July 21, 2019 Seminar for HDOT

BFRP-RC Standardization of Design & Materials

FHWA Project: STIC-0004-00A
(Phase 3 - Technology Transfer)

STIC State Transportation Innovation Councils

FRP-RC Design - Part 1

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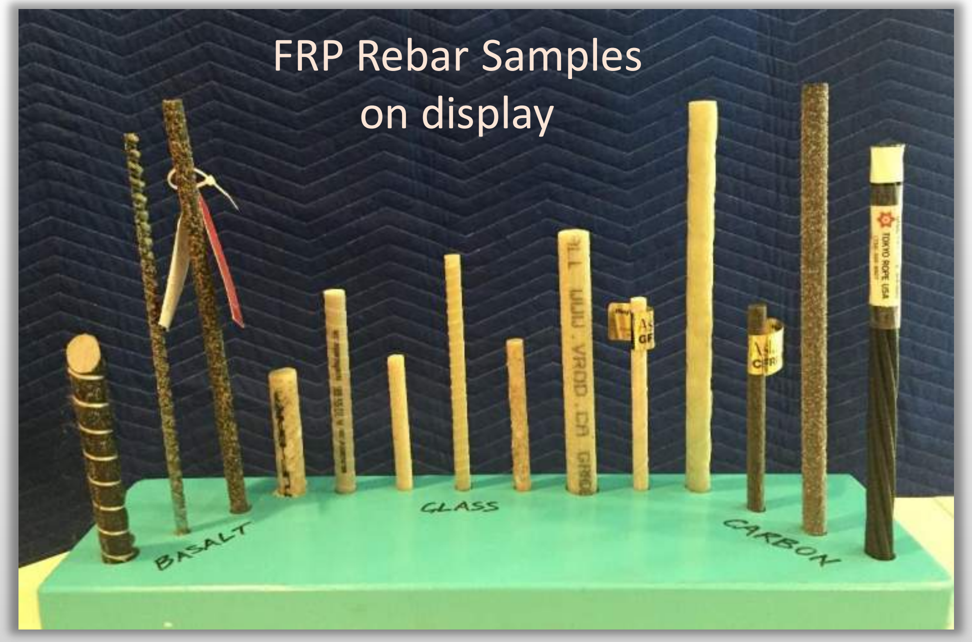
Department of Transportation State of Hawaii | College of Engineering University of Hawai'i at Mānoa | PISCES Pacific International Space Center for Exploration Systems | FAMU-FSU Engineering | Miami | FDOT

Seminar Description

Fiber-reinforced polymer (FRP) materials have emerged as an alternative for producing reinforcing bars for concrete structures. Due to other differences in the physical and mechanical behavior of FRP materials versus steel, unique guidance on the engineering and construction of concrete structures reinforced with FRP bars is necessary.



Learning Objectives

Part 1

- Understand the mechanical properties of FRP bars
- Describe the behavior of FRP bars

Part 2

- Describe the design assumptions
- Describe the use of internal FRP bars for serviceability & durability design including long-term deflection

Part 3

- Describe the flexural/shear/compression design procedures of concrete members internally reinforced with FRP bars

Part 4

- Review the procedure for determining the development, splice length, and bends for FRP bars.

Content of the Complete Seminar

FRP-RC Design - Part 1, (30 min.)

This session will introduce concepts for reinforced concrete design with FRP rebar. Topics will address:

- Materials & Design Specifications;
- Design & Typical Applications;
- FRP Rebar Properties;
- New Developments and Solutions;

BFRP-RC Design - Part 2, (45 min.)

This session will introduce FRP rebar that is being standardized under FHWA funded project ***STIC-0004-00A*** with extended FDOT research under BE694, and provide training on the flexural design of beams, slabs, and columns for:

- Design Assumptions and Material Properties
- Ultimate capacity and rebar development length under strength limit states;
- Crack width, sustained load resistance, and deflection under service limit state;

Content of the Complete Seminar

FRP-RC Design - Part 3, (45 min.)

This session continues with FRP rebar from Part 2, covering shear and axial design of columns at the strength limit states for:

- Shear resistance of beams and slabs;
- Axial Resistance of columns;
- Combined axial and flexure loading.

FRP-RC Design - Part 4 (30 min.)

This session continues with FRP rebar from Part 3, covering detailing and plans preparation:

- Fatigue resistance under the Fatigue limit state;
- Minimum Shrinkage and Temperature Reinforcing;
- Bar Bends and Splicing;

Some Local Flavor

Honoapi'ilani Hwy, Maui

Pearl Harbor, Oahu

Photos courtesy of Prof. Doug Gremel, Hughes Bros. (2016)

Introduction - *A word from your local sponsors…*

During the last few years, Universities have been working closely with national & international engineering firms and government departments (including HDOT & FDOT):

- Bridges
- Parking facilities
- Water-treatment plants
- Tunnels
- Retaining walls
- Traffic Barriers
- RC/PC Sheet Piles
- Precast Driven Piles

Introduction - Significant Applications

Examples of major national and international projects using FRP bars:

- Nipigon Bridge on the Trans-Canada Highway (northwestern Ontario, Canada)
- Champlain Bridge (Montreal)
- TTC Subway North Tunnels (Highway 407) (Toronto)
- Port of Tanger Med II (Morocco)
- Port of Miami Tunnel (Florida - FDOT)
- Pearl Harbor Dry Dock Rehab (Hawaii – US Navy)

Introduction - **Significant Applications**





Photos courtesy of Prof. B. Benmokrane (2015, 2018)

… **alternatively** (corrosion induced failures) -->

Let us begin…

FRP-RC Design - Part 1, (30 min.)

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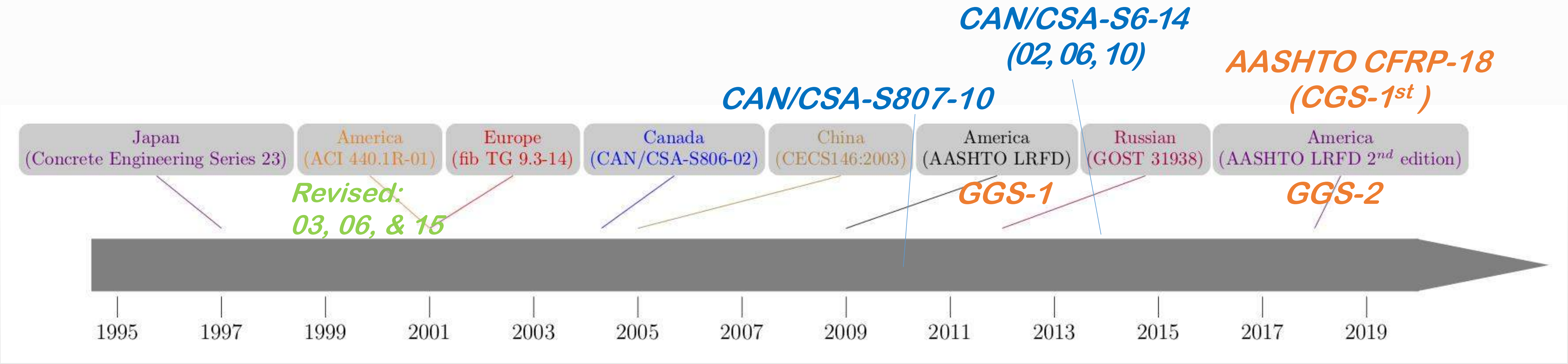
Session 1: **Materials & Design Specs.**

North American Material Specifications and Design Codes for Concrete Structures Reinforced with FRP Bars

Seminar based on ***CAN/CSA-S6, -806 & -807***
vs. ***AASHTO GGS-2*** *and* ***FDOT Specifications***

Session 1: Materials & Design Specs.

Development of Worldwide FRP-RC/PC Guidelines

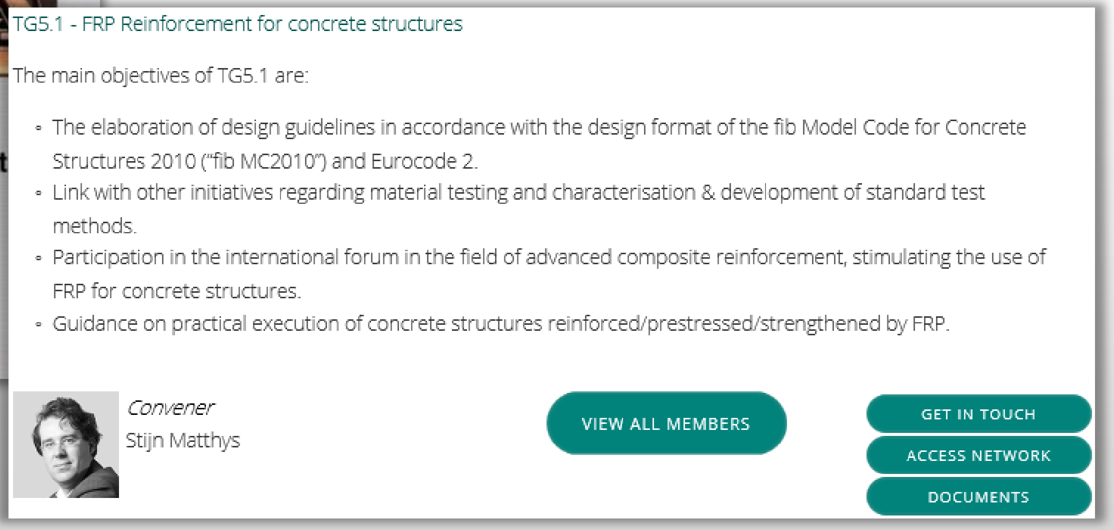


Session 1: Materials & Design Specs.

Other national Specifications and Design Codes for Concrete Structures Reinforced with FRP Bars

European –

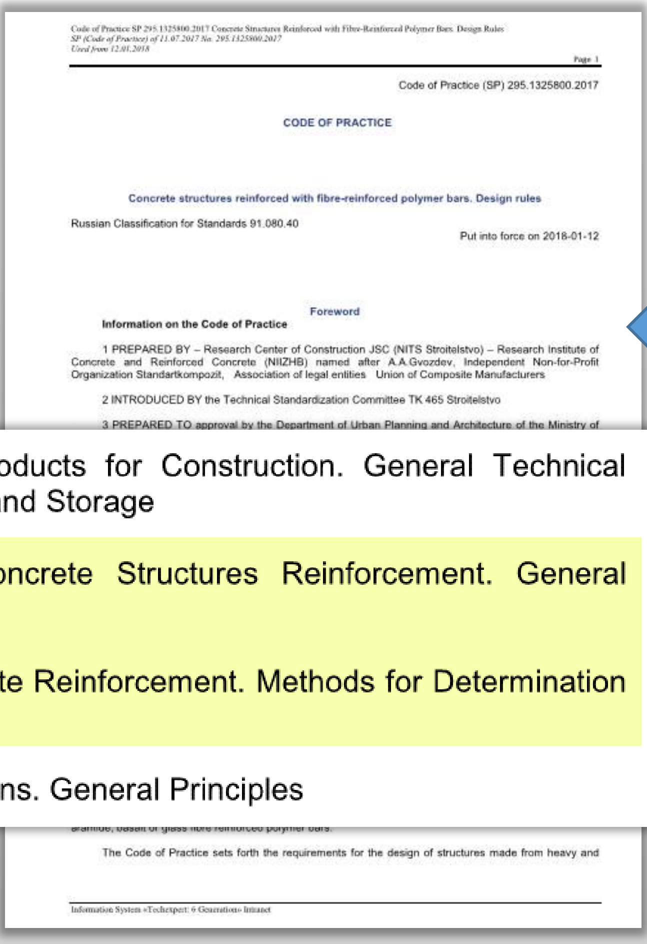
- ***fib*** **(Fédération internationale du béton),** ***Bulletin 40:*** **FRP reinforcement in RC structures: Technical report (2007)**
- ***fib Model Code 2020*** **(in development)**
- ***Eurocode 1992*** **(in development)**



Session 1: Materials & Design Specs.

