

SECTION 03300

CAST-IN-PLACE CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section specifies cast-in place concrete, including formwork, reinforcing, mix design, placement procedures, and finishes.
- B. Cast-in-place concrete includes the following:
 - 1. Foundations and footings.
 - 2. Slabs-on-grade.
 - 3. Fill for steel deck.
 - 4. Foundation walls.
 - 5. Equipment pads and bases.
- C. Related Sections: The following Sections contain requirements that relate to this Section:
 - 1. Division 2 Section "Portland Cement Concrete Paving" for concrete paving and walks.
 - 2. Division 3 Section "Architectural Cast-in-Place Concrete Formwork".
 - 3. Division 5 Section "Steel Deck" for steel deck construction.

1.3 SUBMITTALS

- A. General: Submit the following according to Conditions of the Contract and Division 1 Specification Sections.

- B. Product data for proprietary materials and items, including reinforcement and forming accessories, admixtures, patching compounds, waterstops, joint systems, curing compounds, dry-shake finish materials, and others if requested by Contracting Officer.
- C. Shop drawings for reinforcement detailing fabricating, bending, and placing concrete reinforcement. Comply with ACI 315 "Manual of Standard Practice for Detailing Reinforced Concrete Structures" showing bar schedules, stirrup spacing, bent bar diagrams, and arrangement of concrete reinforcement. Include special reinforcing required for openings through concrete structures.
- D. Samples of materials as requested by Contracting Officer, including names, sources, and descriptions, as follows:
 - 1. Normal weight aggregates.
 - 2. Reglets.
 - 3. Waterstops.
 - 4. Vapor retarder/barrier.
 - 5. Form liners.
- E. Laboratory test reports for concrete materials and mix design test.
- F. Material certificates in lieu of material laboratory test reports when permitted by Contracting Officer. Material certificates shall be signed by manufacturer and Contractor, certifying that each material item complies with or exceeds specified requirements. Provide certification from admixture manufacturers that chloride content complies with specification requirements.

1.4 QUALITY ASSURANCE

- A. Codes and Standards: Comply with provisions of the following codes, specifications, and standards, except where more stringent requirements are shown or specified:
 - 1. American Concrete Institute (ACI) 301, "Specifications for Structural Concrete for Buildings."
 - 2. ACI 318, "Building Code Requirements for Reinforced Concrete."
 - 3. Concrete Reinforcing Steel Institute (CRSI) "Manual of Standard Practice."

- B. Concrete Testing Service: Employ a testing agency acceptable to Contracting Officer to perform material evaluation tests and to design concrete mixes.
- C. Materials and installed work may require testing and retesting at any time during progress of Work. Tests, including retesting of rejected materials for installed Work, shall be done at Contractor's expense.

PART 2 - PRODUCTS

2.1 REINFORCING MATERIALS

- A. Reinforcing Bars: ASTM A 615, Grade 60, or Grade 40, deformed as noted on drawings.
- B. Steel Wire: ASTM A 82, plain, cold-drawn steel.
- C. Welded Wire Fabric: ASTM A 185, welded steel wire fabric.
- D. Supports for Reinforcement: Bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire fabric in place. Use wire bar-type supports complying with CRSI specifications.
 - 1. For slabs-on-grade, use supports with sand plates or horizontal runners where base material will not support chair legs.
 - 2. For exposed-to-view concrete surfaces where legs of supports are in contact with forms, provide supports with legs that are protected by plastic (CRSI, Class 1) or stainless steel (CRSI, Class 2).

2.2 CONCRETE MATERIALS

- A. Portland Cement: ASTM C 150, Type I. Use one brand of cement throughout Project unless otherwise acceptable to Architect.
- B. Fly Ash: ASTM C 618, Type F.
- C. Normal-Weight Aggregates: ASTM C 33 and as specified. Provide aggregates from a single source for exposed concrete.
 - 1. For exposed exterior surfaces, do not use fine or coarse aggregates that contain substances that cause spalling.
 - 2. Local aggregates not complying with ASTM C 33 that have been shown to

produce concrete of adequate strength and durability by special tests or actual service may be used when acceptable to Contracting Officer.

