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**SECTION 54 – STRUCTURAL CONCRETE (FAA P-610)****54-1 GENERAL**

The Contractor shall perform all work required by the plans requiring structural concrete for drainage structures, electrical foundations, and miscellaneous other uses, in accordance with Sections 200, 201, and 303 of the Standard Specifications, except as specified otherwise in FAA Specification Item P-610, as included and modified hereafter, and as shown on the Plans.

**ITEM P-610 STRUCTURAL PORTLAND CEMENT CONCRETE****DESCRIPTION**

**610-1.1** *This item shall consist of plain or reinforced structural portland cement concrete, prepared and constructed in accordance with these specifications, at the locations and of the form and dimensions shown on the plans.*

**MATERIALS**

**610-2.1 GENERAL.** *Only approved materials, conforming to the requirements of these specifications, shall be used in the work. They may be subjected to inspection and tests at any time during the progress of their preparation or use. The source of supply of each of the materials shall be approved by the Engineer before delivery or use is started. Representative preliminary samples of the materials shall be submitted by the Contractor, when required, for examination and test. Materials shall be scored and handled to insure the preservation of their quality and fitness for use and shall be located to facilitate prompt inspection. All equipment for handling and transporting materials and concrete must be clean before any material or concrete is placed therein.*

*In no case shall the use of pit-run or naturally mixed aggregates be permitted. Naturally mixed aggregate shall be screened and washed, and all fine and coarse aggregates shall be stored separately and kept clean. The mixing of different kinds of aggregates from different sources in one storage pile or alternating batches of different aggregates will not be permitted.*

*Aggregates shall be tested for deleterious reactivity with alkalis in the cement that may cause excessive expansion of the concrete. Acceptance of aggregates shall be based upon satisfactory evidence furnished by the Contractor that the aggregates, combined with other mixture constituents, do not produce excessive expansion in the concrete. This evidence shall include service records of concrete of comparable properties under similar conditions or exposure and certified*



records of tests by a testing laboratory that meets the requirements of ASTM C 1077. Tests shall be made in accordance with ASTM C 1260. Test specimens shall be produced using all components (e.g. coarse aggregate, fine aggregate, cement and fly ash...) to be included in the produced concrete. If the mean expansion of the test specimens, tested in accordance with ASTM C 1260, does not exceed 0.10 % at 16 days from casting the aggregates shall be accepted. If the mean expansion at 16 days is greater than 0.10% but less than 0.15%, the aggregate may be accepted based upon satisfactory service records and acceptance of the aggregate by a State Highway Department specifically addressing Alkali-Silica Reactivity. If the expansion is greater than 0.15%, the aggregate shall not be accepted for use.

**610-2.2 COARSE AGGREGATE.** The coarse aggregate for concrete shall meet the requirements of ASTM C 33. Crushed stone aggregate shall have a durability factor, as determined by ASTM C 666, greater than or equal to 95. The Engineer may consider and reserve final approval of other State classification procedures addressing aggregate durability.

Coarse aggregate shall be well graded from coarse to fine and shall meet one of the gradations shown in Table 1, using ASTM C 136.

**610-2.3 FINE AGGREGATE.** The fine aggregate for concrete shall meet the requirements of ASTM C 33.

The fine aggregate shall be well graded from fine to coarse and shall meet the requirements of Table 2 when tested in accordance with ASTM C 136:

<i>Table 1</i>							
<b>GRADATION FOR COARSE AGGREGATE</b>							
<i>Sieve Designation (square openings)</i>	<i>Percentage by Weight Passing Sieves</i>						
	<i>2"</i>	<i>1-1/2"</i>	<i>1"</i>	<i>3/4"</i>	<i>1/2"</i>	<i>3/8"</i>	<i>No. 4</i>
<i>No. 4 to 3/4 in.</i>			<i>100</i>	<i>90-100</i>		<i>20-55</i>	<i>0-10</i>
<i>No. 4 to 1 in.</i>		<i>100</i>	<i>90-100</i>		<i>25-60</i>		<i>0-10</i>
<i>No. 4 to 1-1/2 in.</i>	<i>100</i>	<i>95-100</i>		<i>35-70</i>		<i>10-30</i>	<i>0-5</i>