Other national Material Specifications and Design Codes for Concrete Structures Reinforced with FRP Bars

SP295 Russian Code of Practice (2017, 2018.12.01 English translation)


Code of Practice SP 295.1325800.2017 Concrete Structures Reinforced with Fibre-Reinforced Polymer Bars. Design Rules
SP (Code of Practice) of 11.07.2017 No. 295.1325800.2017
Used from 12.01.2018
Page 1

Code of Practice (SP) 295.1325800.2017

CODE OF PRACTICE

Concrete structures reinforced with fibre-reinforced polymer bars. Design rules

Russian Classification for Standards 91.080.40

Put into force on 2018-01-12

Foreword

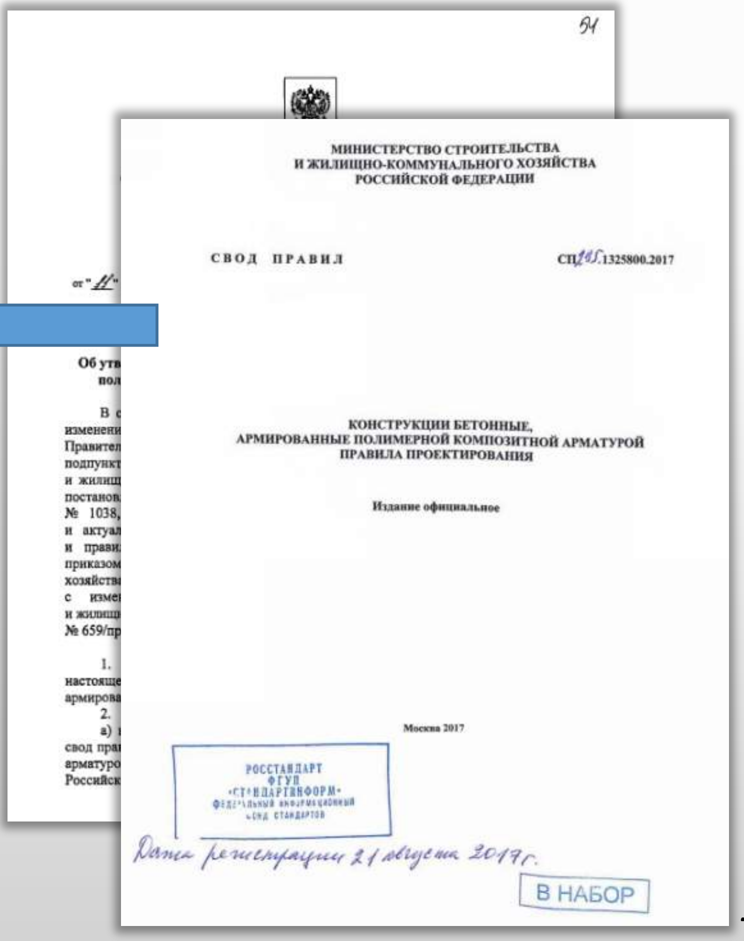
Information on the Code of Practice

1 PREPARED BY – Research Center of Construction JSC (NITS Stroitelstvo) – Research Institute of Concrete and Reinforced Concrete (NIIZHB) named after A.A.Gvozdev, Independent Non-for-Profit Organization Standartkompozit, Association of legal entities Union of Composite Manufacturers

2 INTRODUCED BY the Technical Standardization Committee TK 465 Stroitelstvo

3 PREPARED TO approval by the Department of Urban Planning and Architecture of the Ministry of

The Code of Practice sets forth the requirements for the design of structures made from heavy and



GOST 13015-2003 Reinforced Concrete and Concrete Products for Construction. General Technical Requirements. Rules for Acceptance, Marking, Transportation and Storage

GOST 31938-2012 Fibre-Reinforced Polymer Bar for Concrete Structures Reinforcement. General Specifications

GOST 32492-2015 Fibre-Reinforced Polymer Bar For Concrete Reinforcement. Methods for Determination of Structural and Thermo-Mechanical Characteristics

GOST 27751-2014 Reliability for Constructions and Foundations. General Principles

Session 1: Materials & Design Specs.

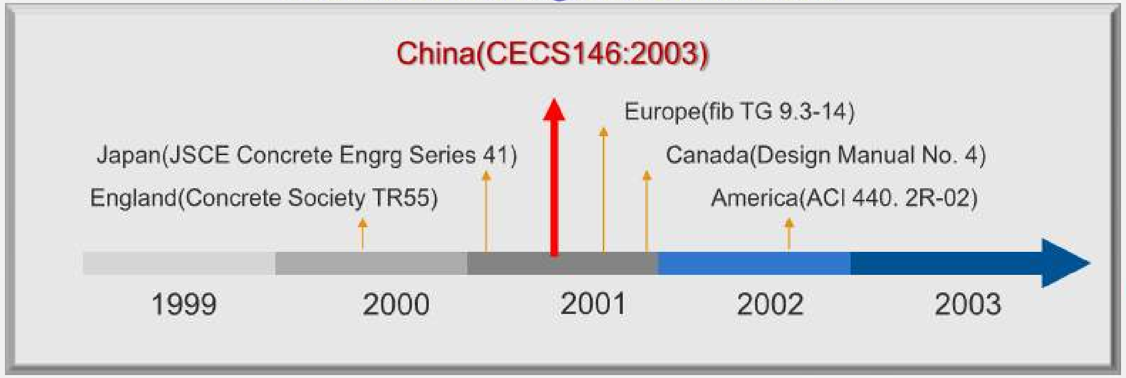
Other national Material Specifications and Design Codes for Concrete Structures Reinforced with FRP Bars

FRP Design Standard —— China's First FRP Standard

In 1998, the first applied technical standard of FRP was developed in China.

CECS146:2003 *Technical specification for strengthening concrete structures with carbon fiber reinforcea polymer laninate*

Compilation time of the first FRP specification in the major countries and regions of the world



An overview of research, development and application of FRP for civil infrastructure in China

Angela Wei Liu
Nanjing Fenghui Composite Material Co.,Ltd

In collaboration with
Nanjing Tech University

2017

CAMX

JG/T406-2013 *Class frbre reinforced plastics rebar for civil engineering*

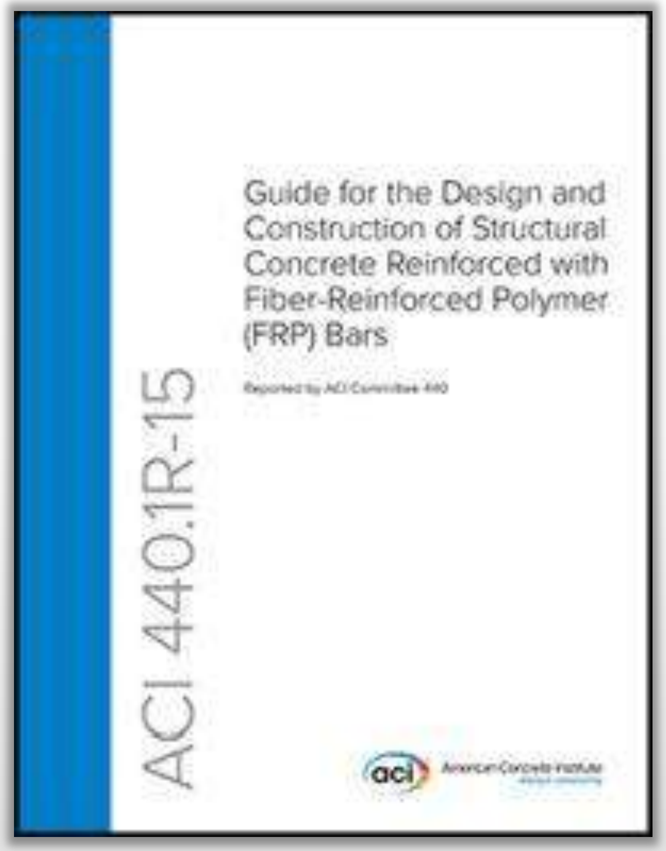
JG/T351-2012 *Fiber reinforced composite bars*

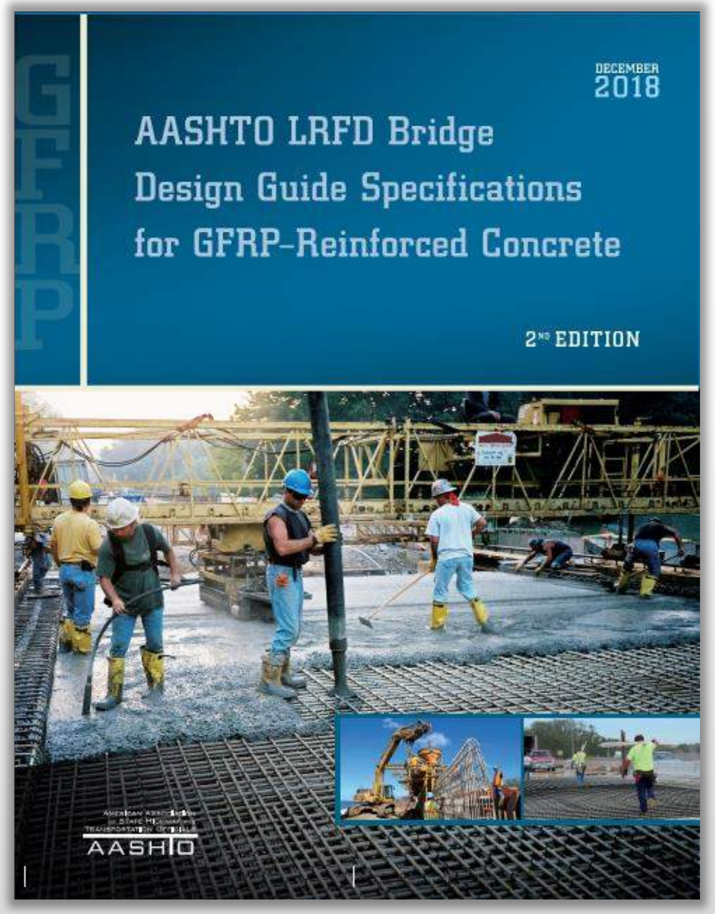
GB50608-2010 *Technical code for infrastructure appliaction of FRP composites*

