346 PORTLAND CEMENT CONCRETE.
(REV 12-22-08) (FA 1-8-09) (7-09)

SECTION 346 (Pages 303-326) is deleted and the following substituted:

SECTION 346
PORTLAND CEMENT CONCRETE

346-1 Description.

Use concrete composed of a mixture of portland cement, aggregate, water, and, where specified, admixtures, pozzolan and ground granulated blast furnace slag. Deliver the portland cement concrete to the site of placement in a freshly mixed, unhardened state.

Obtain concrete from a plant that is currently on the list of Producers with Accepted Quality Control Programs. Producers seeking inclusion on the list shall meet the requirements of 105-3. If the concrete production facility’s Quality Control Plan is suspended, the Contractor is solely responsible to obtain the services of another concrete production facility with an accepted Quality Control Plan or await the re-acceptance of the affected concrete production facility’s Quality Control Plan prior to the placement of any further concrete on the project. There will be no changes in the contract time or completion dates. Bear all delay costs and other costs associated with the concrete production facility’s Quality Control Plan acceptance or re-acceptance.

346-2 Materials.

346-2.1 General: Meet the following requirements:

Coarse Aggregate..Section 901
Fine Aggregate*...Section 902
Portland Cement..Section 921
Water...Section 923
Admixtures..Section 924
Pozzolans and Slag ....Section 929

*Use only silica sand except as provided in 902-5.2.3.

Do not use materials containing hard lumps, crusts or frozen matter, or that is contaminated with dissimilar material.

346-2.2 Types of Cement: Unless a specific type of cement is designated elsewhere, use Type I, Type IP, Type IS, Type II, or Type III cement in all classes of concrete.

Use only the types of cements designated for each environmental condition in structural concrete. A mix design for a more aggressive environment may be substituted for a lower aggressive environmental condition.

TABLE 1			
BRIDGE SUPERSTRUCTURES			
Component	Slightly Aggressive Environment	Moderately Aggressive Environment	Extremely Aggressive Environment
Precast Superstructure and Prestressed	Type I or Type III	Type I or Type III with Fly Ash and/or Slag,	Type II with Fly Ash or Slag

TABLE 1			
BRIDGE SUPERSTRUCTURES			
Component	Slightly Aggressive Environment	Moderately Aggressive Environment	Extremely Aggressive Environment
Elements		Type II, Type IP, or Type IS	
Cast In Place	Type I	Type I with Fly Ash and/or Slag, Type II, Type IP, or Type IS	Type II with Fly Ash or Slag
BRIDGE SUBSTRUCTURE, DRAINAGE STRUCTURES AND OTHER STRUCTURES			
Component	Slightly Aggressive Environment	Moderately Aggressive Environment	Extremely Aggressive Environment
All Elements	Type I or Type III	Type I with Fly Ash and/or Slag, Type II, Type IP, or Type IS	Type II with Fly Ash or Slag

346-2.3 Pozzolans and Slag: Use as desired, on an equal weight replacement basis, fly ash, silica fume, ultrafine fly ash, metakaolin, or slag materials as a cement replacement in all classes of concrete, with the following limitations:

(1) Mass Concrete:

a. Fly Ash - Ensure that the quantity of cement replaced with fly ash is 18% to 50% by weight, except where the core temperature is expected to rise above 165° F. In that case, ensure that the percentage of fly ash is 35% to 50% by weight.

b. Slag - Ensure that the quantity of cement replaced with slag is 50% to 70% by weight. Ensure that slag is 50% to 55% of total cementitious content by weight when used in combination with silica fume, ultrafine fly ash and/or metakaolin.

c. Slightly and Moderately Aggressive Environments - Ensure that there is at least 20% fly ash by weight and 40% portland cement by weight for mixes containing portland cement, fly ash and slag.

(2) Drilled Shaft:

a. Fly Ash - Ensure that the quantity of cement replaced with fly ash is 33% to 37% by weight.

b. Slag - Ensure that the quantity of cement replaced with slag is 58% to 62% by weight.

(3) Precast Concrete – Ensure that the precast concrete has a maximum of 25% fly ash or a maximum of 70% slag. In Extremely Aggressive Environments, ensure that the precast concrete has a minimum of 18% fly ash or a minimum of 50% slag.

(4) For all other concrete uses not covered in (1), (2) and (3) above,

a. Fly Ash - Ensure that the quantity of cement replaced with fly ash is 18% to 22% by weight.

b. Slag - Ensure that the quantity of cement replaced with slag is 25% to 70% for Slightly and Moderately Aggressive Environments and 50% to 70% by weight when used in Extremely Aggressive Environments. Ensure that slag is 50% to 55% of total cementitious content by weight when used in combination with silica fume, ultra fine fly ash and/or metakaolin.

c. As an option for Slightly and Moderately Aggressive Environments ensure that there is at least 20% fly ash by weight and 40% portland cement by weight for mixes containing portland cement, fly ash and slag.

d. Class I and Class II concrete, excluding Class II (Bridge Deck), are not required to meet the minimum fly ash or slag requirements. The fly ash content shall be less than or equal to 25% by weight of cement and the slag content shall be less than or equal to 70% by weight of cement.

(5) Type IS **-** Ensure that the quantity of slag in Type IS is less than or equal to 70% by weight.

(6) Silica Fume, Metakaolin and Ultrafine Fly Ash:

a. Silica Fume **-** Ensure that the quantity of cementitious material replaced with silica fume is 7% to 9% by weight.

b. Metakaolin **-** Ensure that the quantity of cementitious material replaced with metakaolin is 8% to 12% by weight.

c. Ultrafine Fly Ash - Ensure that the quantity of cementitious material replaced with ultrafine fly ash is 8% to 12% by weight.

d. Cure in accordance with the manufacturer's recommendation and as approved by the Engineer.

346-2.4 Coarse Aggregate Gradation: Produce all concrete using Size No. 57, 67 or 78 coarse aggregate. With the Engineer's approval, Size No. 8 or Size No. 89 may be used either alone or blended with Size No. 57, 67 or 78 coarse aggregate. The Engineer will consider requests for approval of other gradations individually. Submit sufficient statistical data to establish production quality and uniformity of the subject aggregates, and establish the quality and uniformity of the resultant concrete. Furnish aggregate gradations sized larger than nominal maximum size of 1.5 inch as two components.

For Class I and Class II, excluding Class II (Bridge Deck), the coarse and fine aggregate gradation requirements set forth in Sections 901 and 902 are not applicable and the aggregates may be blended; however, the aggregate sources must be approved by the Department. Do not blend the aggregate if the size is smaller than Size No. 78.