<i>Table 2</i> <b>GRADATION FOR FINE AGGREGATE</b>	
<i>Sieve Designation (square openings)</i>	<i>Percentage by Weight Passing Sieves</i>
<i>3/8 inch</i>	<i>100</i>
<i>No. 4</i>	<i>95-100</i>
<i>No. 16</i>	<i>45-80</i>
<i>No. 30</i>	<i>25-55</i>
<i>No. 50</i>	<i>10-30</i>
<i>No. 100</i>	<i>2-10</i>

*Blending will be permitted, if necessary, in order to meet the gradation requirements for fine aggregate. Fine aggregate deficient in the percentage of material passing the No. 50 mesh sieve may be accepted, provided that such deficiency does not exceed 5% and is remedied by the addition of pozzolanic or cementitious materials other than portland cement, as specified in 610-2.6 on admixtures, in sufficient quantity to produce the required workability as approved by the Engineer.*

**610-2.4 CEMENT.** *Cement shall conform to the requirements of ASTM C150, Type II or V.*

*The Contractor shall furnish vendors' certified test reports for each carload, or equivalent, of cement shipped to the project. The report shall be delivered to the Engineer before permission to use the cement is granted. All such test reports shall be subject to verification by testing sample materials received for use on the project.*

**610-2.5 WATER.** *The water used in concrete shall be free from sewage, oil, acid, strong alkalis, vegetable matter, and clay and loam. If the water is of questionable quality, it shall be tested in accordance with AASHTO T 26.*

**610-2.6 ADMIXTURES.** *The use of any material added to the concrete mix shall be approved by the Engineer. Before approval of any material, the Contractor shall be required to submit the results of complete physical and chemical analyses made by an acceptable testing laboratory. Subsequent tests shall be made of samples taken by the Engineer from the supply of the material being furnished or proposed for use on the work to determine whether the admixture is uniform in quality with that approved.*

*Pozzolanic admixtures shall be fly ash or raw or calcined natural pozzolons meeting the requirements of ASTM C 618.*



*Air-entraining admixtures shall meet the requirements of ASTM C 260. Air-entraining admixtures shall be added at the mixer in the amount necessary to produce the specified air content.*

*Water-reducing, set-controlling admixtures shall meet the requirements of ASTM C 494, Type A, water-reducing or Type D, water-reducing and retarding. Water-reducing admixtures shall be added at the mixer separately from air-entraining admixtures in accordance with the manufacturer's printed instructions.*

*High-range water reducers will not be allowed.*

**610-2.7 PREMOLDED JOINT MATERIAL.** *Pre-molded joint material for expansion joints shall meet the requirements of ASTM D1751 or ASTM D1752.*

**610-2.8 JOINT FILLER.** *The filler for joints shall meet the requirements of Section 42 (FAA Item P-6050, unless otherwise specified in the proposal).*

**610-2.9 STEEL REINFORCEMENT.** *Reinforcing shall conform to the following requirements, as appropriate to the details shown on the Plans.*

*Welded Deformed Steel Fabric ASTM A497  
Bar Mats ASTM A184 or A704*

**610-2.10 COVER MATERIALS FOR CURING.** *Curing materials shall conform to one of the following specifications:*

<i>Waterproof paper for curing concrete</i>	<i>ASTM C 171</i>
<i>Polyethylene Sheeting for Curing Concrete</i>	<i>ASTM C 171</i>
<i>Liquid Membrane-Forming Compounds for Curing Concrete</i>	<i>ASTM C 309, Type 2</i>

**CONSTRUCTION METHODS**

**610-3.1 GENERAL.** *The Contractor shall furnish all labor, materials, and services necessary for, and incidental to, the completion of all work as shown on the drawings and specified herein. All machinery and equipment owned or controlled by the Contractor, which he proposes to use on the work, shall be of sufficient size to meet the requirements of the work, and shall be such as to produce satisfactory work; all work shall be subject to the inspection and approval of the Engineer.*

**610-3.2 CONCRETE COMPOSITION.** *Concrete shall develop a compressive strength of 4,000 psi in 28 days for structures under full strength PCC and asphalt pavements and 3,000 psi in 28 days for all other areas, unless otherwise*



*stated in the Plans or Specifications, as determined by test cylinders made in accordance with ASTM C 31 and tested in accordance with ASTM C 39. The concrete shall contain not less than 470 pounds of cement per cubic yard. The concrete shall contain 5% of entrained air, plus or minus 1%, as determined by ASTM C 231 and shall have a slump of not more than 4 inches as determined by ASTM C 143.*