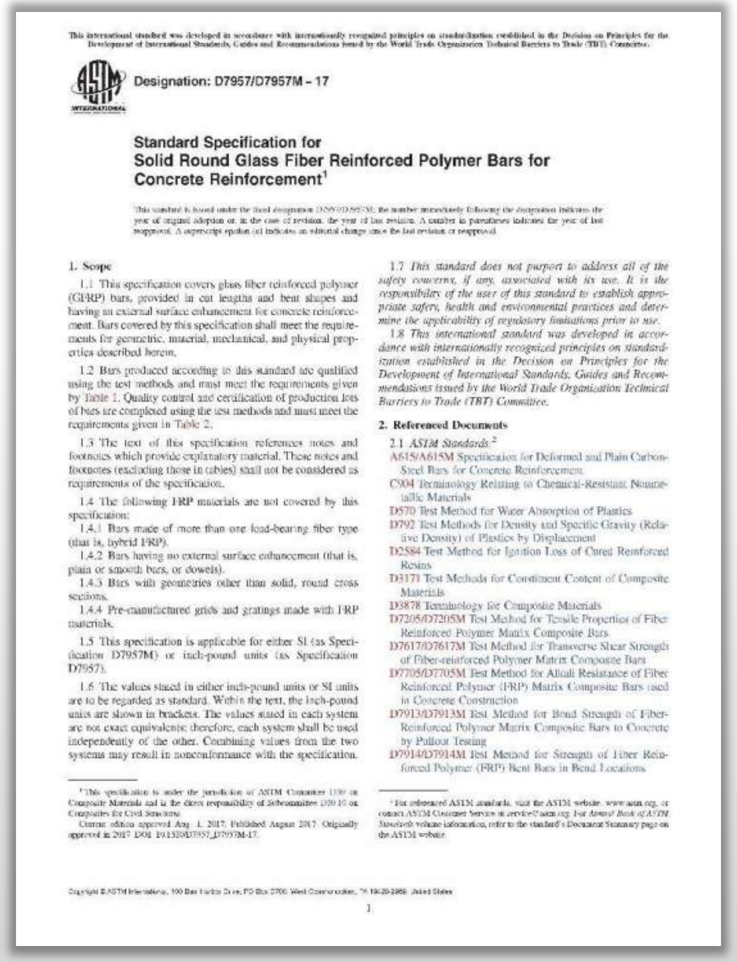
Session 1: **Materials & Design Specs.**

1. **ACI 440. 1R**: “Guide for the design and Construction of Structural Concrete Reinforced with FRP Bars". *1st Edition in 2001, 2nd Edition in 2003, 3rd Edition in 2006, 4th Edition in 2015, Design Code (ACI 318 in 2020)*.
2. **AASHTO LRFD**: “ Bridge Design Guide Specifications for GFRP-Reinforced Concrete Bridge Decks and Traffic Railings“. *1st Edition in 2009, 2nd Edition 2018*
3. **ASTM D7957-17**: “Standard Specification for Solid Round Glass Fiber Reinforced Polymer Bars for Concrete Reinforcement“. *1st Edition 2017*
4. **CAN/CSA S6**: "Canadian Highway Bridge Design Code", Section 16 "Fibre Reinforced Polymers (FRP) Structures". *1st Edition in 2000, 2nd Edition in 2006, Supplement S1 in 2010, 3rd Edition in 2014, 4th Edition in 2019*
5. **CAN/CSA S806**: "Design and Construction of Building Components with FRP". *1st Edition in 2002, 2nd Edition in 2012, 3rd Edition in 2019?*
6. **CAN/CSA-S807**: “Specifications for Fibre Reinforced Polymers". *1st Edition in 2010, 2nd Edition in 2019*

Session 1: Materials & Design Specs.







This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

ASTM INTERNATIONAL

Designation: D7957/D7957M – 17

Standard Specification for Solid Round Glass Fiber Reinforced Polymer Bars for Concrete Reinforcement[1]

This standard is issued under the fixed designation D7957/D7957M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers glass fiber reinforced polymer (GFRP) bars, provided in cut lengths and bent shapes and having an external surface enhancement for concrete reinforcement. Bars covered by this specification shall meet the requirements for geometric, material, mechanical, and physical properties described herein.

1.2 Bars produced according to this standard are qualified using the test methods and must meet the requirements given by Table 1. Quality control and certification of production lots of bars are completed using the test methods and must meet the requirements given in Table 2.

1.3 The text of this specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables) shall not be considered as requirements of the specification.

1.4 The following FRP materials are not covered by this specification:

1.4.1 Bars made of more than one load-bearing fiber type (that is, hybrid FRP).

1.4.2 Bars having no external surface enhancement (that is, plain or smooth bars, or dowels).

1.4.3 Bars with geometries other than solid, round cross sections.

1.4.4 Pre-manufactured grids and gratings made with FRP materials.

1.5 This specification is applicable for either SI (as Specification D7957M) or inch-pound units (as Specification D7957).

1.6 The values stated in either inch-pound units or SI units are to be regarded as standard. Within the text, the inch-pound units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

1.7 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.8 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*[2]

A615/A615M Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement
C904 Terminology Relating to Chemical-Resistant Nonmetallic Materials
D570 Test Method for Water Absorption of Plastics
D792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
D2584 Test Method for Ignition Loss of Cured Reinforced Resins
D3171 Test Methods for Constituent Content of Composite Materials
D3878 Terminology for Composite Materials
D7205/D7205M Test Method for Tensile Properties of Fiber Reinforced Polymer Matrix Composite Bars
D7617/D7617M Test Method for Transverse Shear Strength of Fiber-reinforced Polymer Matrix Composite Bars
D7705/D7705M Test Method for Alkali Resistance of Fiber Reinforced Polymer (FRP) Matrix Composite Bars used in Concrete Construction
D7913/D7913M Test Method for Bond Strength of Fiber-Reinforced Polymer Matrix Composite Bars to Concrete by Pullout Testing
D7914/D7914M Test Method for Strength of Fiber Reinforced Polymer (FRP) Bent Bars in Bend Locations

[1] This specification is under the jurisdiction of ASTM Committee D30 on Composite Materials and is the direct responsibility of Subcommittee D30.10 on Composites for Civil Structures.
Current edition approved Aug. 1, 2017. Published August 2017. Originally approved in 2017. DOI: 10.1520/D7957_D7957M-17.

[2] For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

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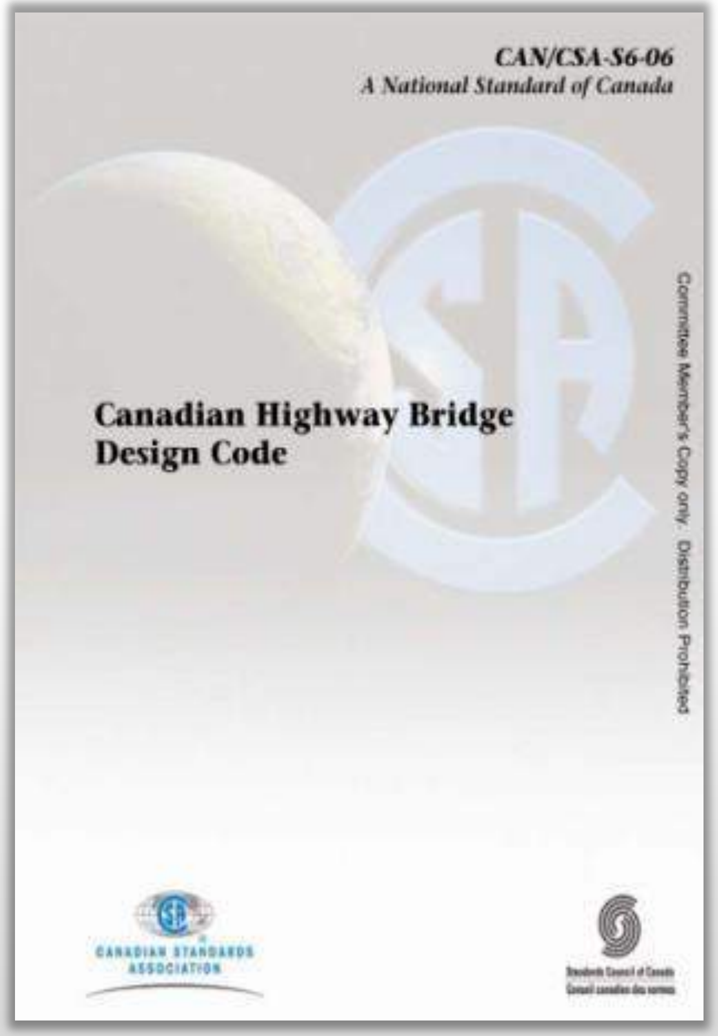
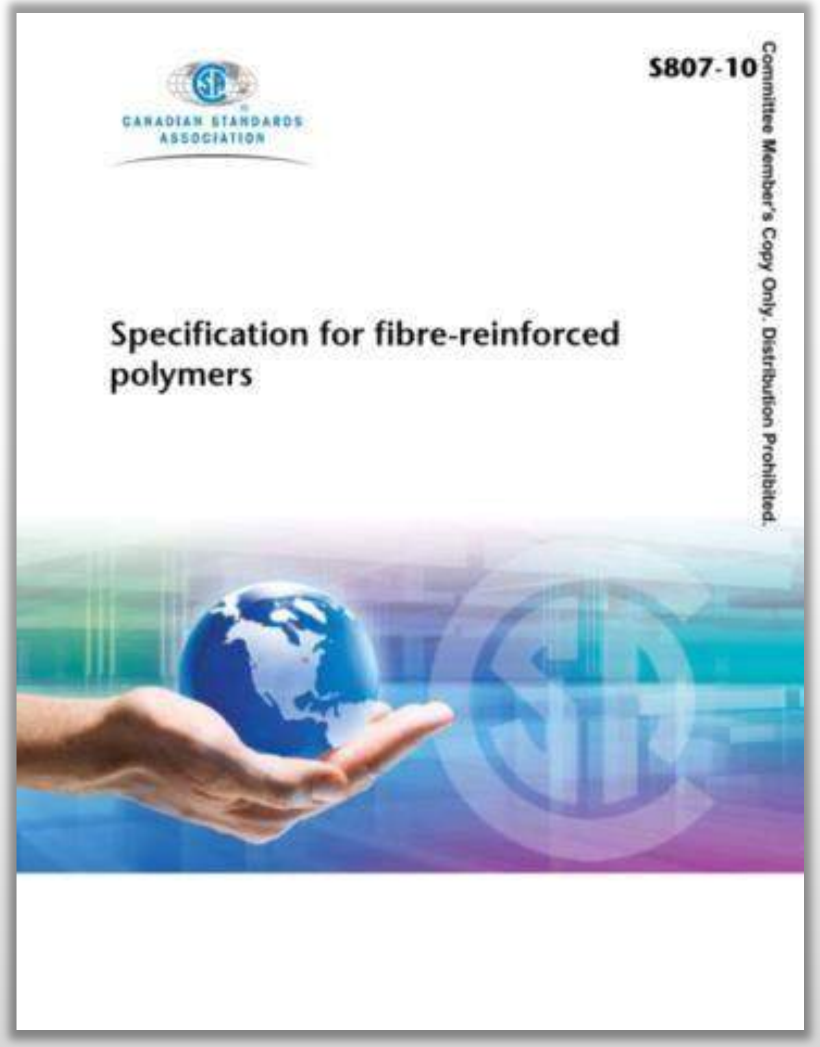
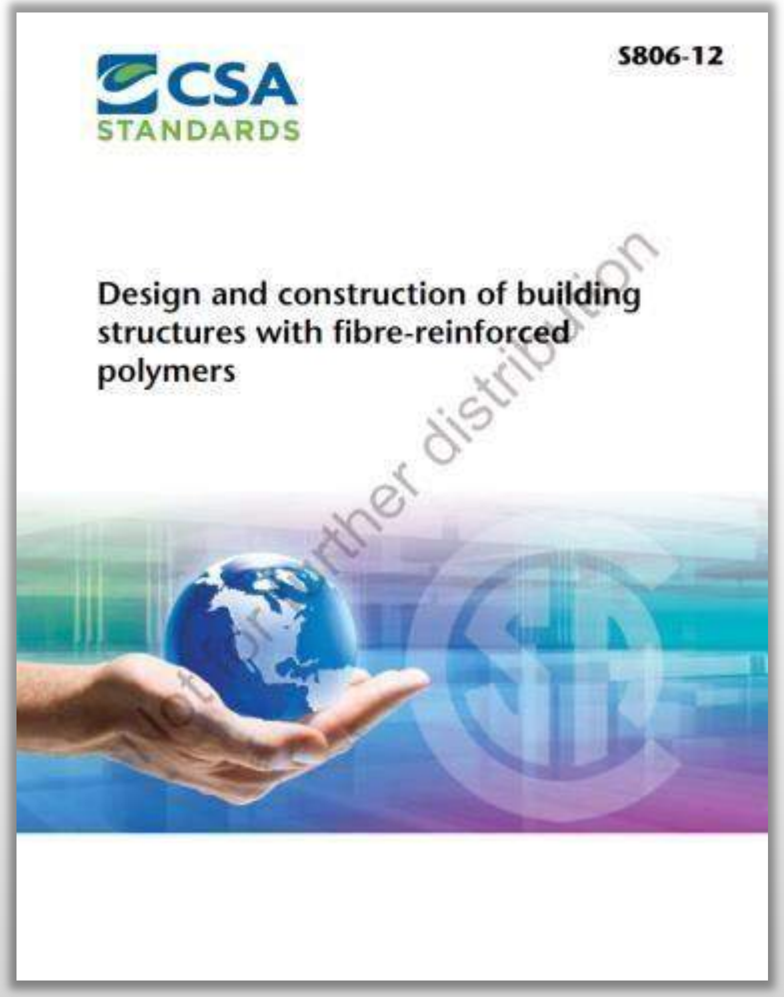
Session 1: Materials & Design Specs.







