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M E M O R A N D U M

DATE: November 18, 2021

TO: Specification Review Distribution List

FROM: Daniel Strickland, P.E., State Specifications Engineer

SUBJECT: Proposed Specification: **4000200 Concrete Structures.**

In accordance with Specification Development Procedures, we are sending you a copy of a proposed specification change.

The changes are proposed by Melissa Hollis from the Product Evaluation Office and Jose Armenteros from the State Materials Office. Melissa Hollis's changes were to update APL references for filter fabric and to be consistent with other Division II references. These changes were reflected on Article 400-13, subarticle 400-15.2.6, 400-16.6, and 400-22.2.2. Jose Armenteros's changes were made to eliminates Class I concrete from the list of concrete classifications. Jose Armenteros's changes were reflected in Article 400-16 and Subarticle 400-23.9. The proposed changes are associated with Section 346.

Please share this proposal with others within your responsibility. Review comments are due within four weeks and should be sent to Mail Station 75 or online at http://fdotewp1.dot.state.fl.us/programmanagement/development/industryreview.aspx . Comments received after **December 16, 2021,** may not be considered. Your input is encouraged.

DS/ra

Attachment

CONCRETE STRUCTURES
(REV 11-8-21)

ARTICLE 400-2 is deleted and the following substituted:

400-2 Materials.

Meet the following requirements:

Concrete ..... Sections 346 and 347
Penetrant Sealer .....Section 413
High Molecular Weight Methacrylate (HMWM)**
..... Section 413
Reinforcing for Concrete .....Section 415
Water.....Section 923
Curing Materials*,** .....Section 925
Epoxy Bonding Compounds** ..... Section~~s~~ 926~~ and 937~~
Post Installed Anchor Systems**.....Section 937
Joint Materials**.....Section 932
Bearing Pads .....Section 932
Non-Shrink Grout** .....Section 934
Class 5 Applied Finish Coatings**.....Section 975
Galvanizing Compound** .....Section 562
Dowel Bar Assembly** .....Section 931
Filter Fabric**.....Section 985
*The Engineer will allow clean sand and sawdust for certain curing, when and as specified.
**Use products listed on the Department's Approved Product List (APL).

ARTICLE-13 is deleted and the following substituted:

400-13 Epoxy Bonding Compounds.

Where epoxy bonding compounds for bonding concrete are specified or required, apply the epoxy bonding materials only to clean, dry, structurally sound concrete surfaces. Provide surface preparation, application, and curing of epoxy bonding compound in strict accordance with the manufacturer's recommendations for each particular application. ~~Use an epoxy bonding compound listed on the Department's APL.~~

SUBARTICLE 400-15.2.6.1 is deleted and the following substituted:

400-15.2.6 Class 5 Applied Finish Coating:

400-15.2.6.1 General: Place an applied finish coating upon all concrete surfaces where the Plans indicate Class 5 applied finish coating. Apply the finish coating after completion of the general surface work specified for all exposed concrete surfaces. ~~Select an applied finish coating from the APL meeting the requirements of Section 975.~~

ARTICLE 400-16 is deleted and the following substituted:

400-16 Curing Concrete.

400-16.1 Internal curing: At the Contractor's option use internal curing in combination with one or more of the external curing methods listed in 400-16.1.2. Use lightweight fine aggregates from Department-approved sources meeting the requirements of ASTM C1761.

400-16.2 External curing: Cure cast-in-place and precast (non-prestressed) concrete as required herein for a minimum duration of 72 hours. If forms are loosened or removed before the 72 hour curing period is complete, expand the curing to cover these surfaces by either coating with curing compound or extending the continuous moist cure area.

Until curing has begun, retain concrete surface moisture at all times by maintaining a surface moisture evaporation rate less than 0.1 pound per square foot per hour. Periodically, at the site of concrete placement prior to and during the operation, measure the ambient air temperature, relative humidity and wind velocity with industrial grade weather monitoring instruments to determine the on-site evaporation rate. If the evaporation is, or is likely to become 0.1 pound per square foot per hour or greater, employ measures to prevent moisture loss such as application of evaporation retarder, application of supplemental moisture by fogging or reduction of the concrete temperature during batching. Compute the evaporation rate by using the nomograph in the ACI manual of Concrete Practice Part 2, Section 308R Guide to Curing Concrete, or by using an evaporation rate calculator approved by the Engineer.

400-16.2.1 Methods: Except where other curing methods are specified, select from the following options the chosen method(s) for curing all concrete components.

1. Continuous Moisture: Place burlap on the surface and keep it continuously saturated for the curing period by means of soaker hoses or automatic sprinklers. Water flow may be metered to cycle repetitively for five minutes on and five minutes off during the 72 hour curing period. Do not apply moisture manually. If side forms are loosened or removed during the curing period, extend the burlap so as to completely shield the sides of the members.