346-2.5 Admixtures: Use admixtures in accordance with the requirements of this subarticle. Chemical admixtures not covered in this subarticle may be approved by the Department. Submit statistical evidence supporting successful laboratory and field trial mixes which demonstrate improved concrete quality or handling characteristics.

Use admixtures in accordance with the manufacturer's recommended dosage rate. Do not use admixtures or additives containing calcium chloride (either in the raw materials or introduced during the manufacturing process) in reinforced concrete.

346-2.5.1 Water-Reducer/Water-Reducer Retardant Admixtures: When a water-reducing admixture is used, meet the requirements of a Type A. When a water-reducing and retarding admixture is used, meet the requirements of a Type D.

346-2.5.2 Air Entrainment Admixtures: Use an air entraining admixture in all concrete mixes except counterweight concrete. For precast concrete products, the use of air entraining admixture is optional for Class I and Class II concrete.

346-2.5.3 High Range Water-Reducing Admixtures:

346-2.5.3.1 General: When a high range water-reducing admixture is used, meet the requirements of a Type F or Type I. When a high range water-reducing and retarding admixture is used, meet the requirements of a Type G or Type II. Do not use Type I, II, F or G admixtures in drilled shaft concrete. When silica fume or metakaolin is incorporated into a concrete mix design, the use of a high range water-reducing admixture Type I, II, F or G is mandatory.

346-2.5.3.2 Flowing Concrete Admixtures for Precast/Prestressed Concrete: Use a Type I, II, F or G admixture for producing flowing concrete. If Type F or G admixture is used, verify the distribution of aggregates in accordance with ASTM C 1610 except allow for minimal vibration for consolidating the concrete. The maximum allowable difference between the static segregation is less than or equal to 15 percent. Add the flowing concrete admixtures at the concrete production facility.

346-2.5.4 Corrosion Inhibitor Admixture: Use only with concrete containing Type II cement, Class F fly ash or slag, and a water-reducing retardant admixture, Type D, or High Range Water-Reducer retarder admixture, Type G, to normalize the setting time of concrete. Ensure that all admixtures are compatible with the corrosion inhibitor admixture.

346-2.5.5 Accelerating Admixture for Precast Concrete: The use of non-chloride admixtures Type C and Type E is allowed in the manufacturing of precast concrete products that are used in Slightly Aggressive Environments.

346-3 Classification, Strength, Slump and Air Content.

346-3.1 General: The separate classifications of concrete covered by this Section are designated as Class I, Class II, Class III, Class IV, Class V and Class VI. Strength, slump, and air content of each class are specified in Table 2.

Substitution of a higher class concrete in lieu of a lower class concrete may be allowed, if approved by the Engineer. When the compressive strength acceptance data is less than the minimum compressive strength of the higher design mix, notify the Engineer. Acceptance is based on the requirements in Table 2 for the lower class concrete.

TABLE 2

Class of Concrete	Specified Minimum Strength (28-day) (psi)	Target Slump (inches) (c)	Air Content Range (%)
STRUCTURAL CONCRETE			
I (a)	3,000	3 (b)	1.0 to 6.0
I (Pavement)	3,000	2	1.0 to 6.0
II (a)	3,400	3 (b)	1.0 to 6.0
II (Bridge Deck)	4,500	3 (b)	1.0 to 6.0
III (e)	5,000	3 (b)	1.0 to 6.0
III (Seal)	3,000	8	1.0 to 6.0
IV	5,500	3 (b) (d)	1.0 to 6.0
IV (Drilled Shaft)	4,000	8.5	0.0 to 6.0
V (Special)	6,000	3 (b) (d)	1.0 to 5.0
V	6,500	3 (b) (d)	1.0 to 5.0
VI	8,500	3 (b) (d)	1.0 to 5.0

(a) For precast drainage systems that are manufactured at the precast plant, apply the chloride content limits specified in 346-4.2 to all box culverts. For precast box culverts and precast drainage structures, the target air content will not apply and maximum slump shall be 6 inches. The Contractor is permitted to use concrete meeting the requirements of ASTM C 478 4,000 psi in lieu of Class I or Class II concrete for precast drainage systems.

(b) The Engineer may allow higher target slump, not to exceed 7 inches, when a Type F, G, I or II admixture is used.

(c) The Engineer may approve a reduction in the target slump for slip-form operations.

(d) When the use of silica fume, ultrafine fly ash, or metakaolin is required as a pozzolan in Class IV, Class V, Class V (Special) or Class VI concrete, ensure that the concrete exceeds a resistivity of 29 KOhm-cm at 28 days, when tested in accordance with FM 5-578. Submit three 4 x 8 inch cylindrical test specimens to the Engineer for resistivity testing before mix design approval. Take the resistivity test specimens from the concrete of the laboratory trial batch or from the field trial batch of at least 3 yd^3. Verify the mix proportioning of the design mix and take representative samples of trial batch concrete for the required plastic and hardened property tests. Cure the field trial batch specimens similar to the standard laboratory curing methods. Submit the resistivity test specimens at least 7 days prior to the scheduled 28 day test. The average resistivity of the three cylinders, eight readings per cylinder, is an indicator of the permeability of the concrete mix.

(e) When precast box culverts or precast drainage products require a Class III concrete, the minimum cementitious materials will be 470 lb/yd^3. The air content range and target slump will not apply.

346-3.2 Drilled Shaft Concrete: When drilled shaft concrete is placed in any wet shaft, provide concrete in accordance with the following specified slump loss requirements.

Test each load of concrete for slump to ensure the concrete is within the limits of Table 6. Ensure that the slump loss is gradual as evidenced by slump loss tests described below. The concrete elapsed time is the sum of the mixing and transit time, the placement time, the time required for removal of any temporary casing that causes or could cause the concrete to flow into the space previously occupied by the temporary casing and bolt/embedment installation.

346-3.2.1 Slump Loss Test Requirements: Provide slump loss tests before drilled shaft concrete operations begin, demonstrating that the drilled shaft concrete maintains a slump of at least 5 inches throughout the concrete elapsed time. Inform the Engineer at least 48 hours before performing such tests. Perform slump loss testing of the drilled shaft mix using personnel meeting the requirements of Section 105.

Perform the following procedures for slump loss tests:

(1) Begin all elapsed times when water is initially introduced into the mixer.

(2) The slump loss test is performed at a temperature consistent with the highest ambient and concrete temperatures expected during actual concrete placement.

(3) Ensure that the mix is at least 3 cubic yards and is mixed in a truck mixer.

(4) After initial mixing, determine the slump, ambient and concrete temperatures, and air content. Ensure that the concrete properties are within the required specification target range.

(5) Verify the water to cementitious materials ratio and that other delivery ticket data meet design mix requirements.

(6) Mix the concrete intermittently for 30 seconds every 5 minutes at the manufacture recommended mixing speed. Agitate the mixer when concrete is not being mixed).

