

CONTRACTOR-FABRICATED PRECAST CONCRETE STRUCTURE

**** From New Haven BRF 0183(1)**

- xx. DESCRIPTION. This work shall consist of manufacturing, transporting, handling, and erecting precast concrete structure components fabricated by the Contractor at a location other than a Precast Concrete Institute (PCI) or National Precast Concrete Association (NPCA) certified precast concrete facility.
- xx. MATERIALS. Materials shall meet the requirements of Subsections 501.02, 507.02, and 540.02.
- (a) Concrete. Concrete shall meet the requirements of Subsection 540.05, with the exception that the requirements of part (a) do not apply. In lieu of a mix meeting the requirements of Subsection 540.05, the Contractor may provide a mix meeting the requirements of Section 501 for Concrete, High Performance Class A or Concrete, High Performance Class B, provided that the design strength as shown in the Plans as well as that required for lifting and handling is met.
- xx. GENERAL FABRICATION REQUIREMENTS. Unless noted otherwise herein, Contractor-fabricated Precast Concrete (CFPC) produced and paid under this Special Provision shall meet the requirements of Sections 501, 507, and 540.
- xx. SUBMITTALS. As soon as practical after award of the Contract, all required information shall be prepared and submitted.

A complete copy of the structural design calculations for the CFPC shall be submitted as Construction Drawings in accordance with Section 105. The design calculations shall substantiate that the proposed precast concrete satisfies the design parameters of the Contract. The applicable design code will be the latest edition of the AASHTO LRFD Bridge Design Specifications unless indicated otherwise in the Contract Documents.

Fabrication Drawings for the precast concrete shall be submitted in accordance with Section 105, with an additional copy to the Composite Materials Engineer. In addition to the requirements for Fabrication Drawings in Section 105, the following shall be included:

- (a) Dimensions and tolerances of the precast concrete to be fabricated.
- (b) The concrete mix design, including but not limited to the following:
- (1) Batch weights specifying dry or saturated surface dry.
 - (2) Material names and sources.
 - (3) Aggregate properties and date tested.
 - (4) Chemical and physical properties of cementitious material.

- (5) Admixture names and sources.
- (6) Lab data that shall include, but not be limited to:
 - a. Slump.
 - b. Air Content.
 - c. Temperature.
 - d. Ratio of Water/Cementitious Material.
 - e. Cylinder breaks for 3, 7, and 28 days cured in the same manner as the piece to be fabricated.
 - f. 56-day Rapid Chloride Ion Permeability - AASHTO T 277 test data. The results shall be the average from testing 3 specimens, but the individual specimen results shall also be included. Testing shall be performed by an independent laboratory accredited by AMRL in this test method.
 - g. Alkali-Silica Reactivity (ASR) - AASHTO T 303 data from testing of both the fine and coarse aggregates. Testing shall be performed by an independent laboratory accredited by AMRL in this test method.
- (7) Alkali-Silica Reactivity (ASR). If potentially reactive aggregates are to be used in a mix design, then proposed mitigation method(s) and test results must be provided.

The AASHTO T 303 test must be run again with the proposed mitigation method(s) and using the proposed job cementitious material proportioning. The proposed mitigation method(s) shall reduce expansion to below 0.10%.

If a mix design, including the testing results, has been submitted and approved within a 12 month period, it may be used in lieu of submitting an additional mix design. However, if any change in the material sources, properties, or proportions has occurred, then a new mix design with lab test data will be required regardless of previous approval. The requirements for testing in Subsections 540.04(b)(6)f, 540.04(b)(6)g, and 540.04(b)(7) above shall be waived if the submitted mix design has a minimum proportion of the cementitious material content of that allowed for use in High Performance Concrete in Section 501.

The mix design shall be approved by the Composite Materials Engineer prior to fabrication.

- (c) The sources and properties of the materials proposed for use.
- (d) The placement of reinforcing steel, welded wire fabric, mechanical bar connectors, and inserts.
- (e) The type of surface finish and how the finish will be obtained.

Include details of potential repair procedures.

