

GUIDELINES — FOR PROJECTS REQUIRING HYDRAULIC CEMENT CONCRETE. LOW PERMEABILITY CONCRETE IS NOW INCLUDED IN THIS SP. WHEN THIS PROVISION APPLIES INCLUDE THE FOLLOWING IN THE PROPOSAL: SS21402 HYDRAULIC CEMENT AND SS21501 HYDRAUL CEMENT CONC ADMIXTURES.

SS21705-0911

January 27, 2011

VIRGINIA DEPARTMENT OF TRANSPORTATION
2007 ROAD AND BRIDGE SUPPLEMENTAL SPECIFICATIONS

SUPPLEMENTAL SECTION 217—HYDRAULIC CEMENT CONCRETE

SECTION 217—HYDRAULIC CEMENT CONCRETE of the Specifications is amended as follows:

Section 217.02(a) Cementitious Materials is replaced with the following:

Cementitious materials shall be a blend of mineral admixtures and Portland cement or a blended cement. In overlay concretes, expansive hydraulic cement is permitted in lieu of Portland cement. Portland cement (Types I, II, III) blended cements (Type IP, Type IS) or expansive cement (Type K) shall comply with Section 214 of the Specifications. Flyash, ground granulated iron blast-furnace slag (GGBFS), silica fume or metakaolin shall conform to Section 215 of the Specifications. As a portion of the cementitious material, Table 1 lists the minimum percents of specific pozzolans required by mass of the cementitious material depending on the alkali content of the cement. Any other mineral admixture or any other amount or combination of mineral admixtures may be used if approved by the Engineer. As a portion of the cementitious material, the fly ash content shall not exceed 30 percent for Class F, the ground granulated blast-furnace slag content shall not exceed 50 percent and the silica fume content shall not exceed 10 percent unless approved by the Engineer. Class C Flyash or other pozzolans may be used provided the contractor demonstrates that the percent usage of Class C Flyash or other pozzolans have a maximum expansion of 0.15% according to ASTM C227 at 56 days using borosilicate glass as aggregate. Blended cements require no further pozzolan additions to meet minimum pozzolan content to compensate for the alkali-silica reaction.

Up to 7 percent silica fume may be added to all combinations of cementitious materials to reduce early permeability without approval by the Engineer. Other silica fume additions must be approved by the Engineer.

Table 1 – Minimum percent pozzolan required by mass of cementitious material as a portion of the total cementitious materials and are based upon the alkali content of the cement.

	Total Alkalies of Cement is less than or equal to 0.75%	Total Alkalies of Cement is greater than 0.75% and less than or equal to 1.0%
Class F Flyash	20%	25%
GGBF Slag	40%	50%
Silica Fume	7%	10%
Metakaolin	7%	10%

TABLE II–17 Requirements for Hydraulic Cement Concrete is replaced with the following:

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**TABLE II-17
Requirements for Hydraulic Cement Concrete**

A5 Prestressed and other special designs ²	5,000 or as specified on the plans	57 or 68	1,500	1,500	1,500	1	A	635	0.40	0-4	4 1/2 ± 1 1/2
A4 General	4,000	56 or 57	2,000	2,500	2,000	1	A	635	0.45	2-4	6 1/2 ± 1 1/2
A4 Post & rails	4,000	7,8 or 78	2,000	2,500	2,000	0.5	A	635	0.45	2-5	7 ± 2
A3 General	3,000	56 or 57	2,000	3,500	2,000	1	A	588	0.49	1-5	6 ± 2
A3a Paving	3,000	56 or 57	3,500	3,500	3,500	1	A	564	0.49	0-3	6 ± 2
A3b Paving	3,000	357	3,500	3,500	3,500	2	A	N.A	0.49	0-3	6 ± 2
B2 Massive or lightly Reinforced	2,200	57	N.A.	N.A.	N.A.	1	B	494	0.58	0-4	4 ± 2
C1 Massive Unreinforced	1,500	57	N.A.	N.A.	N.A.	1	B	423	0.71	0-3	4 ± 2
T3 Tremie seal	3,000	56 or 57	N.A.	N.A.	N.A.	1	A	635	0.49	3-6	4 ± 2
Latex hydraulic cement concrete overlay ³	3,500	7,8 or 78	1,500	1,500	1,500	0.5	A	658	0.40	4-6	5 ± 2
Silica fume, silica fume /Class F Fly Ash or silica fume/slag concrete overlay ⁴	5000	7,8 or 78	1,500	1,500	1,500	0.5	A	658	0.40	4-7	6 ± 2
Class F Fly Ash or slag overlay	4000	7,8 or 78	1,500	1,500	1,500	0.5	A	658	0.40	4-7	6 ± 2