Session 1: Materials & Design Specs.

- Design principles well established through extensive research and field practice, and experience gained on viability of construction management practices where FRP reinforcement is adopted through traditional low-bid letting processes and competitive bidding from multiple FRP bar suppliers
- Provisions governing testing and evaluation for certification and QC/QA
- Describes permitted constituent materials, limits on constituent volumes, and minimum performance requirements
- Specific properties of FRP reinforcement, design equations and resistance factors, detailing, material and construction specifications
- FRP bar preparation, placement (including cover requirements, reinforcement supports), repair, and field cutting.

FRP Material Characterizing & Durability Testing



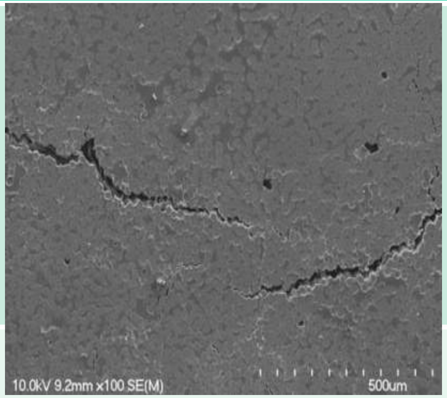


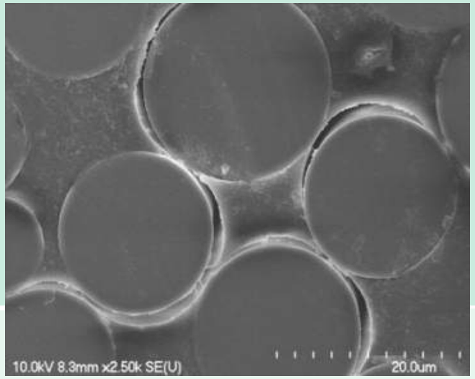


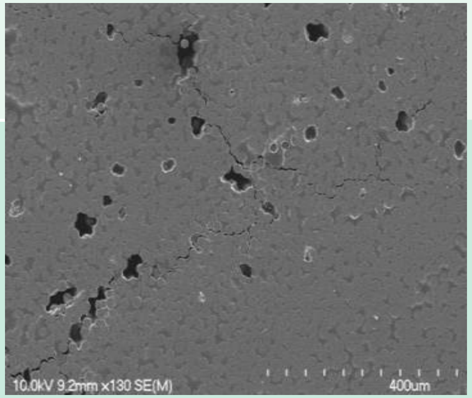
SEM, FTIR, DSC, DMA, Creep/Mechanical, etc.

Techniques for assessing physical properties and microstructure of FRP bars

Technique	Principle and objective	Typical results
DSC (Differential Scanning Calorimetry)	Measure the difference in the amount of heat required to increase the temperature of a sample and reference as a function of temperature **Determination of glass transition temperature or softening point (Tg) and cure ratio**	
TMA (Thermomechanical Analysis)	Measure the change of dimension of a sample as a function of temperature **Determination of coefficient of thermal expansion (CET)**	
FTIR (Infrared Spectroscopy)	Provide infrared spectrum of a material (i.e polymeric resin) to detect chemical changes, such as degradation **Detection of chemical degradation of resin, such as hydrolysis**	
SEM (Scanning Electronic microscopy)	Produce images of a sample by scanning it with a focused beam of electrons **Investigation of the morphology, structure, defects (porosity, microcracking, debonding, corrosion, etc.)**	







Session 1: Design & Typ. Applications

Design Considerations

- The designer should understand that a direct substitution between FRP and steel bars is not possible due to differences in mechanical properties of the two materials
- A major difference is that FRP's are linear up to failure and exhibit no ductility or yielding
- Another major difference is that serviceability will be more of a design limitation in FRP reinforced members than with steel. Due to it's lower modulus of elasticity (e.g., GFRP bars), deflection and crack widths will govern the design.

Session 1: **Design & Typ. Applications**

Where should FRP Concrete Reinforcing be used?

- Any concrete member susceptible to steel corrosion by chloride ions
- Any concrete member requiring non-ferrous reinforcement due to electro-magnetic considerations, e.g. tolling plaza
- As an alternative to epoxy, galvanized, or stainless-steel rebars
- Where machinery will "consume" the reinforced member (i.e., mining and tunneling)
- Applications requiring thermal non-conductivity

Session 1: Design & Typ. Applications

Civil and Building Applications

Concrete exposed to de-icing chlorides or salt sprays:

- Bridge decks
- Approach slabs
- Barrier walls
- Railroad crossings
- Salt storage facilities
- Retaining walls
- Parking Garages
- Seawalls, piles and piers
- Marine structures

Session 1: Design & Typ. Applications

Tunneling Softeyes

London, UK

Session 1: Design & Typ. Applications

Marine Structures

Corrosion of the steel reinforcement caused concrete delamination

Dry-Docks

Pearl Harbor, Hawaii

Session 1: Design & Typ. Applications

Marine Structures

Seawall Rehabilitation

Session 1: Design & Typ. Applications

Bridge Railings

Session 1: Design & Typ. Applications

Electromagnetic Applications

- MRI rooms in hospitals
- Airport radio & compass calibration pads
- Electrical high voltage transformer vaults
- Concrete near high voltage cables and substations
- Electronic tolling plaza pavements and traffic barriers

Session 1: Design & Typ. Applications

Electric Utilities

Wall Protection System

- *Protect key transformer sites on the energy grid from ballistics, explosions and fire without requiring grounding of reinforcement*

Session 1: Design & Typ. Applications

Electrified Rail Isolation

Miami MetroRail: 2.4 miles of elevated rail

- *Rail Plinths 100% reinforced with GFRP Bars*

Session 1: Design & Typ. Applications

FRP Rebar Use in Concrete Bridges in USA

- 65 Bridges – 27 States

Colorado	2
Connecticut	1
Florida	8
Georgia	2
Indiana	1
Iowa	2
Kansas	1
Kentucky	2
Mass	1
Maine	4
Michigan	2
Minnesota	1
Missouri	6
Nebraska	1

New Hampshire	1
New York	3
North Carolina	1
Ohio	4
Oregon	1
PA/NJ	1
Pennsylvania	1
Texas	3
Utah	2
Vermont	1
Virginia	1
West Virginia	9
Wisconson	3

Applications		
Deck only	Deck, parapet, barrier, enclosure, and/or sidewalk	Parapet, barrier, enclosure, and/or sidewalk
56	5	4

Source: ACMA, 2016

FRP Rebar Use in Concrete Bridges in Canada

- 202 Bridges – 5 provinces

	Rebar	Deck only	Deck, parapet, barrier, enclosure, and/or sidewalk	Parapet, barrier, enclosure, and/or sidewalk
Bridges in Canada	202	167	23	12

Source: ACMA, 2016

Session 1: Design & Typ. Applications

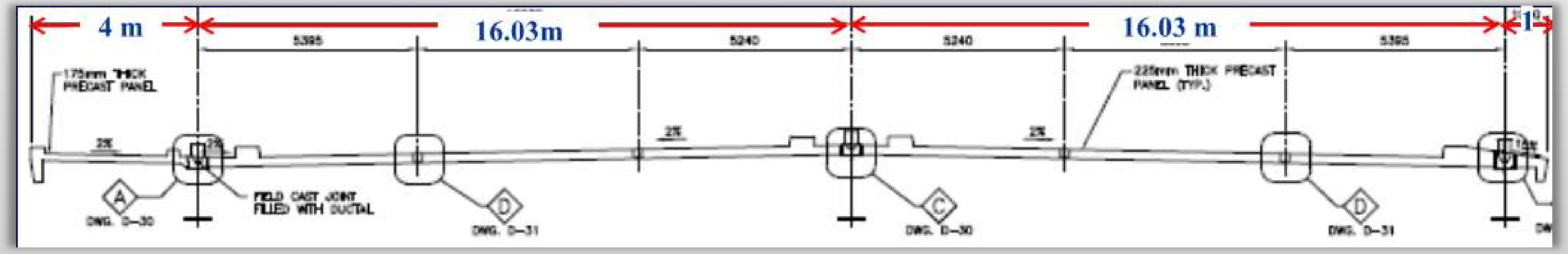
Nipigon River Cable-Stayed Bridge *(Canada)*