- (f) The curing method, detailing sequence, and duration.
- (g) The minimum required concrete strength for design strength and form removal.
- (h) The design of the lifting attachments.
- (i) Transportation, handling, and storage details.
- (j) The installation procedures, including a detailed grouting procedure.
- (k) A Quality Control Plan that identifies a Quality Control Manager and provides previous experience for work of this nature. A Description of Quality Control Processes addressing but not limited to:
 - (1) Concrete production including batching, delivery, and placement.
 - (2) Formwork.
 - (3) Reinforcing.
 - (4) Concrete finishing.
 - (5) Concrete cure.
 - (6) Shipping/Installation procedures.

xx. INSPECTION. Materials furnished and the work performed herein shall be inspected by the Agency. The Agency will test all concrete incorporated into the work in accordance with Section 501. The inspector shall have the authority to reject any material or work that does not meet the requirements of the Specifications. Advance notification of at least two (2) weeks shall be provided by the Contractor to the Agency's Engineer and the Composite Materials Engineer concerning the proposed intention to commence work. A minimum of five (5) working days notification shall be provided by the Contractor to the Agency's Engineer and the Composite Materials Engineer to confirm the fabrication start date.

Prior to placing any precast concrete elements produced under these Specifications, all materials shall have all applicable certifications approved in accordance with Subsection 700.02.

xx. FABRICATION.

- (a) Pre-Production Meeting. Unless the Engineer deems, in writing, that a pre-production meeting is unnecessary, then a pre-production meeting shall be held a minimum of seven (7) calendar days prior to beginning concrete placement. The pre-production meeting shall be attended by, as a minimum but not limited to, the Crew Supervisor, Contractor Project Manager, Concrete

Producer, Resident Engineer, Project Manager, and Composite Materials Engineer.

- (b) Placing Concrete. Concrete placement shall be in accordance with Subsection 501.10 and as specified herein. Concrete shall not be deposited in the forms until the appropriate Agency representative has approved placement of the reinforcement, conduits, and anchorages.
 - (c) Repairs/Patching. CFPC structure components that contain minor defects caused by manufacture or handling may be repaired at the manufacturing site. Minor defects are defined as holes, honeycombing, or spalls which are 150 mm (6 inches) or less in diameter and that do not penetrate deeper than 25 mm (1 inch) into the concrete. Surface voids or "bugholes" that are less than 16 mm (5/8 inch) in diameter and less than 6 mm (1/4 inch) deep need not be repaired. Repairs shall be made using a material from the Agency's Approved Products List for overhead and vertical concrete repair. The repair material shall be cured as specified by the manufacturer. Repairs shall be approved by the Engineer.
 - (d) Cracking. Cracks less than 0.25 mm (0.01 inch) in width shall be sealed by a method approved by the Engineer. Cracks in excess of 0.25 mm (0.01 inch) may be cause for rejection. At the Engineer's discretion, cracked CFPC structure components shall be repaired or replaced at the Contractor's expense.
 - (e) Dimensional Tolerances. All tolerances shall be in accordance with the latest editions of both PCI MNL 116 *Manual for Quality Control for Plants and Production of Precast and Prestressed Concrete Products* and PCI MNL 135 *Tolerance Manual for Precast and Prestressed Concrete Construction*, or with the National Precast Concrete Association (NPCA) *Quality Control Manual for Precast Concrete*, unless otherwise noted in the Contract Documents or as approved by the Engineer.
 - (f) Marking. The date of manufacture, the production lot number, and the piece mark shall be clearly marked on each individual piece of precast concrete. The mark shall be in a location that will not be visible in the finished product.
- xx. HANDLING, STORAGE, AND SHIPPING. Each CFPC structure shall be handled, stored, and shipped in such a manner as to minimize chipping, cracks, fractures, discoloration, and excessive bending stresses. A unit damaged by handling, storage, or shipping shall be replaced at the Contractor's expense.

A CFPC structure shall not be installed until the respective unit has been inspected. This inspection shall verify that the pieces are free from defects, and that all specification requirements, including but not limited to those for compressive strength and tolerance requirements, have been achieved. In addition, a CFPC structure will not be considered for shipment until the completion of the cure period and the required strength has been attained as demonstrated by field-cured cylinder breaks.

