



Florida Department of Transportation

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Tallahassee, FL 32399-0450

KEVIN J. THIBAUT, P.E.
SECRETARY

December 13, 2021

Khoa Nguyen
Director, Office of Technical Services
Federal Highway Administration
3500 Financial Plaza, Suite 400
Tallahassee, Florida 32312

Re: State Specifications Office
Section: **931**
Proposed Specification: **9310203 Metal Accessory Materials for Concrete Pavement
and Concrete Structures.**

Dear Mr. Nguyen:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

The changes are proposed by Tim McCullough to move materials requirements to a table and add quality and emission requirements when paint is applied in the field.

Please review and transmit your comments, if any, within two weeks. Comments should be sent via email to daniel.strickland@dot.state.fl.us.

If you have any questions relating to this specification change, please call me at 850-414-4130.

Sincerely,

Signature on file

Daniel Strickland, P.E.
State Specifications Engineer

DS/dh

Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

METAL ACCESSORY MATERIALS FOR CONCRETE PAVEMENT AND CONCRETE STRUCTURES.

(REV ~~10-612-8-21~~)

SUBARTICLE 931-2.3 is deleted and the following substituted:

931-2.3 Dowel Bars: Dowel bars must meet the requirements of Table 931-1. ~~shall be plain steel bars conforming to the requirements of ASTM A615 for any grade of steel shown.~~ They shall be of the length, size and spacing as shown in the Plans. ~~When coated dowel bars are specified, coat with epoxy meeting the requirements of ASTM A775 by a producer with Epoxy Coating Certification from the Concrete Reinforcing Steel Institute, or one coat of zinc rich primer meeting the requirements of SSPC Paint 20.~~

The Contractor shall submit to the Engineer a certified test report from the manufacturer of the dowel bars confirming that the requirements of this Section are met. The certified test report shall conform to the requirements of Section 6 and include metallurgical mill analysis, grade, length and size. Each certification shall cover only one LOT for dowel bars.

SUBARTICLE 931-3.1 is deleted and the following substituted:

931-3 Metal Dowel Bar Assemblies for Joints in Concrete Pavement.

931-3.1 Approved Product List (APL): The dowel bars and basket assembly ~~used~~ must meet the requirements of Table 931-1 and shall be a product included on the Department's APL.

Manufacturers seeking evaluation of their product shall submit an application in accordance with Section 6 and shall submit product photo and drawings, technical data sheets, and certifications that ~~or distributors seeking approval of their material in accordance with this specification shall~~ demonstrate the performance of their products in accordance with the requirements in 931-3.~~2-1~~ thru 931-3.~~65~~.

<u>Table 931-1 Material Requirement for Dowel Bar and Basket Assemblies</u>		
<u>Component</u>	<u>Base Metal</u>	<u>Coating</u>
<u>Dowel Bar</u>	<u>ASTM A615</u>	<u>ASTM A775 or SSPC Paint 20</u>
<u>Wire Basket Assembly</u>	<u>ASTM A1064</u>	<u>ASTM A775 or SSPC Paint 20 or Primer with \geq 40% Solids (by weight)</u>

Produce dowel bars coated in the shop. Wire basket assemblies may be coated in the shop or the field. For welded wire basket assemblies fabricated after coating, apply touch-up coating in the shop or field over all welded connections. All field applied coatings must have a volatile organic compound (VOC) content \leq 420g/L.

SUBARTICLE 931-3.6 is deleted.

~~931-3.6 Materials: The wire for the welded assembly shall be in accordance with all applicable requirements of ASTM A1064.~~

~~After fabrication of dowel bar assemblies, apply coating in accordance with the requirements of 931-2.3.~~

METAL ACCESSORY MATERIALS FOR CONCRETE PAVEMENT AND CONCRETE STRUCTURES.

(REV 12-8-21)

SUBARTICLE 931-2.3 is deleted and the following substituted:

931-2.3 Dowel Bars: Dowel bars must meet the requirements of Table 931-1. They shall be of the length, size and spacing as shown in the Plans.

The Contractor shall submit to the Engineer a certified test report from the manufacturer of the dowel bars confirming that the requirements of this Section are met. The certified test report shall conform to the requirements of Section 6 and include metallurgical mill analysis, grade, length and size. Each certification shall cover only one LOT for dowel bars.

SUBARTICLE 931-3.1 is deleted and the following substituted:

931-3 Metal Dowel Bar Assemblies for Joints in Concrete Pavement.

931-3.1 Approved Product List (APL): The dowel bars and basket assembly must meet the requirements of Table 931-1 and shall be a product included on the Department's APL.

Manufacturers seeking evaluation of their product shall submit an application in accordance with Section 6 and shall submit product photo and drawings, technical data sheets, and certifications that demonstrate the performance of their products in accordance with the requirements in 931-3.1 thru 931-3.5.

Table 931-1 Material Requirement for Dowel Bar and Basket Assemblies		
Component	Base Metal	Coating
Dowel Bar	ASTM A615	ASTM A775 or SSPC Paint 20
Wire Basket Assembly	ASTM A1064	ASTM A775 or SSPC Paint 20 or Primer with $\geq 40\%$ Solids (by weight)

Produce dowel bars coated in the shop. Wire basket assemblies may be coated in the shop or the field. For welded wire basket assemblies fabricated after coating, apply touch-up coating in the shop or field over all welded connections. All field applied coatings must have a volatile organic compound (VOC) content $\leq 420\text{g/L}$.

SUBARTICLE 931-3.6 is deleted.