(See next page for notes on TABLE II-17).

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----- (TABLE II-17 Notes) -----

- ¹ When a high-range water reducer is used, the upper limit for entrained air may be increased by 1% and the slump shall not exceed 7 inches.
- ² When Class A5 concrete is used as the finishing bridge deck riding surface, or when it is to be covered with asphalt concrete with or without waterproofing, the air content shall be $5 \frac{1}{2} \pm 1 \frac{1}{2}$ percent.
- ³ The latex modifier content shall be 3.5 gallons per bag of cement. Slump shall be measured approximately 4.5 minutes after discharge from the mixer.
- ⁴ Silica fume with a minimum of 7% by weight of cementitious material; silica fume with a range of 2.5-5 % shall be combined with Class F Fly Ash in range of 15-20% and minimum cement of 77.5% by weight of cementitious material; silica fume with a range of 2.5-5% shall be combined with Ground Granulated Blast Furnace Slag in the range of 30-35% and a minimum cement of 67.5% by weight of cementitious material.
- ⁵ The permeability testing does not apply to small bridges identified on the bridge plans and to concrete structures and incidental concrete as described in Sections 219, 232, 302, 415, 502, 504, 506 and 519. Curing and testing of test cylinders for permeability will be in accordance with VTM 112.
- ⁶ The contractor may use different aggregate sizes or a combination of sizes to increase the coarse aggregate content of the concrete as approved by the Engineer. The maximum size of the coarse aggregate shall not exceed 2.5 inches.

Note: With the approval of the Engineer, the Contractor may substitute a higher class of concrete for that specified at the Contractor's expense.

Section 217.02(b) Formulated latex modifier is amended by adding the following:

For latex-modified concrete, Type I, Type II, Type III or Type K, cement shall be used without mineral admixtures.

Section 217.04(a)4. Admixtures is replaced with the following:

4. **Admixtures** shall be dispensed and used according to the manufacturer's recommendations. They shall be added within a limit of accuracy of 3 percent, by means of an approved, graduated, transparent, measuring device before they are introduced into the mixer. If more than one admixture is to be used, they shall be released in sequence rather than in the same instant. Once established, the sequence of dispensing admixtures shall not be altered. However, when the amount of admixture required to give the specified results deviates appreciably from the manufacturer's recommended dosage, use of the material shall be discontinued.

Section 217.05—Equipment is amended to replace the first paragraph with the following:

Equipment and tools necessary for handling materials and performing all parts of the work will be approved by the Engineer and must be in accordance with one of the following procedures:

1. having a current National Ready Mix Concrete Association Plant and Truck Certification, or
2. having a Department approved self-certification program in-place prior to the production of concrete for the Department.

Failure to comply with one or the other of these procedures will result in the concrete production being unapproved and work will not be allowed to proceed.

Section 217.05(a) Batching Equipment is amended to replace the second paragraph with the following:

Scales used for weighing aggregates and cement shall be approved and sealed in accordance with the requirements of Section 109 of the Specifications.

Section 217.05—Equipment is amended to add the following:

(d) **High Performance Volumetric Mixers (HPVMs):** The Contractor may produce the specified class of hydraulic cement concrete in Table II-17 in accordance with Section 217.02(a) of the Specifications provided that the manufacturer's equipment meets the tolerance requirements of Section 217.04(a) of the Specifications and has a stamped plate from the Volumetric Mixers Manufacturers Bureau stating that the equipment conforms to the requirements in ASTM C685.