- xx. INSTALLATION METHODS, EQUIPMENT, AND ERECTION. Cranes, lifting devices, and other equipment for CFPC structure erection shall be of adequate design and capacity to safely erect, align, and secure all members and components in their final positions without damage. The Contractor is solely responsible for the methods and equipment employed for the erection of the CFPC structure components.

Construction Drawings for CFPC structure component erection shall be submitted in accordance with Section 105. The erection plan shall include the necessary computations to indicate the magnitude of stress in the units during erection and to demonstrate that all of the erection equipment has adequate capacity for the work to be performed, and provisions for all stages of construction, including temporary stoppages.

Post tensioning shall comply with Subsection 540.12.

Submittal of the erection plan is for the Agency's documentation only and shall in no way be construed as approval of the proposed method of erection. The Contractor shall follow the erection plan as submitted.

- xx. GROUT.

- (a) Unless otherwise noted grout shall be used to fill shear keys, leveling screw voids, transverse tie anchor recesses, dowel holes, and for fairing joints as detailed in the Contract Documents or as ordered by the Engineer.

Grout shall be Mortar, Type IV. Acceptable grout materials shall be those included on the Approved Products List on file with the Agency's Materials and Research Section. Additional aggregates shall not be added to the material during field mixing.

The Contractor, with written permission from the Engineer, has the option to use ready-mixed mortar for the grouting process. The Contractor shall prepare and submit for approval the mix design for the grout. The maximum quantity that may be delivered in a single load is one cubic meter (1.25 cubic yards), which shall be delivered and placed within the time limits specified by the manufacturer.

For testing, 6 neat 50 mm (2 inch) cubes shall be molded and cured in accordance with AASHTO T 106 (ASTM C 109). The average compressive strength of 3 cubes shall be a minimum of 7 MPa (1000 psi) at 3 days and a minimum of 35 MPa (5000 psi) at 28 days.

- (b) The surface to be grouted shall be thoroughly cleaned, wetted, and free of all standing water. The grout shall be mixed using a mechanical mixer according to the manufacturer's recommendations and shall be readily pourable so that it completely fills the shape of the shear keys or holes, depending on the product being installed. The placement of grout shall be continuous so as to produce a monolithic key absent of any voids or cold joints.

(c) All exposed grout shall be cured for a period of not less than three days by the wetted burlap method in accordance with Section 501. Curing shall commence as soon as practical after grout placement.

xx. METHOD OF MEASUREMENT. The quantity of Special Provision (Contractor-Fabricated Precast Concrete Structure) of the type and size specified to be measured for payment shall be on a lump sum basis. The lump sum shall include all of the CFPC structure components in the complete and accepted work for each location specified in the Contract.

xx. BASIS OF PAYMENT. The accepted quantity of Special Provision (Contractor-Fabricated Precast Concrete Structure) of the type and size specified will be paid for at the Contract lump sum price. Payment shall be full compensation for designing, detailing, fabricating, repairing, transporting, handling, and erecting the materials specified, for furnishing and implementing the erection plan, and for furnishing all labor, tools, equipment, and incidentals necessary to complete the work.

Any grouting work, such as fairing out unevenness between adjacent precast concrete structure components and filling leveling screw holes, shear keys, transverse anchor recesses, and dowel holes, is considered incidental to the work for Special Provision (Contractor-Fabricated Precast Concrete Structure).

Payment will be made under:

<u>Pay Item</u>	<u>Pay Unit</u>
900.645 Special Provision (Contractor-Fabricated Precast Concrete Structure)(Abutment #1)	Lump Sum
900.645 Special Provision (Contractor-Fabricated Precast Concrete Structure)(Abutment #2)	Lump Sum
900.645 Special Provision (Contractor-Fabricated Precast Concrete Structure)(Approach Slab #1)	Lump Sum
900.645 Special Provision (Contractor-Fabricated Precast Concrete Structure)(Approach Slab #2)	Lump Sum