(7) Determine slump, ambient and concrete temperatures at 30 minute intervals until the slump is 5 inches or less. Remix the mix for one minute at the mixing speed of the mixer before these tests are run.

(8) Ensure that the concrete maintains a slump of at least 5 inches for the anticipated elapsed time.

(9) Cast cylinders to determine when 500 psi compressive strength is obtained for the purpose of transporting field samples to the laboratory.

(10) Obtain the Engineer’s approval of slump loss test results in terms of elapsed time before concrete placements.

346-3.3 Mass Concrete: When mass concrete is designated in the Contract Documents, provide an analysis of the anticipated thermal developments in the mass concrete elements for all expected project temperature ranges using the selected mix design, casting procedures, and materials.

Use a Specialty Engineer competent in the design and temperature control of concrete in mass elements. The Specialty Engineer shall follow the procedure outlined in Section 207 of the ACI Manual of Concrete Practice to formulate, implement, administer and monitor a temperature control plan, making adjustments as necessary to ensure compliance with the Contract Documents. The Specialty Engineer shall select the concrete design mix proportions that will generate the lowest maximum temperatures possible to ensure that a 35°F differential temperature between the concrete core and the exterior surface is not exceeded. The mass concrete maximum allowable temperature is 180°F. If either the differential temperature or the maximum allowable temperature is exceeded, the Specialty Engineer shall be available for immediate consultation.

Describe the measures and procedures intended for use to maintain a temperature differential of 35°F or less between the interior core center and exterior surface(s) of the designated mass concrete elements during curing. Submit both the mass concrete mix design and the proposed mass concrete plan to monitor and control the temperature differential to the Engineer for acceptance. Provide temperature monitoring devices to record temperature development between the interior core center and exterior surface(s) of the elements in accordance with the accepted mass concrete plan.

The Specialty Engineer, or a qualified technician employed by the Specialty Engineer, must personally inspect and approve the installation of monitoring devices and verify that the process for recording temperature readings is effective for the first placement of each size and type mass component. Submit to the Engineer for approval the qualification of all technicians employed to inspect or monitor mass concrete placements. For placements other than the first, designate an employee(s) approved by the Specialty Engineer, as qualified to inspect monitoring device installation, to record temperature readings, to be in contact at all times with the Specialty Engineer if adjustments must be made as a result of the temperature differential or the maximum allowable temperature being exceeded, and to immediately implement adjustments to temperature control measures as directed by the Specialty Engineer. Read the monitoring devices and record the readings at intervals no greater than 6 hours. The readings will begin when the mass concrete placement is complete and continue until the maximum temperature differential and the temperature is reached and a decreasing temperature differential is confirmed as defined in the temperature control plan. Do not remove the temperature control mechanisms until the core temperature is within 35°F of the ambient temperature. Furnish a copy of all temperature readings to the Engineer as they are recorded, the determined temperature differentials and a final report within three days of completion of monitoring of each element.

If the 35°F differential or the 180°F maximum allowable temperature has been exceeded, take immediate action as directed by the Specialty Engineer to retard further growth of the temperature differential. Describe methods of preventing thermal shock in the temperature control plan. Use a Specialty Engineer to revise the previously accepted plan to ensure compliance on future placements. Do not place any mass concrete until the Engineer has accepted the mass concrete plan(s). When mass concrete temperature differentials or maximum allowable temperature has been exceeded, provide all analyses and test results deemed necessary by the Engineer for determining the structural integrity and durability of the mass concrete element, to the satisfaction of the Engineer. The Department will make no compensation, either monetary or time, for the analyses or tests or any impacts upon the project.

346-3.4 Flowing Concrete for Precast/Prestressed Concrete: Produce flowing concrete mix with target slump of 9 inches.

Subsequent to the laboratory trial batch, perform a field demonstration of the proposed mix design by production and placement of at least three batches, 3 yd^3 minimum size each, of concrete containing flowing concrete HRWR admixture. Take representative samples from each batch and perform slump, air content, density (unit weight), and temperature tests on these samples. Cast specimens from each sample for compressive strength tests. Record the ambient air temperature during the test. Ensure that the concrete properties are within the required specification limits. The plants that are producing concrete with batch sizes of less than 3 yd^3 are required to produce and place at least a total amount of 9 yd^3 and perform the aforementioned tests on at least three randomly selected batches.

Determine the workability of the demonstration concrete batches by performing the slump tests on the samples taken at 15 minute intervals from each batch. Continue sampling and testing until the slump measures 6 inches or less. From the plot of slump versus time, determine the time for each batch when the slump is at 7.5 inches. The shortest time period determined from three consecutive batches, at 7.5 inches slump, is considered the cutoff time of the proposed concrete mix. For production concrete, ensure that the time between the batching and depositing of each load of concrete is less than the cutoff time of the mix and also does not exceed the allowable time limit specified in this Section.

Ensure that the demonstration concrete is mixed, delivered, placed, consolidated and cured in accordance with the proposed method and sequence. Produce the flowing concrete batches at slumps between 7.5 inches to 10.5 inches.

Perform inspection of the demonstration concrete during batching, delivery, placement and post placement. During placement, ensure that the concrete batches meet all plastic property requirements of the specifications and maintain their cohesive nature without excessive bleeding, segregation, or abnormal retardation.

Dispose of concrete produced for demonstration purposes at no expense to the Department. Subject to the Engineer’s approval, the Contractor may incorporate this concrete into non-reinforced concrete items and may be included for payment, provided it meets Contract requirements for slump, entrained air, and strength.

After removal of the forms, perform the post-placement inspection of the in-place concrete. Observe for any signs of honeycombs, cracks, aggregate segregation or any other surface defects and ensure that the hardened concrete is free from these deficiencies. The Engineer may require saw cutting of the mock-up products to verify the uniform distribution of the aggregates within the saw cut surfaces and around the reinforcing steel and prestressing strands. The Engineer will require saw cutting of the demonstration mock-up products for plants that are demonstrating the use of the flowing concrete for the first time. Obtain core samples from different locations of mock-up products to inspect the aggregate distribution in each sample and compare it with the aggregate distribution of other core samples. Perform surface resistivity tests on the core samples or test cylinders at 28 days.

Submit the results of the laboratory trial batch tests and field demonstration of verified test data and inspection reports to the Engineer, along with certification stating that the results of the laboratory trial batch tests and field demonstration tests indicate that the proposed concrete mix design meets the requirements of the specifications. For the proposed mix design, state the anticipated maximum time limit between the batching and when the concrete of each batch is deposited during the production.

Upon the review and verification of the laboratory trial batch, field demonstration test data, inspection reports and contractor's certification statement, the Department will approve the proposed mix design.

