

STATEOFTENNESSEE

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Supplemental Specifications - Section 500
of the
Standard Specifications for Road and Bridge Construction
March 1, 2006

Subsection 501.03, Remove and Replace the entire subsection with the following:

501.03-Propportioning and Quality Assurance of Concrete.

A. Proportioning :

The Contractor shall submit the proposed concrete design to the Engineer for approval. The design shall be determined using saturated surface dry aggregate weights and shall be verified by the use of trial batches meeting the requirements of these specifications. The concrete design shall be prepared by a TDOT certified Class 3 concrete plant technician, or by an approved independent testing laboratory under the direction of a registered professional civil Engineer, licensed by the State of Tennessee. The concrete plant technician or the Civil Engineer shall certify that the information contained on the design is correct and is the result of information gained from the trial batches. Trial batches for design, including admixtures in the proper proportion, shall be built no more than 90 days prior to the design submittal. All cost of concrete design, preparation and submittal shall be the responsibility of the Contractor.

The concrete design shall be air entrained and produce a workable concrete mix meeting the following design and production parameters:

CLASS CP - PAVING CONCRETE

28 day Compressive strength, min. (PSI)	Minimum cementitious content (pounds per CY)	Maximum Water/cement ratio (lb/lb)	Air Content (%)	(inch)
3000	526 ¹ 545 ²	0.49	5% design 3-8 % production	0-2.0 ³ 3±1 ⁴

¹-526 lbs required when the coarse aggregate is crushed stone

²-545 lbs required when the coarse aggregate is gravel

³-Allowable slump for slipform paving

⁴-Allowable slump for other than slipform paving

Chemical Admixtures shall be included in the concrete mixture as specified in the following table based on the ambient air temperature and expected weather conditions.

Class of Concrete	Temperature less than 85° F(30 ° C) and falling	Temperature 85° F(30° C) or greater and rising
CP	Type A or Type F	Type D or Type G

Admixtures to be incorporated into the concrete shall all be from the same manufacturer, shall be incorporated into the concrete in accordance with the manufacturer's recommendations, subject to approval by the Engineer.

The proposed concrete design submittal shall contain as a minimum the following information:

- Source of all aggregate
- Brand and type of cement
- Source and class of fly ash (if used)
- Source and grade of ground granulated blast furnace slag (if used)
- Specific gravity of cement
- Specific gravity of fly ash (if used)
- Specific gravity of ground granulated blast furnace slag (if used)
- Admixtures (if used)
- Gradation of aggregates
- Specific gravities of aggregates (saturated surface dry)
- Air content (if air entrainment is used)
- Percentage of fine aggregate of the total aggregate (by volume)
- Slump
- Weight per cubic yard(m³)
- Yield
- Temperature of plastic concrete
- Water/cement ratio lb./lb.(kg/kg)
- 7 day compressive strength [minimum of 3 x 6-in. x12in. (150mm x 300mm) cylinders]
- 14 day compressive strength [minimum of 3 x-6in. x12in.(150 x 300 mm) cylinders]
- 28 day compressive strength [minimum of 3 x-6in. x12in.(150mm x 300mm) cylinders]
- Weight of each material required to produce a yd³(m³) of concrete

In lieu of the above mix design submittal, the Contractor may submit for approval to use an existing design (Contractor or Department prepared) approved by the Department within the current calendar year. The approval of this concrete design submittal will not relieve the Contractor of the responsibility of providing concrete meeting the requirements of these specifications. A temporary mix design may be issued if the 7 day compressive strengths exceed the required 28 day strengths.

If materials from sources other than those shown on the approved concrete design are to be used, the Contractor must submit and obtain approval of a concrete design showing these sources. No concrete shall be accepted with materials that are not shown on an approved concrete design.

In addition to the option to use Type I-SM cement, the contractor may have the option to replace a portion of Type I cement in Portland cement concrete, up to a maximum specified herein, with fly ash and/or ground granulated blast furnace slag. It is the Contractors responsibility, if he chooses to use fly ash and/or ground granulated blast furnace slag as a partial cement replacement, to provide Portland cement concrete of the design strengths specified in all applicable special provisions, on the plans, or in the standard specifications. Type I-SM cement or Type I cement with fly ash or ground granulated blast furnace slag as a partial cement replacement will not be used in concrete when high early strength is specified. When the Contractor elects to replace a portion of Type I cement with fly ash and/or ground granulated blast furnace slag, the following requirements must be verified prior to producing any Portland cement concrete:

1. Fly ash or ground granulated blast furnace slag shall be stored in silos separate from each other and separate from the Type I cement.
2. The fly ash or ground granulated blast furnace slag is to be added to the concrete by methods and equipment approved by the Engineer, capable of uniformly distributing the materials throughout the mix.
3. The fly ash or ground granulated blast furnace slag may be weighed cumulatively in the weigh hopper with the cement, provided the cement is added first. The temperature of the fly ash or the ground granulated blast furnace slag is not to exceed 160° F(71° C) at the time of introduction to the mix.
4. The mix shall be closely monitored to maintain a consistent air content between 3%and 8%.