- The First Deck Slab Reinforced with GFRP Bars in Cable Stayed Bridge

Session 1: Design & Typ. Applications

Nipigon River Cable-Stayed Bridge *(cont.)*

- 2012-2017
- ~827 ft. (252m) in length
- two-span, four lanes
- 480 precast concrete panels (10 ft. x 23 ft.)
- High Performance concrete
- Panel joint filled with UHPFRC
- Many partners



Session 1: Design & Typ. Applications

***Halls River Bridge Replacement**, Florida, USA*

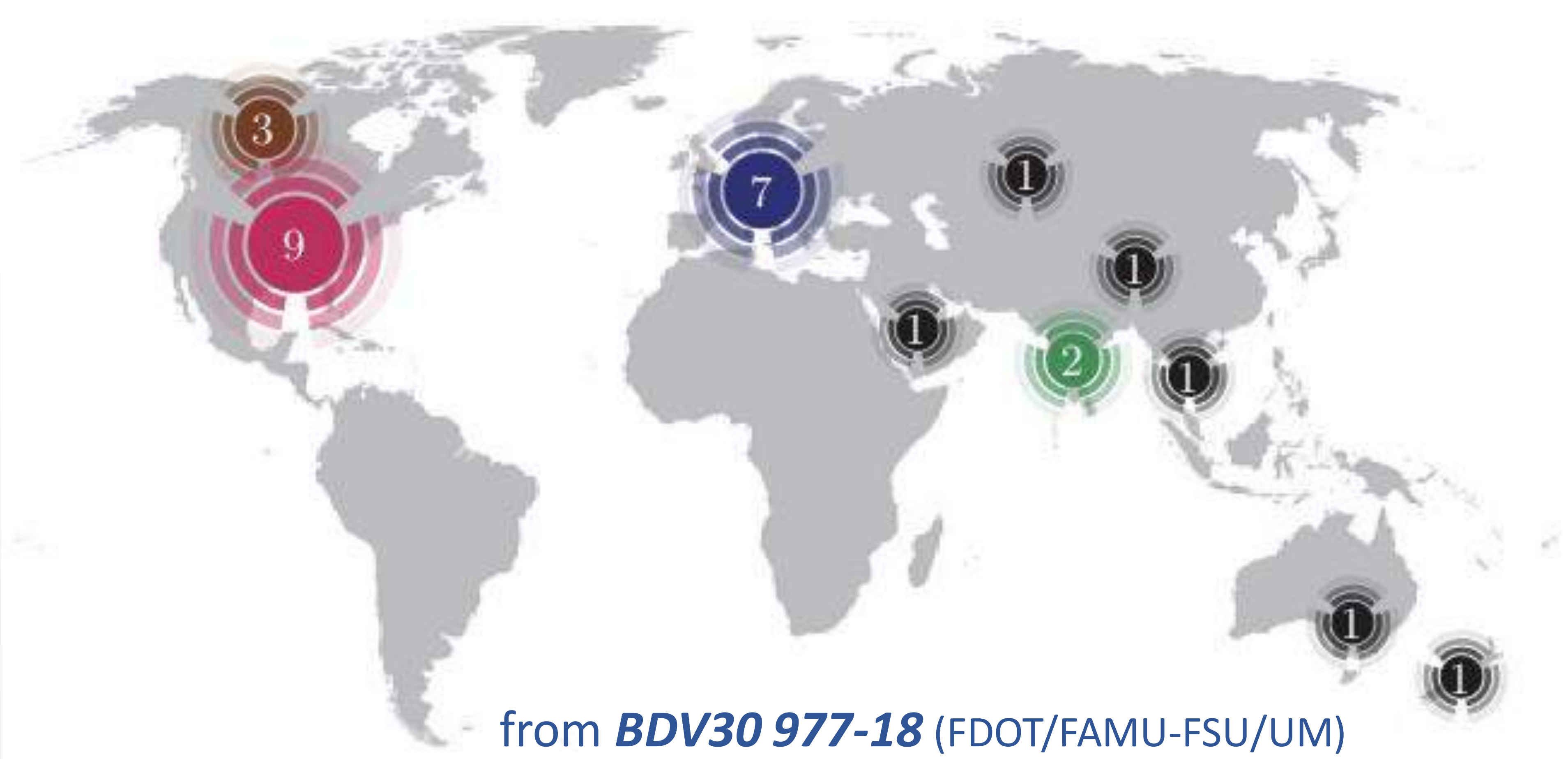
Session 1: Design & Typ. Applications

Halls River Bridge Replacement *(cont.)*

- **Owner:** Citrus County, Designer: FDOT, Funding: FHWA
- **Location:** Homosassa, FL (north of Tampa)
- **Superstructure**: GFRP Bars: Deck, Barriers & Approach Slabs
  - 186 ft. overall bridge length, 58 ft. wide
  - 5 spans (37 ft.), continuous deck, simple span beams
- **Substructure:** CFRP Pre-stressed Piles; Bent Caps: GFRP Bars
- **Sheet Pile Walls**: CFRP Sheet Piles; Wall Cap: GFRP Bars
- **Contractor Bid Cost** - $6.016 Million (Structures = $4M; $2M Roadway & Utilities)
  - Bridge Cost = $218 / sq. ft. (Conventional Construction = $166 / sq.ft.)
- **Accelerated Construction Potential**
  - Lighter Materials – Beams and Rebar
  - Faster Transportation and Delivery – reduced construction time ??

Session 1: FRP Rebar Production

Glass FRP Manufacturer Locations



from ***BDV30 977-18*** (FDOT/FAMU-FSU/UM)

Session 1: FRP Rebar Production

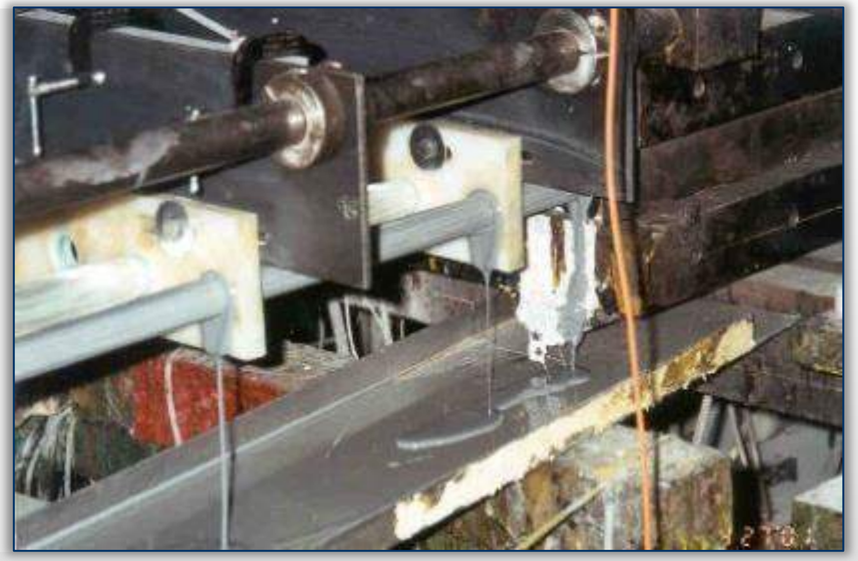
Basalt FRP Manufacturer Locations

from ***BDV30 986-01*** (FDOT/FAMU-FSU/UM)