The Department may approve proposed flowing concrete mixes, centrally mixed at the placement site, without the production of demonstration batches, provided that the proposed mix meets the following two criteria:

(1) A previously approved flowing concrete mix of the same class has demonstrated satisfactory performance under the proposed job placing conditions with a minimum of fifteen consecutive Department acceptance tests, which met all plastic and hardened concrete test requirements.

(2) The cementitious materials and chemical admixtures, including the flowing concrete HRWR admixture, used in the proposed mix are the same materials from the same source used in the previously approved mix, (1) above.

Do not produce or place concrete until the design mixes have been approved.

346-4 Composition of Concrete.

346-4.1 Master Proportion Table: Proportion the materials used to produce the various classes of concrete in accordance with Table 3:

TABLE 3		
Class of Concrete	Minimum Total Cementitious Materials Content lb/yd^3	*Maximum Water to Cementitious Materials Ratio lb/lb
I	470	0.53
I (Pavement)	470	0.50
II	470	0.53
II (Bridge Deck)	611	0.44
III	611	0.44
III (Seal)	611	0.53

TABLE 3		
Class of Concrete	Minimum Total Cementitious Materials Content lb/yd^3	*Maximum Water to Cementitious Materials Ratio lb/lb
IV	658	0.41**
IV (Drilled Shaft)	658	0.41
V (Special)	752	0.37**
V	752	0.37**
VI	752	0.37**
*The calculation of the water to cementitious materials ratio (w/cm) is based on the total cementitious material including cement and any supplemental cementitious materials that are used in the mix. **When the use of silica fume or metakaolin is required, the maximum water to cementitious material ratio will be 0.35. When the use of ultrafine fly ash is required, the maximum water to cementitious material ratio will be 0.30.		

346-4.2 Chloride Content Limits for Concrete Construction:

346-4.2.1 General: Use the following maximum chloride content limits for the concrete application and/or exposure environment shown:

TABLE 4		
Application/Exposure Environment		Maximum Allowable Chloride Content, lb/yd^3
Non Reinforced Concrete		No Test Needed
Reinforced Concrete	Slightly Aggressive Environment	0.70
	Moderately or Extremely Aggressive Environment	0.40
Prestressed Concrete		0.40

Ensure that the chloride content of all produced reinforced concrete does not exceed the maximum allowable limits specified in Table 4. When the source of any component material, including admixtures, for the concrete is changed, sampling for chloride determination shall restart the first day of production of the mix with the new component material.

Ensure the chloride test results from the testing lab are submitted to the concrete production facility within fourteen calendar days.

346-4.2.2 Certification: Certify for each mix design from the first day of production and every 30 calendar days or less thereafter to the Department that all concrete produced for the Department meets the requirements of this Section. Include in the certification all pertinent chloride test data. The Department will require properly executed certifications showing the chloride content within the required limits for acceptance of all concrete produced. Include all the chloride certificates that apply with the monthly certification of compliance as required in Section 105.

346-4.2.3 Control Level for Corrective Action:

If chloride test results exceed the limits of Table 4, suspend concrete delivery immediately for every mix design represented by the failing test results, until corrective measures are made. Reject all concrete placed from the last passing chloride test to the present, or perform an engineering analysis to demonstrate that the material meets the intended service life of the structure. In the event that an engineering analysis is proposed, supply this information within 30 business days of the failing test results from a Professional Engineer registered in the State of Florida and knowledgeable in the areas of corrosion and corrosion control. A written request for time to develop the engineering analysis may be provided to the Engineer; however, the Engineer has the sole option to accept or reject this request.

346-5 Sampling and Testing Methods.

Perform concrete sampling and testing in accordance with the following methods:

TABLE 5	
Description	Method
Slump of Hydraulic Cement Concrete	ASTM C 143
Air Content of Freshly Mixed Concrete by the Pressure Method*	ASTM C 231
Air Content of Freshly Mixed Concrete by the Volumetric Method*	ASTM C 173
Making and Curing Test Specimens in the Field	ASTM C 31
Compressive Strength of Cylindrical Concrete Specimens**	ASTM C 39
Obtaining and Testing Drilled Core and Sawed Beams of Concrete	ASTM C 42
Early Sampling of Fresh Concrete from Revolving Drum Truck Mixers or Agitators	FM 5-501
Low Levels of Chloride in Concrete and Raw Materials	FM 5-516
Density (Unit Weight), Yield and Air Content (Gravimetric) of Concrete	ASTM C 138
Temperature of Freshly Mixed Portland Cement Concrete	ASTM C 1064
Sampling Freshly Mixed Concrete	ASTM C 172
Static Segregation of Self Consolidating Concrete using Column Techniques	ASTM C 1610
Slump Flow of Self Consolidating Concrete	ASTM C 1611
Passing Ability of Self Consolidating Concrete by J-Ring	ASTM C 1621
Concrete Resistivity as an Electrical Indicator of its Permeability	FM 5-578
*Use the same type of meter for QC tests as the Department uses for Verification testing. When using pressure type meters, use an aggregate correction factor determined by the concrete producer for each mix design to be tested. Record and certify test results for correction factors for each type of aggregate at the concrete production facility. **Use 4 x 8 or 6 x 12 inch cylinders for determination of the compressive strength.	

346-6 Control of Quality.

346-6.1 General: Develop a Quality Control Plan (QCP) as specified in Section 105. Meet the requirements of the approved QCP and Contract Documents. Ensure the QCP includes the necessary requirements to control the quality of the concrete.

Perform QC activities to ensure materials, methods, techniques, personnel, procedures and processes utilized during production meet the specified requirements. For precast/prestressed operations, ensure that the QC testing is performed by the producer.

Accept the responsibility for QC inspections on all phases of work. Ensure all materials and workmanship incorporated into the project meet the requirements of the Contract Documents.

When concrete plastic properties (slump, air content and temperature) could be significantly affected by handling between the point of delivery and the point of final placement, including the use of pumps, conveyor belts, troughs, chutes, barge transport or other means, include provisions in the QCP to sample the plastic concrete for all testing at the point of final placement.

Ensure the QCP includes any anticipated requirements for adjusting the concrete at the placement site. Include the testing procedures that will be implemented to control the quality of the concrete and ensure that concrete placed is within the target range. Also, include provisions for the addition of water to concrete delivered to the placement site at designated level areas, to ensure the allowable amount of water stated on the concrete delivery ticket or the maximum water to cementitious materials ratio on the approved design mix are not exceeded. Ensure the anticipated ranges of jobsite water additions are described and the proposed methods of measuring water for concrete adjustments are included.

Failure to meet the requirements of this Specification or the QCP will automatically void the concrete portion of the QCP. To obtain QCP re-approval, implement corrective actions as approved by the Engineer. The Engineer may allow the Contractor to continue any ongoing concrete placement but the Engineer will not accept concrete for any new placement until the QCP re-approval is given by the Engineer.

