

EXPECTED IMPLEMENTATION JULY 2021

STRUCTURAL PORTLAND CEMENT CONCRETE (REV 3-8-21)

SUBARTICLE 346-3.4.1 is deleted and the following substituted:

346-3.4 Durability for Concrete Construction:

346-3.4.1 Minimum Cementitious Materials Content: Ensure that the produced concrete meets the minimum amount of cementitious materials content in Table 346-4.

Table 346-4 Minimum Amount of Total Cementitious Materials Content (pounds per cubic yard of concrete)			
Concrete Class	Environmental Classification		
	Extremely Aggressive	Moderately Aggressive	Slightly Aggressive
I, I (Pavement), II, and III (Seal)	470		
II (Bridge Deck), III, IV, IV (Drilled Shaft), V, V(Special), VI and VII	600	550	510

SUBARTICLE 346-6.4 is deleted and the following substituted:

346-6.4 Plastic Property Tolerances: Reject concrete with slump or air content that does not fall within the specified tolerances, except as noted below, and immediately notify the concrete production facility that an adjustment of the concrete mixture is required. If a load does not fall within the tolerances, test each subsequent load and the first adjusted load. If failing concrete is not rejected or adjustments are not implemented, the Engineer may reject the concrete and terminate further production until the corrections are implemented.

At the Contractor's risk, water may be added at the placement site immediately after completion of the initial slump test, either to correct a low slump or to increase the concrete workability, provided the addition of water does not exceed the water to cementitious materials ratio as defined by the mix design.

After adding water, perform an additional slump test to confirm the concrete is within the slump tolerance range. If the slump is outside the tolerance range, reject the load. If an adjustment is made at the concrete production facility, perform a slump test on the next load to ensure the concrete is within the slump tolerance range. Do not place concrete represented by slump test results outside of the tolerance range. Include water missing from the water storage tanks upon arrival at the project site in the jobsite water added.

Do not allow concrete to remain in a transporting vehicle to reduce slump.

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SUBARTICLE 346-7.2 is deleted and the following substituted:

346-7.2 Transit Truck Mixing: Produce a completely uniform mixed concrete in a truck mixer for 70 to 100 revolutions at the mixing speed designated by the truck manufacturer.

Prior to starting the discharge of the concrete at the jobsite, when water is added, record the added quantity, and mix the concrete 30 additional drum mixing revolutions. Do not make more than two mix adjustments. Seek approval from the Engineer prior to using a central mixer and depositing the batch into a truck mixer.

346-7.2.1 Transit Time: Ensure compliance with Table 346-8 between the initial introduction of water into the mix and completely discharging all the concrete from the truck. Reject concrete exceeding the maximum transit time. The Engineer may approve an extension of the transit time which will be identified on the approved mix design.

Table 346-8	
Maximum Allowable Transit Time	
Non-Agitator Trucks	Agitator Trucks
45 minutes	60 minutes
75 minutes ⁽¹⁾	90 minutes ⁽¹⁾

Note:
(1) When a water-reducing and retarding admixture (Type D, Type G, or Type II) is used.

346-7.2.2 Placement Time: All the concrete in a load must be in its final placement position a maximum of 15 minutes after the transit time has expired unless a time extension is approved by the Engineer.

For Class IV (Drilled Shaft) mixes, placement time may be extended provided the slump loss time of the first concrete placed is not exceeded throughout the elapsed time.

The Engineer may perform Independent Verification (IV) testing to verify the plastic and hardened properties of the concrete when a time extension is granted.

SUBARTICLE 346-7.6 is deleted and the following substituted:

346-7.6 Sample Location: Obtain acceptance samples from the point of final placement.

Where concrete buckets are used to discharge concrete directly to the point of final placement or into the hopper of a tremie pipe, samples will be obtained from the discharge of the bucket. When the concrete is discharged directly from the mixer into the bucket and the bucket is discharged within 20 minutes, samples may be obtained from the discharge of the mixer.

Where conveyor belts, troughs, pumps, or chutes are used to transport concrete directly to the point of final placement or into the hopper of a tremie pipe,

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samples will be obtained from the discharge end of the entire conveyor belt, trough, pump, or chute system.

Where concrete is placed in a drilled shaft or other element using a tremie pipe and a concrete pump, samples will be obtained from the discharge of the pump line at the location of the tremie hopper.

For all other placement methods, prior to each placement, obtain Department approval for sampling at the discharge of the mixer in lieu of sampling at the point of final placement. Submit the sampling correlation procedure to the Engineer for approval prior to the placement of the concrete. Once the comparative sampling correlation is approved by the Engineer, apply this correlation to the plastic properties tolerances for samples obtained from the discharge of mixer.

Where a concrete pump is used to deposit concrete directly into a drilled shaft which is a wet excavation without the use of a tremie, or other applications as approved by the Engineer, ensure the discharge end of the pump line remains immersed in the concrete at all times after starting concrete placement.

SUBARTICLE 346-7-7 is deleted.

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