**610-3.3 ACCEPTANCE SAMPLING AND TESTING.** *Concrete for each structure will be accepted on the basis of the compressive strength specified in paragraph 3.2. The concrete shall be sampled in accordance with ASTM C 172. Compressive strength specimens shall be made in accordance with ASTM C 31 and tested in accordance with ASTM C 39.*

*Concrete cylindrical test specimens shall be made in accordance with ASTM C 31 and tested in accordance with ASTM C 39. The Contractor shall cure and store the test specimens under such conditions as directed. The Engineer will make the actual tests on the specimens at no expense to the Contractor.*

**610-3.4 PROPORTIONING AND MEASURING DEVICES.** *When package cement is used, the quantity for each batch shall be equal to one or more whole sacks of cement. The aggregates shall be measured separately by weight. If aggregates are delivered to the mixer in batch trucks, the exact amount for each mixer charge shall be contained in each batch compartment. Weighing boxes or hoppers shall be approved by the Engineer and shall provide means of regulating the flow of aggregates into the batch box so that the required and exact weight of aggregates can be readily obtained.*

**610-3.5 CONSISTENCY.** *The consistency of the concrete shall be checked by the slump test specified in ASTM C 143.*

**610-3.6 MIXING.** *Concrete may be mixed at the construction site, at a central point, or wholly or in part in truck mixers. The concrete shall be mixed and delivered in accordance with the requirements of ASTM C 94.*

**610-3.7 MIXING CONDITIONS.** *The concrete shall be mixed only in quantities required for immediate use. Concrete shall not be mixed while the air temperature is below 40°F (4°C) without permission of the Engineer. If permission is granted for mixing under such conditions, aggregates or water, or both, shall be heated and the concrete shall be placed at a temperature not less than 50°F (10°C) nor more than 100°F (38°C). The Contractor shall be held responsible for any defective work, resulting from freezing or injury in any manner during placing and curing, and shall replace such work at his/her expense.*



*Retempering of concrete by adding water or any other material shall not be permitted.*

*The delivery of concrete to the job shall be in such a manner that batches of concrete will be deposited at uninterrupted intervals.*

**610-3.8 FORMS.** *Concrete shall not be placed until all the forms and reinforcements have been inspected and approved by the Engineer. Forms shall be of suitable material and shall be of the type, size, shape, quality, and strength to build the structure as designed on the plans. The forms shall be true to line and grade and shall be mortar-tight and sufficiently rigid to prevent displacement and sagging between supports. The Contractor shall bear responsibility for their adequacy. The surfaces of forms shall be smooth and free from irregularities, dents, sags, and holes.*

*The internal ties shall be arranged so that, when the forms are removed, no metal will show in the concrete surface or discolor the surface when exposed to weathering. All forms shall be wetted with water or with a non-staining mineral oil, which shall be applied shortly before the concrete is placed. Forms shall be constructed so that they can be removed without injuring the concrete or concrete surface. The forms shall not be removed before the expiration of at least 30 hours from vertical faces, walls, slender columns, and similar structures; forms supported by falsework under slabs, beams, girders, arches, and similar construction shall not be removed until tests indicate that at least 60% of the design strength of the concrete has developed.*

**610-3.9 PLACING REINFORCEMENT.** *All reinforcement shall be accurately placed, as shown on the plans, and shall be firmly held in position during concreting. Bars shall be fastened together at intersections. The reinforcement shall be supported by approved metal chairs. Shop drawings, lists, and bending details shall be supplied by the Contractor when required.*

**610-3.10 EMBEDDED ITEMS.** *Before placing concrete, any items that are to be embedded shall be firmly and securely fastened in place as indicated. All such items shall be clean and free from coating, rust, scale, oil, or any foreign matter. The embedding of wood shall be avoided. The concrete shall be spaded and consolidated around and against embedded items.*

**610-3.11 PLACING CONCRETE.** *All concrete shall be placed during daylight, unless otherwise approved. The concrete shall not be placed until the depth and character of foundation, the adequacy of forms and falsework, and the placing of the steel reinforcing have been approved. Concrete shall be placed as soon as practical after mixing and in no case later than 1 hour after water has been added to the mix. The method and manner of placing shall be such to avoid segregation and displacement of the reinforcement. Troughs, pipes, and chutes shall be used*