346-6.2 Concrete Design Mix: Provide concrete that has been produced in accordance with a Department approved design mix, in a uniform mass free from balls and lumps. Discharge the concrete in a manner satisfactory to the Engineer. Perform demonstration batches to ensure complete and thorough placements in complex elements, when requested by the Engineer.

Do not place concretes of different compositions such that the plastic concretes may combine, except where the plans require concrete both with and without silica fume, ultrafine fly ash, metakaolin or calcium nitrite in a continuous placement. Produce these concretes using separate design mixes. For example, designate the mix with calcium nitrite as the original mix and the mix without calcium nitrite as the redesigned mix. Ensure that both mixes contain the same cement, fly ash or slag, coarse and fine aggregates and compatible admixtures. Submit both mixes for approval as separate mix designs, both meeting all requirements of this Section. Ensure that the redesigned mix exhibits plastic and hardened qualities which are additionally approved by the Engineer as suitable for placement with the original mix. The Engineer will approve the redesigned mix for commingling with the original mix and for a specific project application only. Alternately, place a construction joint at the location of the change in concretes.

346-6.3 Delivery Certification: Ensure that an electronic delivery ticket is furnished with each batch of concrete before unloading at the placement site. The delivery ticket may be proprietary software or in the form of an electronic spreadsheet, but shall be printed. Ensure that the materials and quantities incorporated into the batch of concrete are printed on the delivery ticket. Include the following information on the Delivery Ticket:

(1) Arrival time at jobsite,

(2) Time that concrete mix has been completely discharged,
(3) Number of revolutions upon arrival at the jobsite,
(4) Total gallons of water added at the jobsite,
(5) Additional mixing revolutions when water is added,
(6) Total number of revolutions at mixing and agitating speed.

Items 3 through 6 do not apply to non-agitating concrete transporting vehicles.

Ensure the batcher responsible for production of the batch of concrete signs the delivery ticket, certifying the batch of concrete was produced in accordance with the Contract Documents.

Sign the delivery ticket certifying that the design mix maximum specified water to cementitious materials ratio was not exceeded due to any jobsite adjustments to the batch of concrete, and that the batch of concrete was delivered and placed in accordance with the Contract Documents.

346-6.4 Tolerances: Meet the following tolerances from target values for plastic concrete properties specified in 346-3.1:

TABLE 6		
Property	Target Range	Tolerance
Slump (Non-Drilled Shaft Concrete without HRWR)	± 0.75 inch	± 1.5 inch
Slump (Non-Drilled Shaft Concrete with HRWR)	± 1.0 inch	± 1.5 inch
Slump (Drilled Shaft Concrete)	± 1.0 inch	± 1.5 inch
Air Content	As shown in the range in Table 2	

Reject concrete with slump or air content exceeding the above tolerances. Do not allow concrete to remain in a transporting vehicle to reduce slump. Water may be added only upon arrival of the concrete to the jobsite and not thereafter.

If the slump varies from the target range as described in Table 6, immediately adjust the concrete mixture to correct the slump of succeeding batches. The Engineer will allow a reasonable time for adjustment. Test each load to ensure only concrete meeting the specification is placed. The Engineer will take into consideration trucks already in route from the concrete production facility after the facility has been notified. If the Contractor does not implement adjustments at the earliest possible time, the Engineer may reject the concrete and terminate further production until the Contractor makes corrections.

346-7 Mixing and Delivering Concrete.

346-7.1 General Requirements: Operate all concrete mixers at speeds and volumes per the manufacturer’s design or recommendation as stipulated on the mixer rating plate.

346-7.2 Transit Mixing: When water is added at the jobsite, mix the concrete 30 additional drum mixing revolutions. When the total number of drum mixing revolutions exceeds 160, do not make additional mix adjustments. Discharge all concrete from truck mixers before total drum revolutions exceed 300. Seek approval from the Engineer prior to using a central mixer and depositing the batch into a truck mixer.

346-7.3 Mixing at the Site: Use a mixer of sufficient capacity to prevent delays that may be detrimental to the quality of the work. Ensure that the accuracy of batching equipment is in accordance with requirements of this Section.

346-7.4 Concreting in Cold Weather: Do not mix concrete when the air temperature is below 45ºF and falling. The Contractor may mix and place concrete when the air temperature in the shade, and away from artificial heat, is 40ºF and rising. Protect the fresh concrete from freezing until the concrete reaches a minimum compressive strength of 1,500 psi unless the concrete is to be heat cured. The requirements of concreting in cold weather are not applicable to precast concrete placement operations occurring in a temperature controlled environment.

346-7.5 Concreting in Hot Weather: Hot weather concreting is defined as the production, placing and curing of concrete when the concrete temperature at placing exceeds 85ºF but is less than 100ºF.

Unless the specified hot weather concreting measures are in effect, reject concrete exceeding 85ºF at the time of placement. Regardless of special measures taken, reject concrete exceeding 100ºF. Predict the concrete temperatures at placement time and implement hot weather measures to avoid production shutdown.

346-7.6 Transit Time: Ensure compliance with the following maximum allowable time between the initial introduction of water into the mix and depositing the concrete in place:

TABLE 7	
Non-Agitator Trucks	Agitator Trucks
45 minutes	60 minutes
75 minutes*	90 minutes*
*When a water-reducing and retarding admixture (Type D, Type G or Type II) is used.	

346-7.7 Adding Water to Concrete at the Placement Site: Perform an initial slump before the addition of water at the jobsite. If the slump is delivered within the target range, no water will be added to the load. If the slump is outside the target range but is within the tolerance range, that load may be adjusted. After adjusting the slump, perform a test to confirm that the slump of the concrete is within the target range as defined in Table 6. Confirm with another test that the next load is within the target range. Maintain the slump within the target range on successive loads. Repeated incidents of concrete being placed outside the target range may result in revocation of that portion of the QCP. Do not place concrete represented by slump test results outside of the tolerance range.

346-7.8 Sample Location: Describe concrete placement and sampling methods in the QCP. Obtain 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, within 25% of the total allowable transit time before discharge of the bucket, 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, 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.

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, and the following sampling correlation procedure is followed:

a. Develop a comparative sampling correlation between the discharge of the mixer and the end of the pump line for slump and air results. Obtain five samples from the discharge of the pump line using the full length of pump line and five samples from the discharge of the mixer. Average the five samples from each sample location and compare the two averages to establish the comparative sampling correlation. Ensure the plastic properties of the concrete sampled from the pump line are within the target range.

b. Once the comparative sampling correlation is established, and approved by the Engineer, apply this correlation to the plastic properties tolerances for samples obtained from the discharge of mixer.

c. Obtain all other samples from the discharge of the mixer delivering concrete to the pump. Ensure the plastic properties of the concrete being delivered to the pump compare with the comparative sampling correlation.

d. If the ambient temperature changes by more than 15 °F, or the configuration of the pumping system changes, the Engineer may require a new comparative sampling correlation.

