



*Florida Department of Transportation*

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SECRETARY

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This Memo Has Expired

MATERIALS BULLETIN NO. 15-14

DCE MEMORANDUM NO. 23-14

*(FHWA Approved: 11/10/2014)*

**TO: DISTRICT MATERIALS AND RESEARCH ENGINEERS  
DISTRICT CONSTRUCTION ENGINEERS**

**FROM:** Timothy Ruelke P.E., Director, Office of Materials  
David A. Sadler, P.E., Director, Office of Construction

**COPIES:** Rudy Powell, Tom Byron, Bob Burleson, Chad Thompson, Nick Finch, Rafiq Darji,  
Mike Bergin, Toby Dillow

**SUBJECT: BORAL MATERIALS-BOWEN PLANT, FLY ASH (FA02)**

In order to prevent concrete placement delays on ongoing construction projects due to the shortage of fly ash from the Boral-Bowen fly ash plant located in Cartersville, Georgia, concrete producers may request the Department to implement a modified mix design approval process. This memorandum will allow placement of concrete prior to receiving formal Department mix design approval, and is only applicable for replacing Boral-Bowen fly ash used in currently approved concrete mix designs assigned to current projects. The Contractor/Producer assumes all risks involved for ensuring that plastic and hardened concrete properties are in compliance with the requirements of the specifications at the time of placement.

If the modified mix approval process is used, the following requirements must be met:

1. District Materials Office personnel will ensure the replacement mix contains the same component materials and quantities as the replaced mix and only fly ash substitution is permitted. The new mix must meet the same requirements as the old mix, including yield, plastic and hardened properties. Adjustments to weights according to specific gravity of replacement fly ash chosen will be permitted as long as the replacement mix equals the original mix regarding application and environmental conditions. All materials must be from approved sources.
2. District Materials Office personnel will submit the replacement mix design to the State Materials Office similar to the material substitution procedure found in Materials Manual Section 9.2.6.8.
3. The State Materials Office will assign a new temporary design mix number with the old design mix number referenced in the mix design comments.
4. At the first job-site placement of the new mix, for each project, the concrete producer's ACI certified technician or the contractor's QC certified CTQP inspector will cast a minimum of six extra 4x8 cylinders to be tested by the concrete producer or the contractor's qualified laboratory. Three test cylinders will be tested for 7-day results, and three will be tested for

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28-day results. If the producer wants earlier than 28-day design mix approval, then additional cylinder sets of three can be fabricated at their discretion.

5. District Materials Office personnel will submit the Producer's 7-day and/or 28-day results to the State Materials Office. Whenever overdesign strength is reached, the new design mix will be fully approved as a new stand-alone permanent mix for FDOT use. **Acceptance cylinders are not to be used for design mix approval process.**

This memorandum does not waive any specification requirements but simply allows an expedient means to approve mix designs. It is in effect until **December 1, 2014**. After that date the normal mix design approval process will be in effect. It serves as a blanket approval to process this change as a no cost specification revision and shall be attached to the work order or supplemental agreement required for its processing.

Should you have any questions please contact Toby Dillow, State Materials Office at 352-955-6681 or Mike Bergin, State Materials Office 352-955-6666.

TR/td