*as an aid in placing concrete when necessary. Dropping the concrete a distance of more than 5 feet, or depositing a large quantity at one point, will not be permitted. Concrete shall be placed upon clean, damp surfaces, free from running water, or upon properly consolidated soil.*

*The concrete shall be compacted with suitable mechanical vibrators operating within the concrete. When necessary, vibrating shall be supplemented by hand spading with suitable tools to assure proper and adequate compaction. Vibrators shall be manipulated so as to work the concrete thoroughly around the reinforcement and embedded fixtures and into corners and angles of the forms. The vibration at any joint shall be of sufficient duration to accomplish compaction but shall not be prolonged to the point where segregation occurs. Concrete deposited under water shall be carefully placed in a compact mass in its final position by means of a tremie, a closed bottom dump bucket, or other approved method and shall not be disturbed after being deposited.*

**610-3.12 CONSTRUCTION JOINTS.** *When the placing of concrete is suspended, necessary provisions shall be made for joining future work before the placed concrete takes its initial set. For the proper bonding of old and new concrete, such provisions shall be made for grooves, steps, keys, dovetails, reinforcing bars or other devices as may be prescribed. The work shall be arranged so that a section begun on any day shall be finished during daylight of the same day. Before depositing new concrete on or against concrete that has hardened, the surface of the hardened concrete shall be cleaned by a heavy steel broom, roughened slightly, wetted, and covered with a neat coating of cement paste or grout.*

**610-3.13 EXPANSION JOINTS.** *Expansion joints shall be constructed at such points and of such dimensions as may be indicated on the drawings. The premolded filler shall be cut to the same shape as that of the surfaces being joined. The filler shall be fixed firmly against the surface of the concrete already in place in such manner that it will not be displaced when concrete is deposited against it.*

**610-3.14 DEFECTIVE WORK.** *Any defective work discovered after the forms have been removed shall be immediately removed and replaced. If any dimensions are deficient, or if the surface of the concrete is bulged, uneven, or shows honeycomb, which in the opinion of the Engineer cannot be repaired satisfactorily, the entire section shall be removed and replaced at the expense of the Contractor.*

**610-3.15 SURFACE FINISH.** *All exposed concrete surfaces shall be true, smooth, and free from open or rough spaces, depressions, or projections. The concrete in horizontal plane surfaces shall be brought flush with the finished top surface at the proper elevation and shall be struck-off with a straightedge and*



*floated. Mortar finishing shall not be permitted, nor shall dry cement or sand-cement mortar be spread over the concrete during the finishing of horizontal plane surfaces.*

*When directed, the surface finish of exposed concrete shall be a rubbed finish. If forms can be removed while the concrete is still green, the surface shall be pointed and wetted and then rubbed with a wooden float until all irregularities are removed. If the concrete has hardened before being rubbed, a carborundum stone shall be used to finish the surface. When approved, the finishing can be done with a rubbing machine.*

**610-3.16 CURING AND PROTECTION.** *All concrete shall be properly cured and protected by the Contractor. The work shall be protected from the elements, flowing water, and from defacement of any nature during the building operations. The concrete shall be cured as soon as it has sufficiently hardened by covering with an approved material. Water-absorptive coverings shall be thoroughly saturated when placed and kept saturated for a period of at least 3 days. All curing mats or blankets shall be sufficiently weighted or tied down to keep the concrete surface covered and to prevent the surface from being exposed to currents of air. Where wooden forms are used, they shall be kept wet at all times until removed to prevent the opening of joints and drying out of the concrete. Traffic shall not be allowed on concrete surfaces for 7 days after the concrete has been placed.*

**610-3.17 DRAINS OR DUCTS.** *Drainage pipes, conduits, and ducts that are to be encased in concrete shall be installed by the Contractor before the concrete is placed. The pipe shall be held rigidly so that it will not be displaced or moved during the placing of the concrete.*

**610-3.18 COLD WEATHER PROTECTION.** *When concrete is placed at temperatures below 40°F (4°C), the Contractor shall provide satisfactory methods and means to protect the mix from injury by freezing. The aggregates, or water, or both, shall be heated in order to place the concrete at temperatures between 50°F and 100°F (10°C and 38°C).*