346-8 Plastic Concrete Sampling and Testing.

QC tests include air content, temperature, slump, and preparing compressive strength cylinders for testing at later dates. In addition, calculate the water to cementitious materials ratio in accordance with FM 5-501 for compliance to the approved mix design.

Ensure that each truck has a valid mixer identification card issued by the Department, the revolution counter on the mixer is working properly, and calibration of the water dispenser has been performed within the last twelve months and verify batch weights within required limits of the mix design. Reject any concrete batches that are delivered in trucks that do not have mixer identification cards. The Contractor may remove the mixer identification cards when a truck mixer is discovered to be in noncompliance. When the mixer identification card is removed for noncompliance, forward the card to the District Materials Engineer in the District where the plant is located.

Perform plastic concrete tests on the initial delivery of each concrete design mix each day. Ensure QC technicians meeting the requirements of Section 105 are present and performing tests throughout the placement operation. Ensure one technician is present and performing tests throughout the placement operation at each placement site. If a placement site has multiple concrete trucks, identify the number of technicians in the Quality Control Plan. If a placement site has multiple trucks placing concrete, then have at least two technicians present at that site. Ensure that the equipment used for delivery, placement and finishing meets the requirements of this Specification. Do not proceed with the placement operation until QC tests confirm that the delivered concrete complies with the plastic properties specified. When a truck designated for QC testing arrives at the site of discharge, subsequent trucks may not discharge until QC testing results are known. Reject non-complying loads at the jobsite. Ensure that corrections are made on subsequent loads.

Furnish sufficient concrete of each design mix as required by the Engineer for verification testing. When the Engineer's verification test results do not compare with the QC plastic properties test results, within the limits defined by the Independent Assurance (IA) checklist comparison criteria, located in Materials Manual Chapter 5, disposition of the concrete will be at the option of the Contractor.

If any of the QC plastic properties tests fail, reject the remainder of that load, terminate the LOT and notify the Engineer. Make cylinders representing that LOT from the same sample of concrete.

Following termination of a LOT, obtain samples from a new load, and perform plastic properties tests until such time as the water to cementitious materials ratio, air content, temperature and slump comply with the Specification requirements. Initiate a new LOT once the testing indicates compliance with Specification requirements.

Suspend production when three consecutive LOTs, or when any five LOTs in two days of production of the same design mix are outside the specified tolerances. Make the necessary revisions to concrete operations and increase the frequency of QC testing in the QCP to bring the concrete within allowable tolerances. Obtain the Engineer's approval of the revisions before resuming production. After production resumes, obtain the Engineer's approval before returning to the normal frequency of QC testing.

If concrete placement stops for more than 90 minutes, perform initial plastic properties testing on the next batch and continue the LOT. Cylinders cast for that LOT will represent the entire LOT.

The Department may perform Independent Verification testing to verify compliance with specification requirements.

When the Department performs Independent Verification, the Contractor may perform the same tests on the concrete at the same time. The Department will compare results based on the Independent Assurance Checklist tolerances.

When the Department's Independent Verification test results do not meet the requirements of this Section, the Engineer may require the Contractor to revise the QCP.

346-9 Acceptance Sampling and Testing.

346-9.1 General: Perform plastic properties tests in accordance with 346-8 and cast a set of three QC cylinders (either 4 inch by 8 inch or 6 inch by 12 inch cylinders are acceptable), for all structural concrete incorporated into the project. Take these acceptance samples randomly as determined by a random number generator (acceptable to the Department). The Department will independently perform verification plastic properties tests and cast a set of verification cylinders. The verification cylinders will be the same size cylinder selected by the Contractor, from a separate sample from the same load of concrete as the Contractor's QC sample.

The Department may perform inspections in lieu of plastic properties tests of the precast plants producing Class I and II concrete.

For each set of QC cylinders verified by the Department, cast one additional cylinder from the same sample, and identify it as the QC "hold" cylinder. The Department will also cast one additional "hold" cylinder from each Verification sample. Provide curing facilities that have the capacity to store all QC, Verification, "hold" and Independent Verification cylinders simultaneously for the initial curing. All cylinders will be clearly identified. Deliver the QC samples, including the QC "hold" cylinder to the final curing facility in accordance with

ASTM C 31. At this same time, the Department will deliver the Verification samples, including the Verification "hold" cylinder, to their final curing facility.

Test the QC laboratory cured samples for compressive strength at the age of 28 days, or any other specified age, in a laboratory meeting and maintaining at all times the qualification requirements listed in Section 105.

The QC testing laboratory will input the compressive strength test results into the Department's sample tracking database within 24 hours. When the QC testing laboratory cannot input the compressive strength test results into the Department's sample tracking database within 24 hours, the QC testing laboratory will notify the Verification testing laboratory within 24 hours of testing the cylinder and provide the Verification testing laboratory the compressive strength test results. Ensure the compressive strength results are input into the Department's sample tracking database within 72 hours of determining the compressive strength of the cylinders.

The Department will average the QC compressive strength test data, average the Verification compressive strength test data, and compare the averages. In the event that one set of compressive strength data for a set of cylinders falls outside the range of the other set of cylinders, use the lower Range of Average Compressive Strength to determine the comparison criteria. Based on this comparison, the Department will determine if the Comparison Criteria as shown in Table 8 has been met. When the difference between QC and Verification are less than or equal to the Comparison Criteria, the QC data is verified. When the difference between QC and Verification data exceeds the Comparison Criteria, the Engineer will initiate the resolution procedure.

Table 8	
Range of Average Compressive Strength	Comparison Criteria
Less than 3500 psi	420 psi
3,501 – 4,500 psi	590 psi
4,501 – 6,500 psi	910 psi
6,501 – 8,500 psi	1,275 psi
Greater than 8,500 psi	1,360 psi

346-9.2 Sampling Frequency for Quality Control Tests:

As a minimum, sample and test concrete of each design mix for water to cementitious materials ratio, air content, temperature, slump and compressive strength once per LOT as defined by Table 9. When more than one concrete production facility is used for the same mix design, describe the method of sampling, testing and LOT numbering in the QC Plan. The Engineer will randomly verify one of every four consecutive LOTs of each design mix based on a random number generator, and may perform additional Independent Verification tests. All QC activities, calculations, and inspections will be randomly confirmed by the Department.