STIC State Transportation Innovation Councils

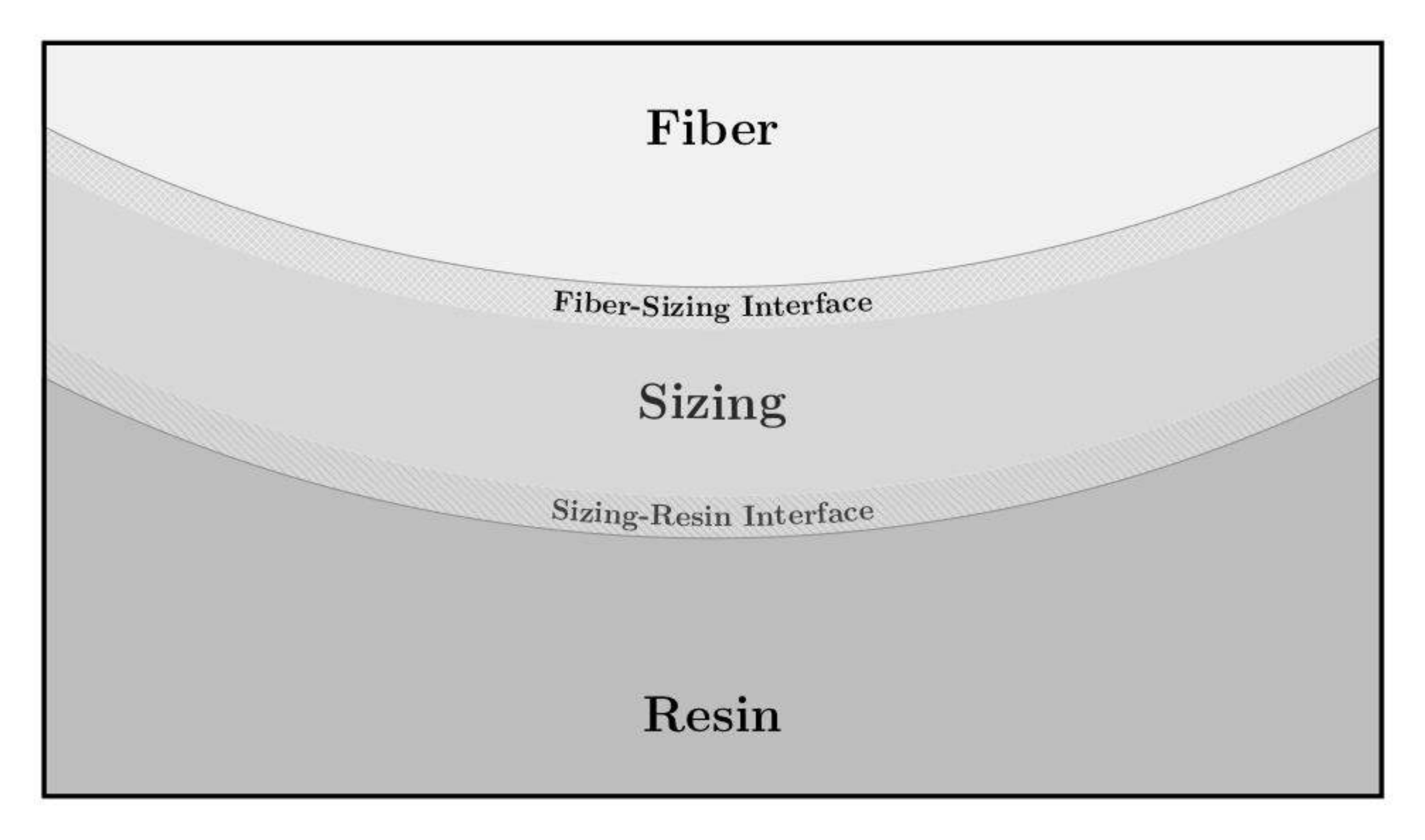
Session 1: FRP Rebar Production

***FRP Reinforcing Bars** - Typically produced by pultrusion process and its variations*



Session 1: FRP Rebar Production

***FRP Reinforcing Bars** – 3 Constituent Materials*



Session 1: **FRP Rebar Production**

FRP Bar Types

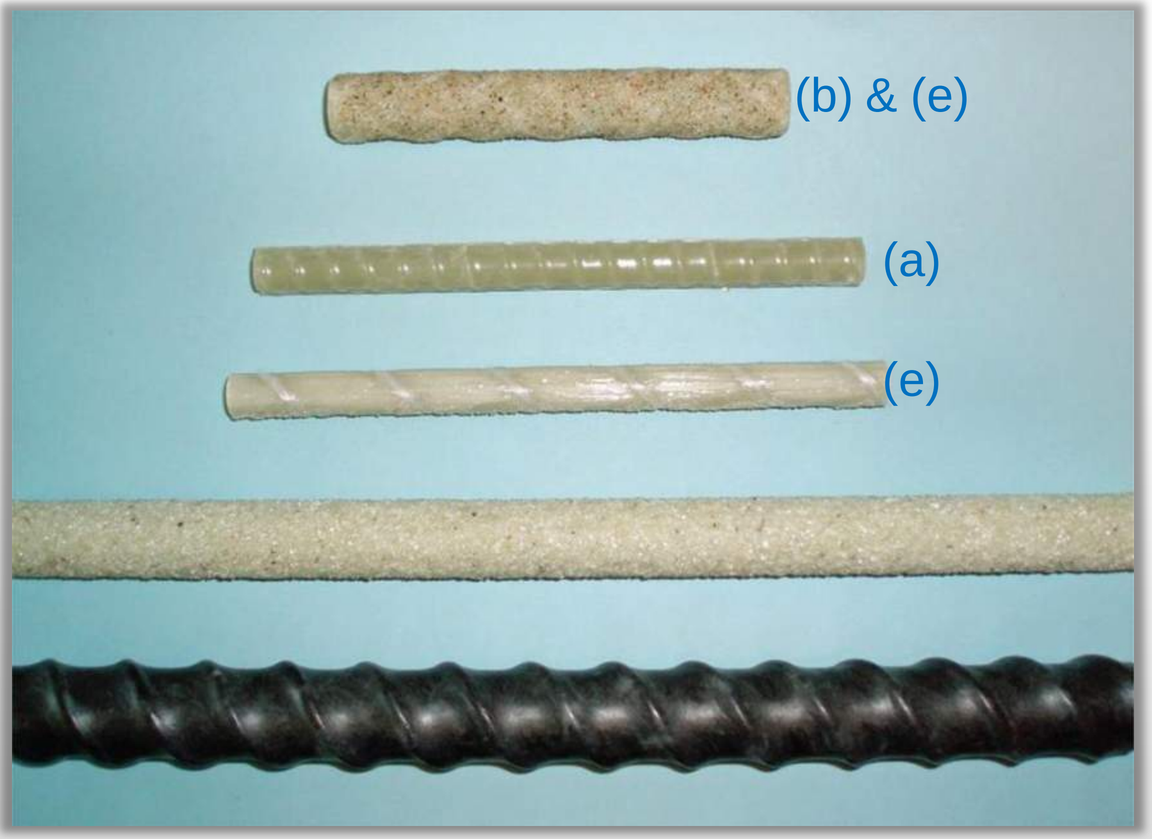
- Materials
  - Glass / vinyl ester
  - Carbon / epoxy
  - Basalt / epoxy/vinylester
  - Aramid / vinyl ester
- Forms
  - Solid round

Session 1: FRP Rebar Properties

FRP Bar Types

External Surface:

- Ribbed (a)
- Sand Coated (b)
- Wrapped and Sand Coated (c)
- Deformed (d)
- Helical (e)
- Grooved (g)
- Hollow core (h)



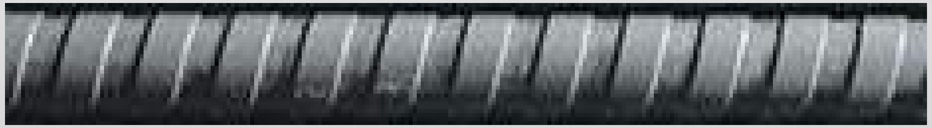
(b) & (e)

(a)

(e)

(b)

(a) (e) (h)



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Session 1: **FRP Rebar Properties**

Differences from Steel

- High longitudinal strength to weight ratio
- Corrosion-resistant
- Electro-magnetic neutrality (glass/basalt/aramid)
- High fatigue endurance (carbon)
- Low thermal and electrical conductivity (glass/basalt)
- Light weight (1/4 steel)

Session 1: FRP Rebar Properties

Differences from Steel (cont.)

- No yielding before failure
- Low transverse strength
- Relatively low modulus (glass/basalt/aramid)
- Some susceptible to UV
- Sensitive to moisture (aramid)
- Sensitive to alkaline environment (glass/basalt)
- High CTE perpendicular to the fibers
- Susceptible to fire and smoke production

Session 1: FRP Rebar Properties

FRP Mechanical Properties and Behavior

- *FRP is anisotropic*

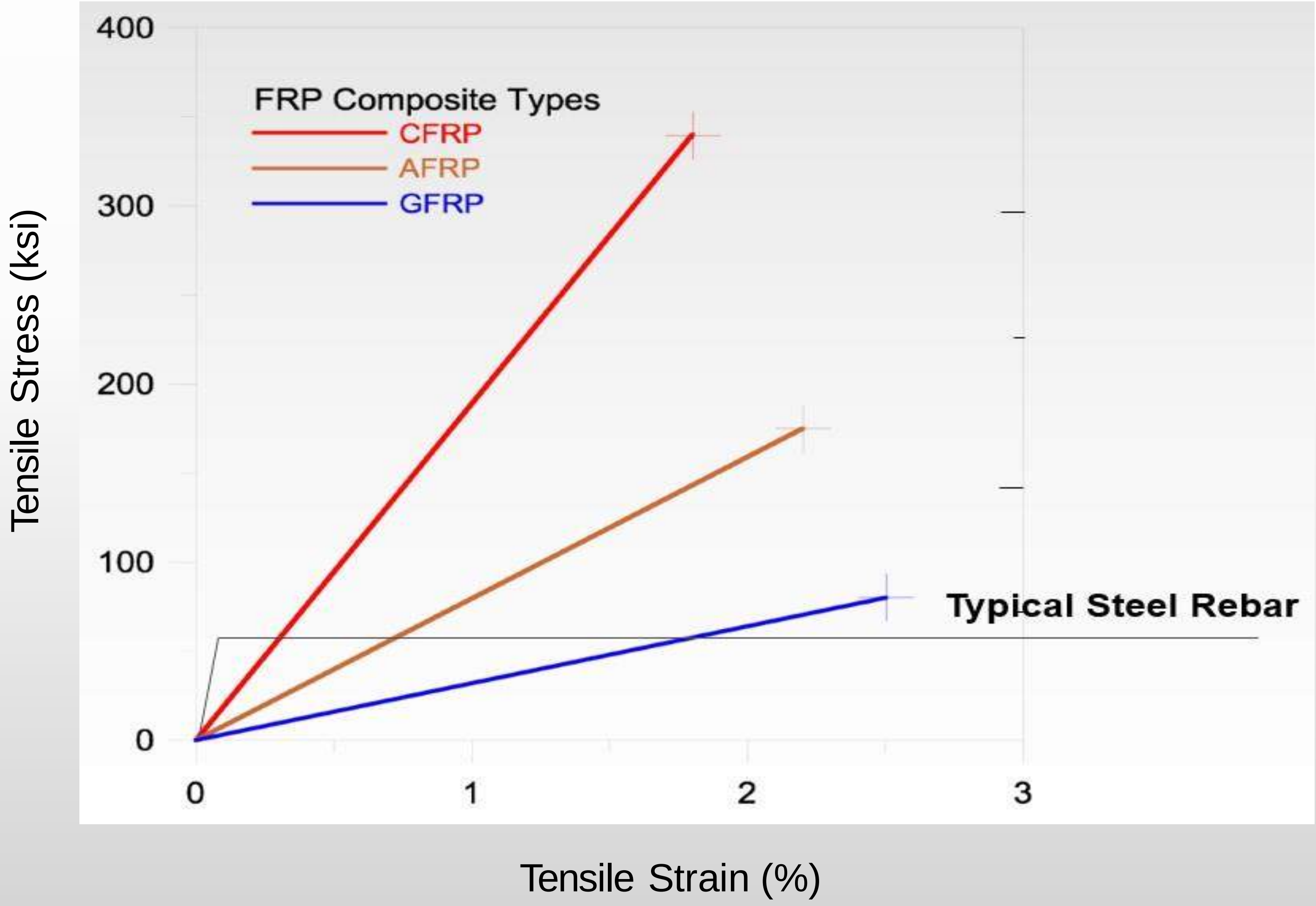
  High strength only in the fiber direction
  Anisotropic behavior affects shear strength, dowel action and bond performance

- *FRP does not exhibit yielding: is elastic until failure*

  Design accounts for lack of ductility

Session 1: FRP Rebar Properties

Tensile Stress-Strain Characteristics



Session 1: FRP Rebar Properties

Tensile Stress-Strain Characteristics

	Steel	GFRP	CFRP	AFRP
Yield Stress ksi (MPa)	40-75 (276-520)	N/A	N/A	N/A
Tensile Strength ksi (MPa)	70-100 (483-690)	70-230 (483-1585)	87-535 (600-3700)	250-368 (1725-2540)
Elastic Modulus X 10^3 ksi (GPa)	29 (200)	5.1 - 8.6 (40-60)	15.9 – 24 (109-165)	6.0 - 18.2 (41-125)
Yield Strain %	0.14-0.25	N/A	N/A	N/A

Session 1: FRP Rebar Properties

Factors Affecting Material Characteristics

- Fiber volume
- Type of fibers
- Type of resin
- Fiber orientation/straightness
- Quality control during manufacturing
- Rate of curing
- Void content
- Service temperature

Session 1: FRP Rebar Properties

Typical Densities *of reinforcing bars*

	Steel	GFRP	CFRP	AFRP
lb./ft^3 (g/cm3)	493 (7.90)	78 – 131 (1.25-2.10)	93 – 100 (1.50-1.60)	78 – 88 (1.25-1.40)