The hydraulic cement concrete shall be mixed at the point of delivery by a combination of materials transport and mixer unit conforming to the following:

1. The unit shall be equipped with calibrated proportioning devices for each ingredient added to the concrete mix. The unit shall be equipped with a working recording meter that is visible at all times and furnishes a ticket printout with the calibrated measurement of the mix being produced. If at anytime the mixer fails to discharge a uniform mix, production of concrete shall halt until any problems are corrected.
2. Each unit shall have a metal plate(s) attached in a prominent place by the manufacturer on which the following are plainly marked: the gross volume of the transportation unit in terms of mixed concrete, the discharge speed and the mass calibrated constant of the machine in terms of volume.
3. HPVMs shall be calibrated by a Department approved testing agency in accordance with the manufacturer's recommendations at an interval of every 6 months or a maximum production of 2500 cubic yards, whichever occurs first prior to use on the project. The yield shall be maintained within a tolerance of ± 1 percent and verified using a minimum 2 cubic feet container every 500 cubic yards or a minimum once per week.
4. The three cubic feet initially discharged from the truck shall be discarded and not used for concrete placement. Acceptance of the specified class of concrete shall comply with Section 217.08 of the Specifications except that the sample secured for acceptance testing will be taken after four cubic feet is discharged from the delivery vehicle. During discharge, the consistency as determined by ASTM C143 on representative samples taken from the mixer discharge at random intervals shall not vary more than 1 inch. Acceptance tests shall be performed on each load. If test data demonstrates that consistency of concrete properties are being achieved, the Engineer may reduce testing requirements.
5. The HPVM shall be operated by a person who is a certified operator by the HPVM manufacturer. Any equipment adjustments made during the on-site production of concrete shall be done under the direct on-site supervision of the producer's VDOT Concrete Plant and Field Certified Technician.

Each load of HPVM produced concrete shall be accompanied by a Form TL-28 signed by the producer's VDOT Certified Concrete Plant Technician or a designated company representative working under the direct on-site supervision of the producer's VDOT Concrete

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Plant and Field Certified Technician. The form shall be delivered to the Inspector at the site of the work. Loads that do not carry such information or do not arrive in satisfactory condition shall not be used.

Section 217.07—Proportioning Concrete Mixtures is amended to replace the first paragraph with the following:

The Contractor is responsible for having a Certified Concrete Plant Technician available during batching operations, and a Certified Concrete Field Technician shall be present during placing operations.

Section 217.07—Proportioning Concrete Mixtures is amended to delete the third paragraph beginning with “**A Certified Concrete Batchers**”.

Section 217.08—Acceptance is replaced with the following:

- (a) **Air Consistency Tests:** Air and consistency tests will be performed by the Department prior to discharge of concrete into the forms to ensure that specification requirements are consistently being complied with for each class of concrete. The sample secured for the tests shall be taken after at least two cubic feet of concrete has been discharged from the delivery vehicle. The two cubic feet discharged is not to be used as part of the test sample. Any deviation from sampling and testing procedures must be approved by the Engineer. The Contractor shall provide a receptacle conforming to the requirements of ASTM C31, Section 5.9, for the Department's use in obtaining the sample. If either determination yields a result that is outside of the allowable range for air content or consistence, the following procedure will be used:
1. The Engineer will immediately perform a recheck determination. If the results confirm the original test results, the load will be rejected.
 2. The Contractor's representative will be immediately informed of the test results.
 3. The Contractor's representative shall notify the producer of the test results through a pre-established means of communication.

The Engineer may perform any additional tests deemed necessary and reject all remaining material that fails the tests.

Entrained air content will be determined in accordance with the requirements of ASTM C231 or ASTM C173. Acceptance or rejection will be based on the results obtained from these tests.

In general, a mixture that contains the minimum amount of water consistent with the required workability shall be used. Consistency will be determined in accordance with the requirements of ASTM C143. Adding cement to loads previously rejected for excessive water content or consistency will not be permitted.