TABLE 9	
Class Concrete	Maximum LOT Size
I	one day's production

TABLE 9	
Class Concrete	Maximum LOT Size
I (Pavement)	250 lane ft, or one day’s production, whichever is less
II (Bridge Deck), III, IV, V (Special), V, VI	50 yd^3, or one day’s production, whichever is less
IV (Drilled Shaft)	50 yd^3, or two hours between placements, whichever is less
III (Seal)	Each Seal placement

346-9.2.1 Reduced Frequency for Acceptance Tests: When ten consecutive strength test results from the same mix design for a Class IV or higher class of concrete are produced at the same concrete production facility, on a given Contract have all been verified and have attained an average strength greater than two standard deviations above the specified minimum, then the LOT may represent a maximum production quantity of 100 yd^3. When five consecutive strength test results from the same mix design for a Class III or lower class of concrete is produced at the same concrete production facility on a given Contract have all been verified and have attained an average strength greater than two standard deviations above the specified minimum, the LOT may represent a maximum production quantity of 100 yd^3.

The average of the consecutive compressive strength test results, based on the class of concrete, can be established using historical data from the previous project. The data must also represent the same prime/subcontractor. The last tests from the previous job must be within the last 60 calendar days or may also be established by a succession of samples on the current project. Only one sample can be taken from each LOT. Test data must be from a laboratory meeting the requirements of Section 105.

If at any time a strength test is not verified and/or the average strength of the previous ten or five consecutive samples based on the class of concrete described above, from the same mix design and the same production facility is less than the specified minimum plus two standard deviations, the maximum production quantity represented by the LOT will return to 50 yd^3. In order to reinitiate reduced frequency, a new set of strength test results will be required.

346-9.3 Strength Test Definition: The strength test of a LOT is defined as the average of the compressive strengths tests of three cylinders cast from the same sample of concrete from the LOT.

346-9.4 Acceptance of Hardened Concrete: Hardened concrete will be accepted or rejected on the basis of strength test results as defined in 346-9.3. Do not discard a cylinder strength test result based on low strength (strength below the specified minimum strength as per the provisions of 346-3 and 346-9). When QC strength test results are verified, the Engineer will accept the concrete based on QC test results. The Engineer will accept at full pay only LOTs of concrete represented by strength test results which equal or exceed the respective specified minimum strength.

When one of the three QC cylinders from a LOT is lost, damaged or destroyed, determination of compressive strength will be made by averaging the remaining two cylinders. If more than one QC cylinder from a LOT is lost, damaged or destroyed, the Contractor will core the structure at no additional expense to the Department to determine the compressive strength.

Acceptance of LOT may be based on verification data at the discretion of the Engineer. Obtain the approval of the Engineer to core, and of the core location prior to coring.

For each QC cylinder that is lost, damaged or destroyed, payment for that LOT will be reduced by $750.00 per 1,000 psi of the specified design strength [Example: loss of two Class IV (Drill Shaft) QC cylinders that has no verification data will require the element to be cored and a penalty will be assessed (4,000 psi / 1,000 psi) x $750 x 2 = $6,000. This reduction will be in addition to any pay adjustment for low strength.

When QC compressive strength test results are not verified, the resolution procedure will be used to accept or reject the concrete. Maintain the "hold" cylinders until the verification of the compressive strength test results.

346-9.5 Resolution Procedure: The Department may initiate an IA review of sampling and testing methods. The resolution procedure may consist of, but need not be limited to, a review of sampling and testing of fresh concrete, calculation of water to cementitious materials ratio, handling of cylinders, curing procedures and compressive strength testing. Core samples of the hardened concrete may be required.

The Engineer will determine through the resolution procedure whether the QC strength test results or the verification strength test results can be relied upon. When the Engineer cannot determine that either the QC or verification strength test results are in error, the concrete represented by the four consecutive LOTs will be evaluated based on the QC data. The Engineer will inform the QC and the Verification lab within four working days of the acceptance compressive strength test to transport their "hold" cylinders to the resolution lab. The QC and Verification laboratories will transport their own hold cylinder to the resolution testing laboratory within 72 hours after the Engineer notifies the Contractor that a resolution is required. In addition, the Engineer will ensure that the QC and verification "hold" cylinders are tested within seven days of the acceptance strength tests.

The resolution investigation will determine the strength test results for each of the four or less LOTs. When the QC strength test results are deemed to be the most accurate, the QC strength test results will represent the four or less consecutive LOTs and the Department will pay for the resolution testing and investigation. When the verification strength test results are deemed to be the most accurate, the Department will assess a 5 percent reduction of payment for the quantity represented by the Resolution Investigation.

The results of the resolution procedure will be forwarded to the Contractor within five days after completion of the investigation. If the Department finds deficiencies based on the Contractor's QCP, the Engineer may suspend that part of the QCP. When the QC plan is suspended, submit corrective actions for approval to the Engineer. The Engineer may take up to five working days to review corrective actions to the QCP. The Engineer will not allow changes to contract time or completion dates. Incur all delay costs and other costs associated with QC plan suspension and re-approval.

346-9.6 Small Quantities of Concrete: When a project has a total plan quantity of less than 50 yd^3, that concrete will be accepted based on the satisfactory compressive strength of the QC cylinders. Provide certification to the Engineer that the concrete was batched and placed in accordance with the Contract Documents. Submit a quality control plan for the concrete placement operation in accordance with Section 105. In addition, the Engineer may conduct Independent Verification (IV) testing as identified in 346-9. Evaluate the concrete in accordance with 346-10 at the discretion of the Engineer. On concrete placements consisting of only one load of concrete, perform initial sampling and testing in accordance with this Section. The acceptance sample and plastic properties tests may be taken from the initial portion of the load.

346-10 Investigation of Low Strength Concrete for Structural Adequacy.

346-10.1 General: When a concrete acceptance strength test result falls more than 10% or 500 psi below the specified minimum strength, whichever is the greater deviation from the specified minimum strength, and the Department determines that an investigation is necessary, make an investigation into the structural adequacy of the LOT of concrete represented by that acceptance strength test result at no additional expense to the Department. The Engineer may also require the Contractor to perform additional strength testing as necessary to determine structural adequacy of the concrete.

Furnish either a structural analysis performed by the Specialty Engineer to establish strength adequacy or drilled core samples as specified in 346-10.3 to determine the in-place strength of the LOT of concrete in question at no additional expense to the Department. Obtain the Engineer's approval before taking any core samples. When the concrete is deemed to have low strength, obtain and test the cores and report the data to the Engineer within 14 days of the 28 day compressive strength tests. Core strength test results obtained from the structure will be accepted by both the Contractor and the Department as the in-place strength of the LOT of concrete in question. The core strength test results will be final and used in lieu of the cylinder strength test results for determination of structural adequacy and any pay adjustment. The Department will calculate the strength value to be the average of the compressive strengths of the three individual cores. This will be accepted as the actual measured value.