Session 1: **FRP Rebar Properties**

Coefficient of Thermal Expansion *(CTE) 10^{-6} / ºF (x 10-6 / ºC)*

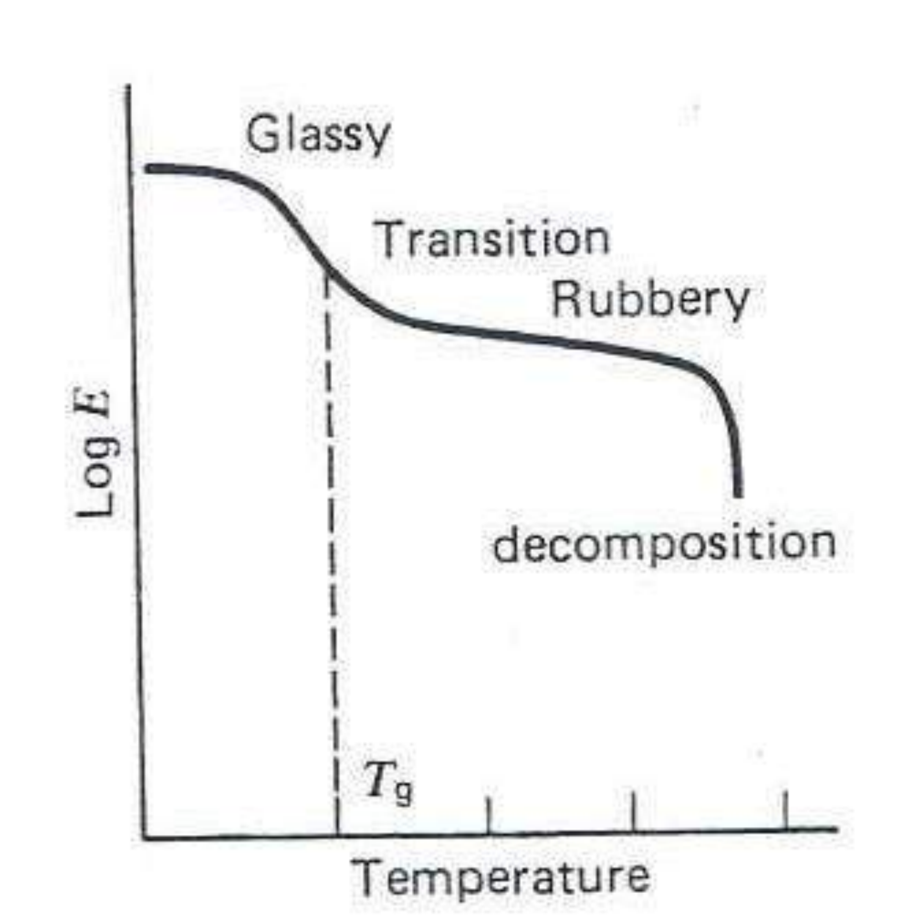
Material	Longitudinal Direction	Transverse
Concrete	4 ~ 6 (7.2 to 10.8)	4 ~ 6 (7.2 to 10.8)
Steel	6.5 (11.7)	6.5 (11.7)
GFRP	3.5 ~ 5.6 (6.0 to 10.0)	≈ 30 (40)
CFRP	-4 ~ 0 (-9.0 to 0.0)	41 ~ 58 (74 to 104)
AFRP	-3.3 ~ -1.1 (-6 to-2)	33 ~ 44 (60 to 80)

Values of CTE differ between FRP materials and concrete and most relevant is the difference in the transverse bar direction

Session 1: FRP Rebar Properties

Effect of High Temperatures

- Resins will soften due to excessive heat
- Tensile, compressive, and shear properties of the resin diminish when temperatures approach the Glass Transition Temperature, T_g
- T_g values are approximately 230-240ºF (*110-115 ºC)* for vinyl ester resins which are typically used with GFRP rebar



Session 1: FRP Rebar Acceptance

FDOT Approval of FRP Production Facilities

https://mac.fdot.gov/smoreports

FDOT

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Fiber Reinforced Polymer Production Facility Listing

FDOT State Materials Office, 5007 N.E. 39th Avenue, Gainesville, FL 32609 (352) 955-6600

FRP-02 OWENS CORNING (SEWARD NE)

Company: Hughes Brothers, Inc.

Contact: DOUG GREMEL **Email:** doug@hughesbros.com

Phone: (402) 646-6211 **Fax:**

Physical Address: **Mailing Address:**

210 North 13th St
Seward, NE 68434

PO Box 159

QC Plan Status: Quality C

#04 GFRP BAR

#05 GFRP BAR

#06 GFRP BAR

#07 GFRP BAR

#08 GFRP BAR

FRP-06 PULTRALL

Company: Pultrall Inc

Contact: ROXANNE FORTIER **Email:** roxanne.fortier@pultrall.com

Phone: (418) 335-3202 ext 231 **Fax:**

Physical Address: **Mailing Address:**

700 9eme rue Nord
Thetford Mines

700 9eme rue Nord
Thetford Mines

CANADA

QC Plan Status:

#03 GFRP

#04 GFRP

#05 GFRP

#06 GFRP

#08 GFRP

FRP-12 TUF-BAR INC (EDMONTON CANADA)

Company: Tuf-Bar Inc.

Contact: Nathan Sim **Email:** nathan@tuf-bar.com

Phone: (780) 448-9338 **Fax:**

Physical Address: **Mailing Address:**

5715-76 Avenue

5715-76 Avenue

CANADA

CANADA

QC Plan Status: Quality Control Plan ACCEPTED 3/19/2019

#03 GFRP BAR	Glass Fiber Reinforced Polymer Reinforcing for Concrete, #3
#04 GFRP BAR	Glass Fiber Reinforced Polymer Reinforcing for Concrete, #4
#05 GFRP BAR	Glass Fiber Reinforced Polymer Reinforcing for Concrete, #5
#06 GFRP BAR	Glass Fiber Reinforced Polymer Reinforcing for Concrete, #6
#07 GFRP BAR	Glass Fiber Reinforced Polymer Reinforcing for Concrete, #7
#08 GFRP BAR	Glass Fiber Reinforced Polymer Reinforcing for Concrete, #8

FRP-07 PULTRON (DUBAI)

Company: Pultron Composites Ltd

Contact: Bogdan Patrascu **Email:** bogdan@pultron.com

Phone: (714) 880-9533 **Fax:**

Physical Address: **Mailing Address:**

S404 Street
Building 10 Jebel Ali Free Zone South

S404 Street
Building 10 Jebel Ali Free Zone South

UNITED ARAB EMIRATES

UNITED ARAB EMIRATES

QC Plan Status: Quality Control Plan ACCEPTED 9/19/2017

#04 GFRP BAR

#05 GFRP

#06 GFRP

#08 GFRP

FRP-08 ATP

Company: ATP

Contact: Aniello Giamundo **Email:** a.giamundo@atp.sa.it

Phone: (811) 948-7131 **Fax:**

Physical Address: **Mailing Address:**

via Campa 34

via Campa 34

ITALY

ITALY

QC Plan Status: Quality Control Plan ACCEPTED 11/4/2016

#03 GFRP BAR Glass Fiber Reinforced Polymer Reinforcing for Concrete, #3

#04 GFRP

#05 GFRP

#06 GFRP

#08 GFRP

FRP-14 TUF-BAR INC (ONTARIO CANADA)

Company: Tuf-Bar Inc.

Contact: Jay Christopher **Email:** jay@tufbarcanada.com

Phone: (519) 833-5050 **Fax:**

Physical Address: **Mailing Address:**

7 Erin Park Dr

7 Erin Park Dr

CANADA

CANADA

QC Plan Status: Quality Control Plan ACCEPTED 12/11/2017

Session 1: **FRP Rebar Acceptance**

At least five Canadian GFRP bar manufacturers qualified their products in accordance with ***CAN/CSA S807*** and obtained approvals from end-users and government authorities (such as MTO and MTQ):

- B&B FRP Manufacturing, Inc. (MSTBAR)
- BP Composites, Inc. (TUF-BAR) *
- Fiberline Composites Canada, Inc. (COMBAR)
- Pultrall, Inc. (V-ROD) *
- Tempcorp, Inc. (TEMBAR)

** Also approved for FDOT use.*

Other reputable manufactures supply North America:

USA: Marshall Composite Technologies Inc. (C-BAR); Composite Rebar Technologies Inc. (CRT); Basalt World (No Rust Rebar); Owens Corning (ASLAN formally Hughes Brothers Inc.)*

Europe: FiReP International AG (Switzerland), Asamer (Austria), Magmatech Ltd (United Kingdom); Sireg; ATP (Italy)*

Elsewhere: Galen (Russia); Pultron Composites Ltd. (MATEENBAR, NZ and Dubia)*

Session 1: **FRP Rebar Acceptance**

Qualification Tests per GFRP Bar Size *(FDOT Spec 932; CSA S807-10)*

1. Tensile Strength & Modulus at room temp.: *15*, 24 samples*
2. Tensile Strength & Modulus at cold temp.: *n/a, 24 samples*
3. Fiber Content: *15*, 9 samples*
4. Bond Strength: *15, 24 samples*
5. Transverse Shear Strength: *15, 24 samples*
6. Strength of bent bars: *15*, 24 samples*
7. Transverse Coeff. Thermal Expansion: *n/a, 9 samples*
8. Void Content: *n/a, 9 samples*
9. Water Absorption: *15*, 15 samples*
10. Cure Ratio/Polymerization: *9*, 15 samples*
11. Glass Transition Temperature: *9*, 15 samples*
12. Alkaline Resistance without/load: *15, 24 samples*
13. Alkaline Resistance with/load: *15, 24 samples*
14. Creep Rupture: *n/a, 24 samples*

** FDOT project level testing @ 3 per bar size*

Session 1: FRP Rebar Product Development

Development of FRP Bar Solutions in North America

- GFRP Bars
- CFRP Bars
- GFRP & CFRP Stirrups
- GFRP & CFRP Spirals & Hoops
- GFRP Bent Bars
- GFRP Headed Bars
- GFRP Dowels
- GFRP Adhesive Anchors
- BFRP Bars (recently)

Session 1: FRP Rebar Product Development

Grades of FRP Bars in Canada

(CAN CSA S807-10)

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Table 2
Grades of FRP bars and grids corresponding to their minimum modulus of elasticity, GPa
(See Clause 8.3 and Table 3)

	Grade I		Grade II		Grade III	
Designation	Individual bars	Bars in a grid	Individual bars	Bars in a grid	Individual bars	Bars in a grid
AFRP	50	40	70	60	90	80
CFRP	80	70	110	100	140	130
GFRP	40	30	50	40	60	50

Session 1: FRP Rebar Product Development

Grades of FRP Bars in Florida *(FDOT Spec 932-3, similar to ASTM D7957)*

Table 3-1
Sizes and Tensile Loads of FRP Reinforcing Bars

Bar Size Designation	Nominal Bar Diameter (in)	Nominal Cross Sectional Area (in²)	Measured Cross-Sectional Area (in²)		Minimum Guaranteed Tensile Load (kips)	
			Minimum	Maximum	*BFRP and* GFRP Bars	CFRP Bars
2	0.250	0.049	0.046	0.085	6.1	10.3
3	0.375	0.11	0.104	0.161	13.2	20.9
4	0.500	0.20	0.185	0.263	21.6	33.3
5	0.625	0.31	0.288	0.388	29.1	49.1
6	0.750	0.44	0.415	0.539	40.9	70.7
7	0.875	0.60	0.565	0.713	54.1	-
8	1.000	0.79	0.738	0.913	66.8	-
9	1.128	1.00	0.934	1.137	82.0	-
10	1.270	1.27	1.154	1.385	98.2	-