- (b) **Strength Tests:** The 28-day compressive strengths (f'_c) specified in Table II-17 are the strengths used in the design calculations. The Engineer will verify design strengths by tests made during the progress of the work in accordance with the requirements of ASTM C31 (Standard Practice for Making and Curing Concrete Test Specimens in the Field) and ASTM C39 (Standard Test Method for Compressive Strength of Cylindrical Concrete Specimens) with the exception that the fresh concrete sample used for testing is to be secured after at least two cubic feet has been discharged from the delivery vehicle. The two cubic feet discharged is not to be used as part of the test sample. Any deviation from

sampling and testing procedures must be pre-approved by the Engineer. The use of ASTM C42 (Standard Test Method for Obtaining and Testing Drilled Cores and Sawed Beams of Concrete) will be at the Engineer's discretion. If the 28-day design compressive strength (f'_c) test results do not conform to the strength requirements specified in Table II-17, immediate steps shall be taken to adjust the mixture design. In addition, the Engineer may require removal of or corrective measures be applied to any concrete that does not meet the requirements of Table II-17. If the concrete cylinder strength, f'_{cyl} , is less than the specified compressive strength found in Table II-17, the criteria in Table II-17A shall apply:

Table II – 17A Price Reduction or Action Taken due to f'_{cyl} not meeting the specification value f'_c listed in Table II-17

Condition	Concrete is a Pay Item	Concrete is <u>Not</u> a Pay Item
f'_{cyl} is greater than or equal to 98% f'_c	A	A
f'_{cyl} is greater than or equal to 90% f'_c and less than 98% f'_c	B	C
f'_{cyl} is less than 90% f'_c	D	D
f'_{cyl} is not available due to the Contractor's inappropriate handling and storage of specimens in accordance with ASTM C31	D	D

f'_c is the 28-day design compressive strength found in Table II-17.

f'_{cyl} is the actual average tested strength of the standard-cured concrete cylinder made and tested in accordance with ASTM C31 and ASTM C39.

A = full payment

B = pay reduction = $[(f'_c - f'_{cyl})/f'_c] \times$ contract unit price for concrete per $yd^3 \times$ number of yds^3 the concrete represents] or \$500, whichever is greater.

C = pay reduction = $[(f'_c - f'_{cyl})/f'_c] \times 5 \times$ Contractor's invoice price for concrete per $yd^3 \times$ number of yds^3 the concrete represents] or \$500, whichever is greater.

D = The Contractor shall submit an investigative plan stamped by a Virginia-licensed Professional Engineer outlining how the Contractor shall demonstrate that the in-place concrete meets the structural strength requirements of the design. For barriers, parapets, railings, etc., no reduction in concrete strength below $0.9f'_c$ shall be allowed. For all other applications, the investigative plan must be approved by the Department's Engineer prior to the execution of the investigation. All costs associated with this investigation shall be borne by the Contractor. After the investigation is completed, a report shall be submitted to the Engineer showing the results of the analysis, testing and conclusions of the Virginia-licensed Professional Engineer and recommendations for action proposed by the Contractor to be

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taken with the concrete that did not meet the strength requirements. The Department retains all rights to determine if the action proposed with regard to the concrete in question is acceptable. If the Department concurs with the proposed action and the concrete meets the structural strength requirements of the design and remains in place, any price reduction will be taken by Method B if the concrete is a pay item or Method C if the concrete is not a pay item. If the concrete does not meet the structural requirements of the design, the concrete shall be removed and replaced at no cost to the Department. The maximum penalty assessed for low strength concrete left in place will be 10% as specified in Table II-17A not including the cost of the investigation and any corrective measures taken by the Contractor.

No calculated penalty less than \$500 will be assessed. The Contractor shall have the right to remove and replace concrete failing to meet specifications at the Contractor's cost.