2. Membrane Curing Compound: Apply a white Type 2 curing compound to all surfaces at a uniform coverage as recommended by the manufacturer but not less than 0.06 gallon per square yard. Allow surfaces covered by the membrane curing compound to remain undisturbed for the curing period. Recoat any cracks, checks or other defects in the membrane seal which are detected during the curing period within one hour. If side forms are loosened during the curing period, maintain surface moisture and remove the forms within one hour and immediately coat the formed surfaces with a membrane curing compound. Bottom surfaces shall be similarly coated after removal of or from the forms.

If curing compound is to be applied by spraying, use a compressor driven sprayer of sufficient size to provide uniform mist. Standby equipment is required in case of mechanical failure and hand held pump-up sprayers may be used only as standby equipment.

3. Curing Blankets: Curing blankets may be used for curing the top surfaces of members while the member side forms remain in place. Do not use curing blankets which have been torn or punctured. Securely fasten all edges to provide as tight a seal as practical. Should the system fail to maintain a moist condition on the concrete surface, discontinue use of the blankets and continue curing using another method. Keep curing blankets in place for the duration of the curing period.

4. Accelerated Cure:

_____a. General: Accelerated curing of the concrete can be achieved by use of either low pressure steam curing, radiant heat curing or continuous moisture and heat curing. If accelerated curing is completed before the 72 hour curing period has elapsed, continue curing for the remaining part of the 72 hour curing period in accordance with one of the curing methods listed above.

_____If accelerated curing is used, furnish temperature recording devices that will provide accurate, continuous and permanent records of the time and temperature relationship throughout the entire curing period. Provide one such recording thermometer for each 200 feet of placement length or part thereof. Initially calibrate recording thermometers and recalibrate at least annually.

_____The preheating period shall equal or exceed the time of initial set as determined by ASTM C403 and shall not be less than 4 hours. When the ambient air temperature is above 50ºF, allow the member to remain undisturbed in the ambient air for the preheating period. If the ambient air temperature is below 50ºF, apply heat during the preheating period to hold the air surrounding the member at a temperature of 50 to 90ºF.

_____To prevent moisture loss from exposed surfaces during the preheating period, enclose members as soon as possible after casting or keep the surfaces wet by fog mist or wet blankets. Use enclosures for heat curing that allow free circulation of heat about the member with a minimum moisture loss. The use of tarpaulins or similar flexible covers may be used provided they are kept in good repair and secured in such a manner to prevent the loss of heat and moisture. Use enclosures that cover the entire placement.

_____During the application or removal of the heat, do not allow the temperature rise or fall within the enclosure to exceed 40ºF per hour. Do not allow the curing temperature throughout the enclosure to exceed 160ºF. Maintain the curing temperature within a temperature range of 130 to 160ºF until the concrete has reached the required form removal strength for precast and cast-in-place components or the required release strength for prestressed concrete components.

_____b. Low-Pressure Steam: The steam used shall be in a saturated condition. Do not allow steam jets to impinge directly on the concrete, test cylinders, or forms. Cover control cylinders to prevent moisture loss and place them in a location where the temperature is representative of the average temperature of the enclosure.

_____c. Curing with Radiant Heat: Apply radiant heat by means of pipes circulating steam, hot oil or hot water, or by electric heating elements. Do not allow the heating elements to come in direct contact with the concrete or the forms. Distribute sources of heat in a manner that will prevent localized high temperatures above 160ºF. To prevent moisture loss during curing, keep the exposed surfaces wet by fog mist or wet blankets.

_____d. Continuous Moisture and Heat: This method consists of heating the enclosure in combination with the continuous moisture method described above.

_____In addition to the curing blankets, an auxiliary cover for retention of the heat will be required over the entire placement. Support this cover at a sufficient distance above the placement being cured to allow circulation of the heat.

400-16.3 Silica Fume Concrete: Cure silica fume concrete a minimum of 72 hours using continuous moisture cure. No substitution of alternative methods nor reduction in the time period is allowed. After completion of the 72 hour curing period, apply a membrane curing compound to all concrete surfaces. Apply curing compound according to 400-16.2.

400-16.4 Bridge Decks and Approach Slabs: Cure bridge decks and approach slabs for a duration of seven days. Apply a membrane curing compound to the top surface in accordance with 400-16.2 using a compressor driven sprayer. In general, apply curing compound when the surface is damp and after all pooled water has evaporated. For Short bridges, begin applying curing compound immediately after the initially placed concrete has been floated, straightedged, textured and a damp surface condition exists and continue applying compound as concrete placement progresses with as little interruption as possible until the entire top surface has been coated with compound. For Long bridges, begin applying curing compound to the initially placed concrete as soon as a damp surface condition exists and continue applying compound as concrete placement progresses with as little interruption as possible until the entire top surface has been coated with compound. For all bridges, the elapsed time between the initial placement of deck or approach slab concrete and the completed application of curing compound must not exceed 120 minutes. The 120 minute limit may be extended by the Engineer if project specific factors (cool temperatures, high humidity, retarding admixtures, etc.) prolong wet surface conditions.

