporary traffic control signal shall be powered using a self-contained battery system capable of providing over 12 days of continuous operations without solar array assistance. A solar panel array will be allowed.

9-36 Shaft-Related Materials

9-36.1 Shaft Casing

9-36.1(1) Permanent Casing

Permanent casing shall be of steel base metal conforming to ASTM A36, ASTM A252 Grades 2 or 3, ASTM A572, or ASTM A588.

Permanent casing for CFST shafts shall conform to Section 9-10.5 requirements for steel pipe piling.

9-36.1(2) Temporary Casing

Temporary casing shall be a smooth wall structure of steel base metal, except where corrugated metal pipe is shown in the Plans as an acceptable alternative material. Use of corrugated metal pipe as temporary casing will not be allowed for shaft foundations of monotube sign bridges and cantilever sign structures.

9-36.2 Shaft Slurry

9-36.2(1) Mineral Slurry

Mineral slurry shall conform to the following requirements:

Property	Test	Requirement
Density (pcf)	Mud Weight (Density) API 13B-1, Section 1	63 to 75
Viscosity (seconds/quart)	Marsh Funnel and Cup API 13b-1, Section 2.2	26 to 50
PH	Glass Electrode, pH Meter, or pH Paper	8 to 11
Sand Content (percent)	Sand API 13B-1, Section 5	
Prior to final cleaning		4.0 max.
Immediately prior to placing concrete		4.0 max.

Use of mineral slurry in salt water installations will not be allowed.

Slurry temperature shall be at least 40F when tested.

9-36.2(2) Synthetic Slurry

Synthetic slurries shall be used in conformance with the manufacturer's recommendations and shall conform to the quality control plan specified in Section 6-19.3(2)B, item 4. The synthetic slurry shall conform to the following requirements:

Property	Test	Requirement
Density (pcf)	Mud Weight (Density) API 13B-1, Section 1	64 max.
Viscosity (seconds/quart)	Marsh Funnel and Cup API 13b-1, Section 2.2	32 to 135
PH	Glass Electrode, pH Meter, or pH Paper	6 to 11.5
Sand Content (percent)	Sand API 13B-1, Section 5	
prior to final cleaning		1.0 max.
immediately prior to placing concrete		1.0 max.

If the product is not listed on the Qualified Products List, the Contractor shall submit a Request for Approval of Materials Source (RAM) form with the following information:

- Test data showing conformance to the properties in the table above, and
- Documentation showing that the synthetic slurry (with load-tested additives) has been approved by the California Department of Transportation (Caltrans).

9-36.2(3) Water Slurry

Water without site soils may be used as slurry when casing is used for the entire length of the drilled hole. Water slurry without full length casing may only be used with the approval of the Engineer.

Water slurry shall conform to the following requirements:

Property	Test	Requirement
Density (pcf)	Mud Weight (Density) API 13B-1, Section 1	65 max.
Sand Content (percent)	Sand API 13B-1, Section 5	1.0 max.

Use of water slurry in salt water installations will not be allowed.

Slurry temperature shall be at least 40°F when tested.

9-36.3 Steel Reinforcing Bar Centralizers

Steel reinforcing bar centralizers shall be steel, conforming to the details shown in the Plans. The Contractor may propose the use of alternative steel reinforcing bar devices as part of the shaft installation narrative as specified in Section 6-19.3(2)B, item 9, subject to the Engineer's review and approval of such devices.

9-36.4 Access Tubes and Caps

Access tubes for CSL or TIP testing shall be steel pipe of 0.145 inches minimum wall thickness and at least 1½ inch inside diameter.

The access tubes shall have a round, regular inside diameter free of defects and obstructions, including all pipe joints, in order to permit the free, unobstructed passage of 1.3-inch maximum diameter source and receiver probes used for the crosshole sonic log tests. The access tubes shall be watertight and free from corrosion, with clean internal and external faces to ensure a good bond between the concrete and the access tubes.

The access tubes shall be fitted with watertight threaded PVC caps on the bottom, and shall be fitted with watertight PVC caps, secured in position by means as approved by the Engineer, on the top.

9-36.5 Grout for Access Tubes

Grout for filling the access tubes at the completion of the crosshole sonic log tests shall be a homogeneous mixture of neat cement grout and potable water, conforming to Section 9-20.3(4), except that the maximum water/cement ratio shall be 0.45.