Additional testing may be required to verify desired properties of Portland cement concrete with fly ash or ground granulated blast furnace slag. Additional compensation for the expense and/or lost production due to the additional testing will not be allowed the Contractor. The following are examples of additional testing that may be required:

1. Additional air test as felt necessary by the Engineer to monitor the entrained air due to fluctuations in LOI and fineness of the fly ash or ground granulated blast furnace slag material.
2. Additional compressive test specimens may be needed to determine strengths for form removal due to the slowed strength development inherent with fly ash or ground granulated blast furnace slag concrete.

Design of Portland cement concrete with Type I cement modified by the addition of fly ash or ground granulated blast furnace slag. The following table indicates that maximum cement replacement rates (by weight) and minimum substitution ratios(by weight) for the type of modifier specified:

Modifier	Cement Replacement Rate(Maximum)% (by weight)	Minimum Cement Substitution Rates (by weight)
Ground Granulated Blast Furnace Slag(GGBFS) (grade 100 or 120)	35.0	1:1
Class "F" Fly Ash	20.0	1:1
Class "C" Fly Ash	25.0	1:1

Ternary cementitious mixtures (mixtures with portland cement, GGBFS, and fly ash) will be allowed for Class CP Concrete provided that the minimum portland cement content is 50%. The maximum amount of fly ash substitution in a ternary blend will be 20%. Substitution rates will be at a 1:1 ratio.

Any request for a change in source of materials or admixtures from the original mix design must be made in writing to the Regional Materials and Tests Engineer explaining the necessity for the change and must be accompanied by a new mix design in accordance with the above provisions. No concrete shall be placed until the new design is approved.

When requested by the Contractor and approved by the Engineer, Class A Concrete for structures, as provided for under **Section 604** and herein modified, will be permitted for use in variable width sections, ramps, and on projects containing 10,000 yd²(m²) of concrete pavement or less. The slump shall be modified to be a maximum of 3 in.(75 mm) and the compressive strength of cylindrical specimens molded, cured and tested in an approved laboratory shall be not less than 3,000 psi(20.7 MPa) in 28 days. No additional payment will be made to the Contractor for increased costs due to the use of the above mixture.

The mix proportions approved by the Department shall govern during the progress of the work, except the Contractor shall make the following adjustments with the approval of the Engineer:

- (a) If the cement content of the concrete varies by more than 2% from the designated value, as determined by AASHTO T 121, the proportions will be so adjusted as to maintain a cement content which does not vary more than 2% from the designated value.
- (b) If it is found impossible to obtain concrete of the desired plasticity and workability with the proportions originally designed, changes will be made in aggregate weights as required, provided that in no case shall the cement content originally designated be changed except as provided in paragraphs (c), (d) and (e).
- (c) If it is found impossible to produce concrete having the required consistency without exceeding the maximum allowable water-cement ratio specified, the cement content shall be increased so that the maximum allowable water-cement ratio will not be exceeded.

- (d) If for any reason the concrete must be placed by hand methods and the water-cement ratio established for the vibrated concrete cannot be maintained, the mix proportions shall be adjusted for placement by hand methods and the cement proportion increased by 38 lbs per cubic yard(22 kgs per m³), or more if necessary in order to maintain the water-cement ratio established for the vibrated concrete. No additional payment will be made to the Contractor for the cost of the additional cement.
- (e) Change the mix proportions because of a change in the character or source of materials.
- (f) Change the mix proportions or mixing procedure in order to maintain the air content within the specified limits.
- (g) Change the mix proportions made necessary by the use of retarders or other chemical additives that may be required or approved.

B. Quality Control and Acceptance of Concrete:

It shall be the responsibility of the Contractor to determine and measure the batch quantities of all ingredients (including all water and any specified or approved admixtures) for all concrete produced for the project and to mix, deliver and place the concrete so that the concrete meets the requirements of these specifications. The minimum size of a batch shall be 2.5 cubic yards(2.0 m³). Sampling, testing and inspection for process control of the concrete at the concrete plant shall be performed by a TDOT Class 2 or higher concrete plant technician certified by the Department. This technician must be present at the concrete plant during all batching operations for the project and his primary responsibility during production shall be process control. Sampling, testing and inspection for process control of the concrete at the placement site shall be performed by a concrete technician that holds a TDOT Class 1, ACI Class 1, or higher certification. A technician shall be present at each placement site during all concrete placement. All necessary equipment required for process control shall be furnished by the Contractor and shall be at the plant and at the placement site at all times during concrete placement. Process control shall include, but not be limited to, the following tests and inspections:

