

EXPECTED IMPLEMENTATION JULY 2021

462 POST-TENSIONING (REV 11-12-20) (FA 1-7-21) (7-21)

SUBARTICLE 462-7.4.1.5.3 is deleted and the following substituted:

462-7.4.1.5.3 Production Test:

1. Test grout fluidity to verify it is within limits established by grout manufacturer during grouting operations. Target fluidity rate is established by manufacturer's representative based on ambient weather conditions.

2. Determine grout fluidity in accordance with

Section 938.

a. Perform a fluidity test using flow cone on grout discharged from anchorage cap outlet immediately after uncontaminated uniform consistency discharge begins for each tendon greater than 50 feet in length. For tendons 50 feet or less, perform a fluidity test on a per batch basis. For fluidity tests done on a per batch basis, perform test after new batch has been transferred from mixing tank to holding tank and thoroughly mixed with remains of the previous batch to produce a new homogenous mixture. During mixing process, continually re-circulate grout from hose into holding tank. Ensure measured grout efflux time is not less than efflux time measured at injection end of grout hose.

b. Additionally, check grout fluidity using Wet Density method contained in Section 938. Density at discharge outlet must not be less than grout density at inlet. Continuously discharge grout until density requirements are met. Discard grout used for testing fluidity.

3. Perform fluidity test for each tendon to be grouted without modifying water-cement ratio.

4. Check temperature of grout at inlet end of grout hose hourly to verify conformance to this Section.

5. Obtain a sample from first production batch of grout and perform a wick induced bleed test on this sample in accordance with Section 938 at beginning of each day's grouting operation. Begin grouting operations after sample is obtained.

6. Once grouting has begun, if zero bleed requirement is found to not have been achieved in the wick induced bleed test at any time during required test time period, complete grouting of any partially grouted tendons currently being grouted but do not begin grouting any new or additional tendons. Immediately inform the Engineer when grouting operations have ceased due to non-compliance of the wick induced bleed test.

7. Do not re-start grouting operations until such time that testing shows grout meets specified requirements.