Prior to the first deck or approach slab placement, submit to the Engineer the method that will be used to periodically measure the rate of application of curing compound in, gallons per square foot as the concrete placement progresses. Prior to the placement of each deck or approach slab, submit to the Engineer the anticipated quantity of curing compound in gallons along with the corresponding square feet of concrete to be covered to meet the coverage rate in 400-16.2. Compute the actual quantity of curing compound applied at the conclusion of each concrete placement and submit the quantity to the Engineer. Apply the curing compound from a work platform.

Place curing blankets on all exposed surfaces which are not formed as soon as possible with minimal effect on the surface texture. Place the curing blankets with sufficient overlapping seams to form an effective moisture seal. Before using curing blankets, mend tears, splits, or other damage that would make them unsuitable. Discard curing blankets that are not repairable. Wet all curing blankets immediately after satisfactorily placing them and maintain them in a saturated condition throughout the seven-day curing period. Supply sufficient quantity of water meeting the requirements of Section 923 at the job site for wetting the blankets.

Where a bridge deck or approach slab is to be subjected to walking, wheeling or other approved construction traffic within the seven-day curing period, protect the curing blankets and the concrete surface from damage by placing wooden sheeting, plywood or other approved protective material in the travel areas.

When the ends of the curing blankets are rolled back to permit screeding of adjacent concrete, keep the exposed surfaces wet throughout the period of exposure.

Bridge deck bottom and side forms may be removed after 72 hours upon compliance with 400-14. Approach slab side forms may be removed after 72 hours. Apply membrane curing compound to all surfaces stripped of forms within one hour of loosening. Apply curing compound according to 400-16.2.

400-16.5 Construction Joints: Cure construction joint areas using either the continuous moisture or curing blankets method.

400-16.6 Concrete Barriers, Traffic Railings, Parapets and End Post: Ensure concrete is cured in accordance with 400-16.2(2), except that a clear Type 1-D curing compound that must contain a fugitive dye may be used in lieu of Type 2. If Type 1-D is used, its removal per 400-15.1 during finishing is not required. When construction is by the slip form method, coat

all concrete surfaces with a curing compound that meets the requirements of 925-2, either within 30 minutes of extrusion or before the loss of water sheen, whichever occurs first. Ensure a curing compound coating period of not less than seven days after application. Prior to each concrete placement, submit to the Engineer the method that will be used to periodically measure the rate of application in gallons per square foot. Also, prior to each placement, submit to the Engineer the anticipated quantity of curing compound in gallons that will be used to meet the coverage rate specified in 400-16.2 along with the corresponding square footage of concrete barriers, traffic railings, parapets and end posts to be coated with that quantity. Measure the actual quantity of curing compound that is applied during each concrete placement and submit the quantity to the Engineer. Applied finish coatings ~~, that are on the APL and~~ that are flagged as permitted for use as a curing compound, may be used in lieu of a curing compound. If an applied finish coating is used in lieu of a curing compound, have a backup system that is in full compliance with 400-16.2(2) available at all times to ensure that an effective alternative system will be immediately available if the applied finish coating cannot be applied within 30 minutes of extrusion or before the loss of water sheen.

400-16.7 Removal of Membrane Curing Compounds: Provide the longest possible curing duration; however, remove curing compound on portions of members to be bonded to other concrete. Compounds may be removed by either sand or water blasting. Water blasting requires the use of water meeting the requirements of Section 923 and a minimum nozzle pressure of 2,900 psi.

SUBARTICLE 400-22.2.2 is deleted and the following substituted:

400-22.2.2 Pay Quantity: The quantity to be paid for will be the original plan quantity, measured as provided in 400-22.2.1.~~, except that where the Plans call for an estimated quantity of miscellaneous concrete for contingent use, the contingent concrete will be measured as the actual quantity in place and accepted.~~

SUBARTICLE 400-23.9 is deleted and the following substituted:

400-23.9 Payment Items:

Payment will be made under:

Item No. 400- 0-	Class NS Concrete – per cubic yard.
~~Item No. 400- 1-~~	~~Class I Concrete - per cubic yard.~~
Item No. 400- 2-	Class II Concrete - per cubic yard.
Item No. 400- 3-	Class III Concrete - per cubic yard.
Item No. 400- 4-	Class IV Concrete - per cubic yard.
Item No. 400- 6-	Precast Anchor Beams - each.
Item No. 400- 7-	Bridge Deck Grooving - per square yard.
Item No. 400- 8-	Class V Concrete - per cubic yard.
Item No. 400- 9-	Bridge Deck Planing - per square yard.
Item No. 400- 16-	Class VI Concrete - per cubic yard.
Item No. 400-143-	Cleaning and Coating Concrete Surfaces - per square foot.
Item No. 400-147-	Composite Neoprene Pads - per cubic foot.
Item No. 400-148-	Plain Neoprene Bearing Pads - per cubic foot.