346-10.2 Determination of Structural Adequacy: If core strength test results are less than 500 psi or 10%, whichever is greater, below the specified minimum strength, consider the concrete represented by the cores structurally adequate. If the core strength test results are more than 10% or 500 psi, whichever is greater, below the specified minimum strength, the Department will consider the concrete represented by the cores structurally questionable. Submit a structural analysis performed by the Specialty Engineer. If the results of the structural analysis indicate adequate strength to serve its intended purpose with adequate durability, and is approved by the Department, the Contractor may leave the concrete in place subject to the requirements of 346-11, otherwise, remove and replace the LOT of concrete in question at no additional expense to the Department.

346-10.3 Coring for Determination of Structural Adequacy: Furnish three undamaged core samples taken from the same approximate location where the questionable concrete is represented by the low strength concrete test cylinders. Select the location of the drilled cores so that the structure is not impaired and does not sustain permanent damage after repairing the core holes. Obtain the Engineer's approval of the core location prior to coring.

346-10.4 Core Conditioning and Testing: The Department will test the cores in accordance with ASTM C 42. The Engineer will make the determination whether to test the cores in a dry or wet condition. If the Engineer decides to test the cores in a wet condition, immerse the cores in water for at least 40 hours, and test the cores wet. The cores will be tested after obtaining the samples within three days for wet cores and within six days for dry cores.

346-11 Pay Adjustments for Low Strength Concrete.

346-11.1 General: Any LOT of concrete failing to meet the specified minimum strength as defined in 346-3, 346-9, 346-10 and satisfactorily meeting all other requirements of the

Contract Documents, including structural adequacy, the Engineer will individually reduce the price of each low strength LOT in accordance with this Section.

346-11.2 Basis for Pay Adjustments: When an acceptance strength test result falls more than 10% or 500 psi, whichever is greater, below the specified minimum strength, core samples may be obtained in accordance with ASTM C 42 from the respective LOT of concrete represented by the low acceptance strength test result for determining pay adjustments. Price adjustment will be applied to the certified invoice price the Contractor paid for the concrete or the precast product.

Do not core hardened concrete for determining pay adjustments when the 28 day acceptance cylinder strength test results are less than 500 psi or 10%, whichever is greater, below the specified minimum strength.

Submit acceptable core samples to the Engineer for testing for determination of payment reductions based upon the results of the strength tests. The results of strength tests of the drilled cores, subject to 346-11.5 and 346-11.6, will be accepted as final and will be used in lieu of the cylinder strength test results for determining pay adjustments.

In precast operations, excluding prestressed, ensure that the producer submits acceptable core samples to the Engineer for testing. The producer may elect to use the products in accordance with 346-11. Otherwise, replace the concrete in question at no additional cost to the Department. For prestressed concrete, core sample testing is not allowed for pay adjustment. The results of the cylinder strength tests will be used to determine material acceptance and pay adjustment.

346-11.3 Coring for Determination of Pay Adjustments: Obtain the cores in accordance with 346-10.3.

346-11.4 Core Conditioning and Testing: The Department will test the cores in accordance with 346-10.4.

346-11.5 Core Strength Representing Equivalent 28 Day Strength: For cores tested no later than 42 days after the concrete was cast, the Engineer will accept the core strengths obtained as representing the equivalent 28-day strength of the LOT of concrete in question. The Engineer will calculate the strength value to be the average of the compressive strengths of the three individual cores. The Engineer will accept this strength at its actual measured value.

346-11.6 Core Strength Adjustments: For cores tested later than 42 days after the concrete was cast, the Engineer will establish the equivalency between 28 day strength and strength at ages after 42 days based on test data developed by a Department approved testing laboratory to relate strength at the actual test age to 28 day strength for the particular class of concrete and design mix represented by the cores. Obtain such data at no additional expense to the Department. When such data is not available and cannot be produced, as determined by the Department, the Engineer will determine the equivalent 28 day strength by adjusting the tested core strengths according to the following relationship:

346-11.6.1 Portland Cement Concrete without Pozzolan or Slag:

Equivalent 28-Day Strength, f'c (28) = 1/F (Average Core Strength) x 100, where:

$F = 4.4 + 39.1 (\ln x) - 3.1 (\ln x)^2$ (Type I Cement)

$F = -17.8 + 46.3 (\ln x) - 3.3 (\ln x)^2$ (Type II Cement)

$F = 48.5 + 19.4 (\ln x) - 1.4 (\ln x)^2$ (Type III Cement)

x = number of days since the concrete was placed
ln = natural log

346-11.6.2 Pozzolanic-Cement Concrete:
Equivalent 28 day compressive strength = $f'_C(28)$, where:

$$f_c'(28) = 0.490 \; x f_c'(t) \, xe^{\left(\frac{8.31}{t}\right)^{0.276}} \quad \text{(Type I Cement)}$$

$$f_c'(28) = 0.730 \; x f_c'(t) \, xe^{\left(\frac{2.89}{t}\right)^{0.514}} \quad \text{(Type II Cement)}$$

$$f_c'(28) = 0.483 \; x f_c'(t) \, xe^{\left(\frac{5.38}{t}\right)^{0.191}} \quad \text{(Type III Cement)}$$

$f'_c(t)$ = Average Core Strength at time t (psi)

t = time compressive strength was measured (days)

346-11.6.3 Slag-Cement Concrete:
Equivalent 28-day compressive strength = $f'_C(28)$, where:

$$f_c'(28) = 0.794 \; x f_c'(t) \, xe^{\left(\frac{7.06}{t}\right)^{1.06}} \quad \text{(Type I Cement)}$$

$$f_c'(28) = 0.730 \; x f_c'(t) \, xe^{\left(\frac{6.02}{t}\right)^{0.747}} \quad \text{(Type II Cement)}$$

$$f_c'(28) = 0.826 \; x f_c'(t) \, xe^{\left(\frac{2.36}{t}\right)^{0.672}} \quad \text{(Type III Cement)}$$

$f'_c(t)$ = Average Core Strength at time t (psi)

t = time compressive strength was measured (days)

346-11.7 Calculating Pay Adjustments: The Engineer will determine payment reductions for low strength concrete accepted by the Department and represented by either cylinder or core strength test results below the specified minimum strength, in accordance with the following:

Reduction in Pay is equal to the reduction in percentage of concrete cylinder strength (specified minimum strength minus actual strength divided by specified minimum strength).

For the elements that payments are based on the per foot basis, the Engineer will adjust the price reduction from cubic yards basis to per foot basis, determine the total linear feet of the elements that are affected by low strength concrete samples and apply the adjusted price reduction accordingly.