

## **SECTION 944**

### **STRUCTURAL PLATE STEEL PIPE AND PIPE ARCH**

#### **944-1 Description.**

This Section covers the materials for corrugated galvanized steel structural plate pipe and pipe arch, including the necessary bolts and nuts for connecting plates and for assembling the pipe or pipe arch at the point of destination when so specified. The sizes of the pipe or pipe arch shall be as shown in the Plans.

#### **944-2 Materials.**

Structural plate pipe and pipe arch shall be of galvanized steel, complying with the requirements of AASHTO M167, with the additional requirement that the minimum thickness of the plates shall be as shown in the Plans.

#### **944-3 Tolerance in Span and Height.**

A tolerance of plus or minus 4% will be allowed in the specified span and height of pipe arches. A tolerance of minus 2 inches to plus 4 inches will be allowed in the specified diameter of round pipe.

#### **944-4 Bituminous Coating.**

When bituminous coating is specified, all plates shall be fully coated on both sides with asphalt cement. The bituminous coating shall conform to the requirements of AASHTO M190, for Type A.

#### **944-5 Mill Analysis and Guarantee.**

Six certified copies of Mill Analysis and Guarantee shall be furnished to the Engineer, and acceptance of the pipe will be based on such reports.

#### **944-6 Assembly Diagrams.**

Diagrams for assembling shall be furnished unless the pipe or pipe arch is furnished completely assembled.

#### **944-7 Fabrication.**

The fabrication of the pipe and pipe arch shall comply with the applicable requirements of Section 23, of the AASHTO LRFD Bridge Construction Specifications. Unless otherwise specified, the pipe and pipe arch shall be of full section for the entire length.

#### **944-8 Assembly.**

When purchase contracts stipulate that the pipe be assembled, the dealer shall furnish the pipe and pipe arch completely assembled at the point of destination, or at the site, as specified, and in lengths as specified.

#### **944-9 Direct Purchases by the Department.**

When the Department purchases the pipe or pipe arch direct from the dealer, the quantity to be paid for shall be the number of feet of pipe and of pipe arch, as ordered, provided that

sufficient materials meeting the requirements of these specifications shall be furnished to construct the pipe and pipe arch of the length and sizes shown.

The quantity shall be the net length as ordered, with no allowance for length in excess thereof.

The price per foot for direct purchases shall be full compensation for furnishing the complete materials for the pipe or pipe arch, including all bolts and nuts required for connecting the plates. When assembling of the pipe or pipe arch is specified, such price shall also include all labor, equipment, tools and incidentals required for completely assembling the pipe or pipe arch.