$E_f \geq 6{,}500$ ksi $E_f \geq 18{,}000$ ksi

Session 1: FRP Rebar Product Development

Improving Properties of FRP Bars in North America

<u>Glass FRP Bars</u> (High Modulus and High Strength)

1. *Guaranteed Tensile Strength up to 175 ksi (1,200 MPa)*
2. *Modulus of Elasticity up to 9,000 ksi (60 GPa)*

Session 1: FRP Rebar Product Development

Improving FRP Bars in North America

Carbon FRP Bars:

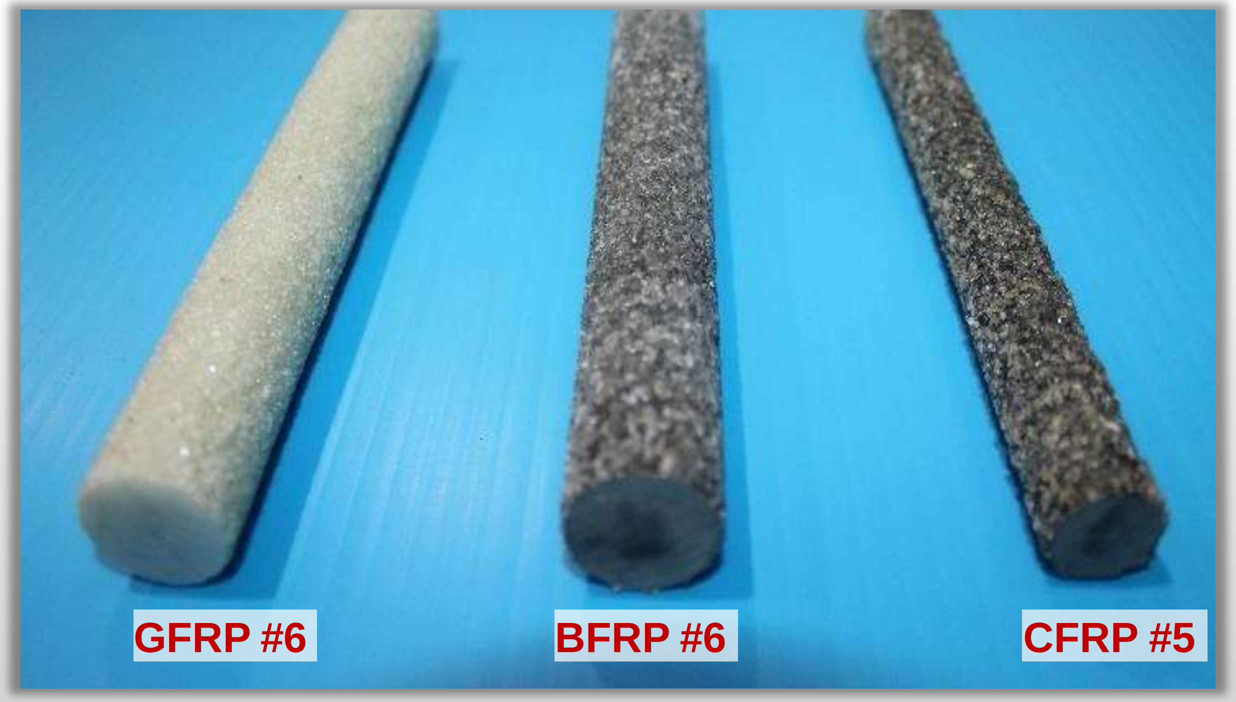
1. *Guaranteed Tensile Strength up to 290 ksi (2,000 MPa)*
2. *Modulus of Elasticity up to 20,000 ksi (135 GPa)*

Session 1: FRP Rebar Product Development

Improving FRP Bars in North America

Basalt FRP Bars (High Modulus and High Strength)

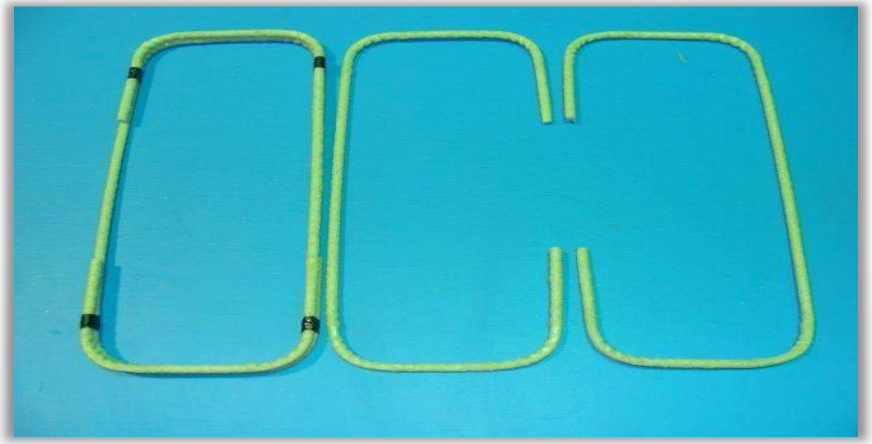
1. *Guaranteed Tensile strength up to 200 ksi (1400 MPa)*
2. *Modulus of elasticity up to 9,000+ ksi (64-75 GPa)*



Session 1: FRP Rebar Product Development

Bent Bars & Complex Shapes in North America

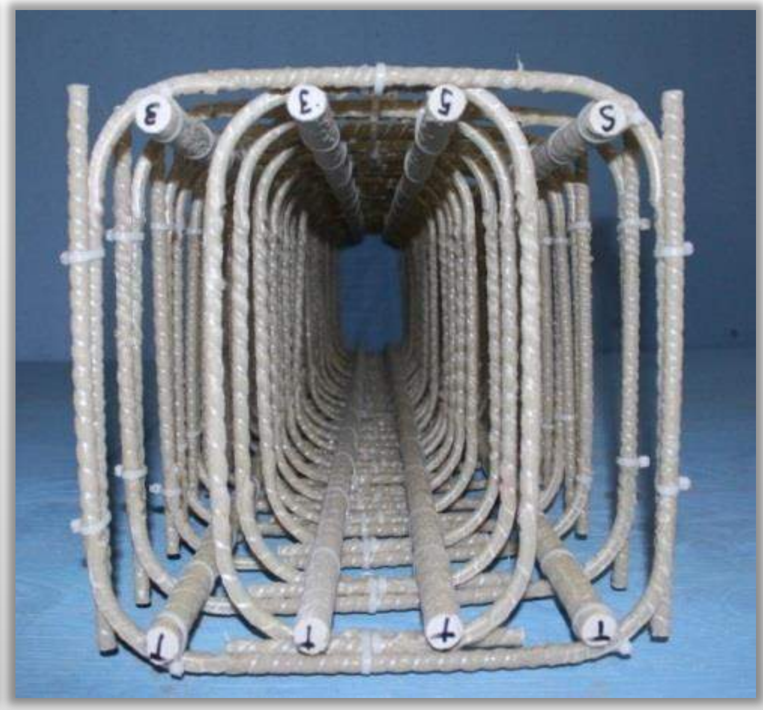
FRP Stirrups

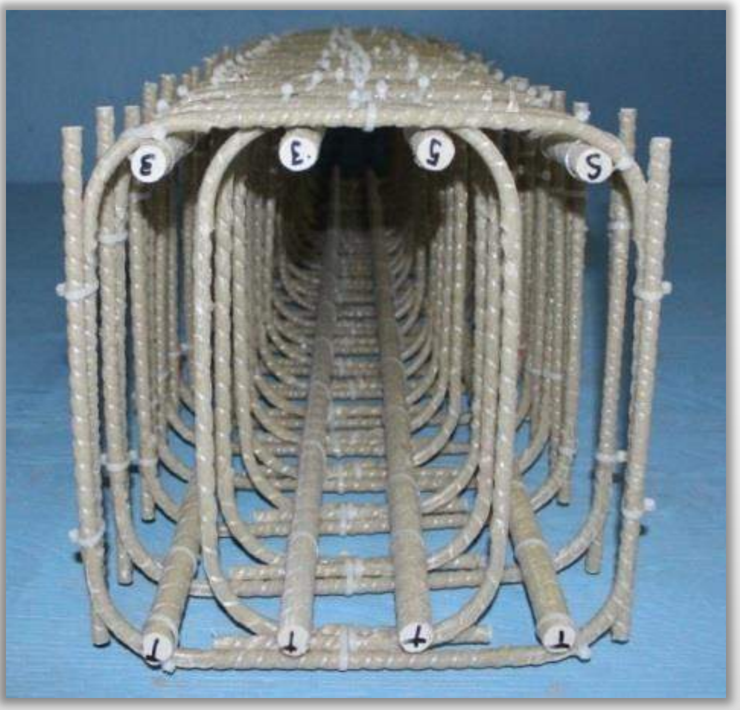


Session 1: FRP Rebar Product Development

Bent Bars & Complex Shapes in North America

FRP Ties

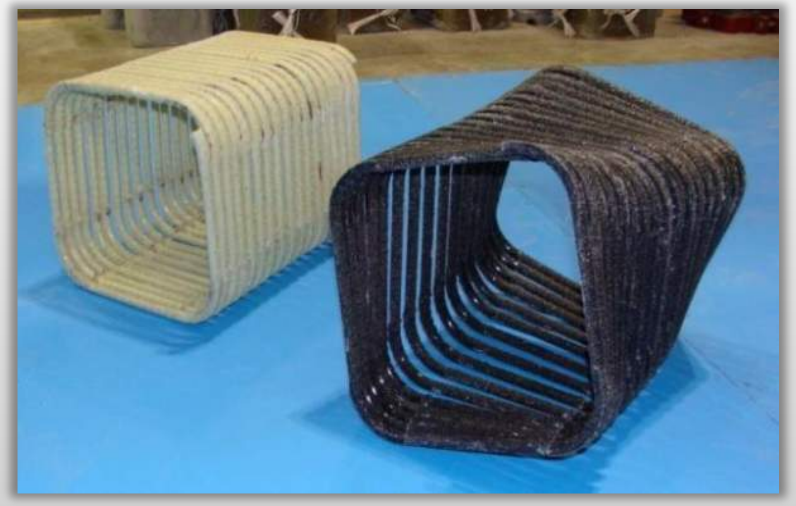




Session 1: FRP Rebar Product Development

Bent Bars & Complex Shapes in North America

FRP Spirals and Hoops



Session 1: FRP Rebar Product Development

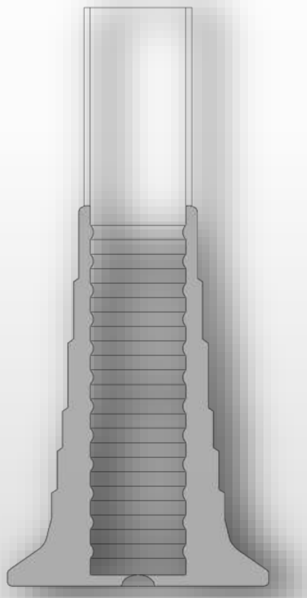
Bent Bars in North America

GFRP Bent Bars

Session 1: FRP Rebar Product Development

Other FRP Solutions in North America

Glass FRP Headed bars



Session 1:

End of Part 1

Questions

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