1. Test to determine aggregate gradations (AASHTO T 27 with AASHTO T 11 when required).
2. Frequent inspections of the stockpile to ascertain that stockpiles are being maintained in an uncontaminated and unsegregated manner. A current aggregate quality report shall be kept at the plant.
3. Calibration of weighing systems, water meters and admixture dispensing systems prior to starting production.
4. Assurance of accurate weighing of the aggregates and cement, the proper metering of water and admixtures and the quality of water.
5. Assurance that mixing equipment is in proper working condition and the proper mixing speeds and revolutions are controlled as required by the specifications and the Materials and Tests Circular Letter File book.
6. Adjustment of mix proportions due to moisture content of both coarse and fine aggregates (moisture determination to be in accordance with AASHTO T 255).
7. Slump (AASHTO T 119) and Air Test (AASHTO T 152).

8. Yield test (AASHTO T 121) (When yield varies more than $\pm 2\%$ from that shown on the design. All batching operations shall cease until the problem has been identified and corrected or a new concrete design has been obtained.
9. Quality control cylinders and early break cylinders (7-14 day, etc), for compression tests in accordance with AASHTO T 22.
10. Tests for concrete and ambient air temperatures.
11. A report furnished daily to the Engineer showing all pertinent information (Date, Contract and Project, Item number(s), batch weights, moisture corrections, admixtures, slump, air content, temperatures, etc.). A sample daily report will be given to the Contractor as an example.
12. A concrete delivery ticket must accompany each load to the placement site. The ticket shall at a minimum include the following:

Date
Contract number
County
Class of concrete
Concrete design number
Number of cubic yards
Load number
Truck number
Maximum water allowed by design
Total water added at the plant
Maximum water allowed to be added on the project
Actual water added on project
Number of revolutions at mixing speed at plant
Number of revolutions at mixing speed at project
Time loaded
Time discharged
Actual and target batch weights of each component including each aggregate, chemical admixture and mineral admixture used.

The Contractor shall develop for approval of the Engineer and maintain at the plant written procedures for sampling, testing and inspection of the concrete. The Contractor shall keep a record of all tests and inspections performed at the plant site and placement site, and this documentation, together with a certification by the Contractor that the concrete incorporated in the work meets the requirements of the specifications, shall be delivered to the Engineer upon completion of the project for inclusion in the project records. Records shall be kept current and shall be made available to the Engineer for review at any time.

It shall be the responsibility of the Contractor to properly make, cure and transport all early break cylinders (7-14 day, etc.) in accordance with AASHTO T 23 and delivered to the Regional laboratory or other established satellite laboratories for tests.

The Department or their representative shall be responsible for performing all acceptance tests. A TDOT Level 1 Certified or ACI Certified Technician shall sample, test air content and slump, and prepare 28 day cylinders for acceptance. The Department shall also be responsible for properly curing and transporting all acceptance cylinders in accordance with AASHTO T 23.

All independent assurance sampling and testing shall be performed by the Department. All sampling and testing for acceptance and independent assurance shall be at the frequencies established in TDOT Procedures. The time and location for obtaining all acceptance and assurance samples will be determined by the Department.

It shall be the responsibility of the Contractor to provide cylinder molds, a wheelbarrow, and provide a level site to perform testing and for initial curing. The Contractor shall also provide a secure storage shed/building for temporary storage of concrete acceptance cylinders in accordance with **Subsection 722.09** of these Specifications.

A TDOT certified class 2 or higher concrete technician, whose duty is process control, shall be at the ready-mix plant during all batching operations. A TDOT or ACI certified class 1 or higher technician is not required to be at the placement site during all small quantity placing operations but is required to perform one complete set of tests during the life of the project. A delivery ticket must accompany each load delivered to the job site.

Batch weights shall be corrected to compensate for any surface moisture on the aggregate at the time of use. The Contractor may elect to withhold some of the water from the mix at the plant provided the delivery ticket indicates the amount of water withheld. If a portion of the water is withheld at the plant, additional water may be added at the work site provided the design water/cement ratio of the mix is not exceeded.

Subsection 501.09, Revise the fifth paragraph to the following:

The tolerance of the individual quantity of each cementitious material shall be no less than 1% nor no more than 4% of the required weight. Aggregates shall be weighed within a tolerance of 1.5% of the required weight.

Subsection 501.17, 2nd full paragraph on page 321, Change the first sentence from "When the pavement being constructed abuts an adjacent pavement" TO:

When the pavement being constructed longitudinally abuts an adjacent pavement