*Calcium chloride may be incorporated in the mixing water when directed by the Engineer. Not more than 2 pounds of Type 1 nor more than 1.6 pounds of Type 2 shall be added per bag of cement. After the concrete has been placed, the Contractor shall provide sufficient protection such as cover, canvas, framework, heating apparatus, etc., to enclose and protect the structure and maintain the temperature of the mix at not less than 50°F (10°C) until at least 60% of the designed strength has been attained.*

**610-3.19 FILLING JOINTS.** *All joints that require filling shall be thoroughly cleaned, and any excess mortar or concrete shall be cut out with proper tools.*





*Joint filling shall not be started until after final curing and shall be done only when the concrete is completely dry. The cleaning and filling shall be carefully done with proper equipment and in a manner to obtain a neat looking joint free from excess filler.*

### **METHOD OF MEASUREMENT**

**610-4.1** See Section 54-2.

### **BASIS OF PAYMENT**

**610-5.1** See Section 54-3.

### **TESTING REQUIREMENTS**

<i>ASTM C 31</i>	<i>Making and Curing Test Specimens in the Field</i>
<i>ASTM C 39</i>	<i>Compressive Strength of Cylindrical Concrete Specimens</i>
<i>ASTM C 136</i>	<i>Sieve Analysis of Fine and Coarse Aggregates</i>
<i>ASTM C 138</i>	<i>Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete</i>
<i>ASTM C 143</i>	<i>Slump of Hydraulic Cement Concrete</i>
<i>ASTM C 231</i>	<i>Air Content of Freshly Mixed Concrete by the Pressure Method</i>
<i>ASTM C 666</i>	<i>Resistance of Concrete to Rapid Freezing and Thawing</i>
<i>ASTM C 1077</i>	<i>Laboratories Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Laboratory Evaluation</i>
<i>ASTM C 1260</i>	<i>Potential Alkali Reactivity of Aggregates (Mortar-Bar Method)</i>

### **MATERIAL REQUIREMENTS**

<i>ASTM A 184</i>	<i>Specification for Fabricated Deformed Steel Bar or Rod Mats for Concrete Reinforcement</i>
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<i>ASTM A 185</i>	<i>Steel Welded Wire Fabric, Plain, for Concrete Reinforcement</i>
<i>ASTM A 497</i>	<i>Steel Welded Wire Fabric, Deformed, for Concrete Reinforcement</i>
<i>ASTM A 615</i>	<i>Deformed and Plain Billet-Steel Bars for Concrete Reinforcement</i>
<i>ASTM A 704</i>	<i>Welded Steel Plain Bars or Rod Mats for Concrete Reinforcement</i>
<i>ASTM C 33</i>	<i>Concrete Aggregates</i>
<i>ASTM C 94</i>	<i>Ready-Mixed Concrete</i>
<i>ASTM C 150</i>	<i>Portland Cement</i>
<i>ASTM C 171</i>	<i>Sheet Materials for Curing Concrete</i>
<i>ASTM C 172</i>	<i>Sampling Freshly Mixed Concrete</i>
<i>ASTM C 260</i>	<i>Air-Entraining Admixtures for Concrete</i>
<i>ASTM C 309</i>	<i>Liquid Membrane-Forming Compounds for Curing Concrete</i>
<i>ASTM C 494</i>	<i>Chemical Admixtures for Concrete</i>
<i>ASTM C 595</i>	<i>Blended Hydraulic Cements</i>
<i>ASTM C 618</i>	<i>Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Concrete</i>
<i>ASTM D 1751</i>	<i>Specification for Preformed Expansion Joint Fillers for Concrete Paving and Structural Construction (Non-extruding and Resilient Bituminous Types)</i>
<i>ASTM D 1752</i>	<i>Specification for Preformed Sponge Rubber and Cork Expansion Joint Fillers for Concrete Paving and Structural Construction</i>
<i>AASHTO T 26</i>	<i>Quality of Water to be Used in Concrete</i>



**END OF ITEM P-610**

**54-2 METHOD OF MEASUREMENT**

Structural concrete will not be measured separately for payment but shall be included in the prices bid for the particular items which reference it.

**54-3 BASIS OF PAYMENT**

Structural concrete is considered incidental to other associated bid items and no separate payment will be made.

**END OF SECTION 54**



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