Before concrete is placed, the Contractor shall provide a storage chamber at his expense for temporary storage of the Department's concrete cylinders. The contractor shall be responsible for maintaining the chamber such that the concrete test cylinders are kept in a continuously moist condition and within a temperature range of 60 degrees F to 80 degrees F. The chamber shall be equipped with a continuously recording thermometer accurate to ± 2 degrees F for the duration of concrete cylinder curing. The chamber shall be located in an area where the test cylinders will not be subject to vibration and shall be of sufficient size or number to store, without crowding or wedging, the required number of test cylinders as determined by the Contractor based on his plan of operations. Location of the chamber is subject to approval by the Engineer.

When use of high-early-strength hydraulic cement concrete is required, it shall conform to the requirements specified in Table II-17 except that the 28-day strength shall be obtained in 7 days. Up to 800 pounds per cubic yard of Type I, Type II or Type III cement may be used to produce high-early-strength concrete.

- (c) **Concrete Temperature** shall be measured in accordance with the requirements of ASTM C1064.
- (d) **Quality Assurance** for Low Permeability Concrete:

General:

At least two trial batches, using job materials, with permissible combination of cementitious materials shall be prepared, and test specimens shall be cast by the Contractor and tested by the Department for permeability and strength at least a month before the field application. The permeability samples shall be cylindrical specimens with a 4-inch diameter and at least 4-inches in length. Cylinders will be tested at 28 days in accordance with VTM 112. The test value shall be the result of the average values of tests on two specimens from each batch. Permeability values obtained from trial batches shall be 500 coulombs below the maximum values specified in Table II-17 of the Specifications to be acceptable.

Acceptance Tests:

For each set of cylinders made for compressive strength tests, two additional cylinders shall be made for the permeability test. The Department will be responsible for making and testing all permeability test specimens.

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If the average permeability test result is equal to or less than the value for the specified class of concrete in Table II-17, then full payment will be made for the lot the average permeability test result represents. However, if the average permeability test result exceeds the coulomb value in Table II-17, payment for that lot of concrete shall be reduced by 0.005 percent for each coulomb above the coulomb value in Table II-17 multiplied by the bid item cost of the concrete times the number of cubic yards or cubic meters of concrete in the lot. The reduction in price will not exceed 5 percent of the bid price of the concrete. Any concrete with a coulomb value that exceeds the maximum required in Table II-17 by 1000 coulomb will be rejected. However, bridge deck concrete with any coulomb value exceeding the maximum required by over 1000 coulomb may be accepted by the Engineer at 95 percent of the bid price if the concrete in question has the required strength and meets other specification requirements, and the Contractor applies, at his own expense, an approved epoxy concrete overlay to the top of the entire deck. In such case deck grooving will not be required. Epoxy overlays over latex overlays will not be permitted. The adjustment to the roadway grade shall be made as required by the Engineer at the Contractor's expense.

Similarly, concrete in abutments and pier caps with coulomb value exceeding the maximum required in Table II-17, by more than 1000 coulomb may be accepted at 95 percent of the bid price if it has the required strength and meets other specification requirements, and the Contractor applies at his own expense, one coat of Type EP-3B and one coat of EP-3T in conformance with the requirements of Section 243.02 of the Specifications, on top of the pier cap or abutment seat.

Section 217.09(b) Ready Mixed Concrete is amended to replace the second paragraph with the following:

Each load of transit or shrink-mixed concrete shall be accompanied by Form TL-28 signed by the VDOT Certified Concrete Field Technician or a designated company representative working under the direction of the VDOT Certified Concrete Field Technician. The form shall be delivered to the Inspector at the site of the work. Loads that do not carry such information or that do not arrive in satisfactory condition shall not be used.

Section 217.09(b) Ready-Mixed Concrete is amended to replace the fourth paragraph and the table with the following:

Each batch of concrete shall be delivered to the site of work and discharged within 90 minutes of the time the cement is introduced into the mixture unless approved otherwise by the Engineer.

Section 217.09(b)1. Transit mixing is amended to replace the first paragraph with the following:

1. **Transit mixing:** Concrete shall be mixed in a truck mixer. Mixing shall begin immediately after all ingredients are in the mixer and shall continue for at least 70 revolutions of the drum or blades at the rate of at least 14 but no more than 20 revolutions per minute.