- D. Water: Potable.
- E. Admixtures, General: Provide concrete admixtures that contain not more than 0.1 percent chloride ions.
- F. Air-Entraining Admixture: ASTM C 260, certified by manufacturer to be compatible with other required admixtures.
 - 1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:
 - 2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Air-Tite, Cormix Construction Chemicals.
 - b. Air-Mix or Perma-Air, Euclid Chemical Co.
 - c. Darex AEA or Daravair, W.R. Grace & Co.
 - d. MB-VR or Micro-Air, Master Builders, Inc.
 - e. Sealtight AEA, W.R. Meadows, Inc.
 - f. Sika AER, Sika Corp.
- G. Water-Reducing Admixture: ASTM C 494, Type A.
 - 1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:
 - 2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Chemtard, ChemMasters Corp.
 - b. PSI N, Cormix Construction Chemicals.
 - c. Eucon WR-75, Euclid Chemical Co.
 - d. WRDA, W.R. Grace & Co.
 - e. Pozzolith Normal or Polyheed, Master Builders, Inc.
 - f. Metco W.R., Metalcrete Industries.
 - g. Prokrete-N, Prokrete Industries.
 - h. Plastocrete 161, Sika Corp.
- H. High-Range Water-Reducing Admixture: ASTM C 494, Type F or Type G.
 - 1. Available Products: Subject to compliance with requirements, products that

may be incorporated in the Work include, but are not limited to, the following:

2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Super P, Anti-Hydro Co., Inc.
 - b. Cormix 200, Cormix Construction Chemicals.
 - c. Eucon 37, Euclid Chemical Co.
 - d. WRDA 19 or Daracem, W.R. Grace & Co.
 - e. Rheobuild or Polyheed, Master Builders, Inc.
 - f. Superslump, Metalcrete Industries.
 - g. PSPL, Prokrete Industries.
 - h. Sikament 300, Sika Corp.
- I. Water-Reducing, Accelerating Admixture: ASTM C 494, Type E.
1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:
 2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Q-Set, Conspec Marketing & Manufacturing Co.
 - b. Lubricon NCA, Cormix Construction Chemicals.
 - c. Accelguard 80, Euclid Chemical Co.
 - d. Daraset, W.R. Grace & Co.
 - e. Pozzutec 20, Master Builders, Inc.
 - f. Accel-Set, Metalcrete Industries.
- J. Water-Reducing, Retarding Admixture: ASTM C 494, Type D.
1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:
 2. Products: Subject to compliance with requirements, provide one of the following:
 - a. PSI-R Plus, Cormix Construction Chemicals.
 - b. Eucon Retarder 75, Euclid Chemical Co.
 - c. Daratard-17, W.R. Grace & Co.
 - d. Pozzolith R, Master Builders, Inc.
 - e. Protard, Prokrete Industries.
 - f. Plastiment, Sika Corporation.

2.3 RELATED MATERIALS

- A. Reglets: Where sheet flashing or bituminous membranes are terminated in reglets, provide reglets of not less than 0.0217-inch-thick (26-gage) galvanized sheet steel. Fill reglet or cover face opening to prevent intrusion of concrete or debris.
- B. Dovetail Anchor Slots: Hot-dip galvanized sheet steel, not less than 0.0336 inch thick (22 gage) with bent tab anchors. Fill slot with temporary filler or cover face opening to prevent intrusion of concrete or debris.
- C. Waterstops: Provide preformed plastic adhesive waterstops at construction joints and other joints as indicated. Manufacturers offering products that may be incorporated in the Work include, but are not limited to, the following: Subject to compliance with requirements, provide products of one of the following:
 - 1. American Colloik Company
 - 2. Synko-flex Products, Inc.
- D. Sand Cushion: Clean, manufactured or natural sand.
- E. Vapor Retarder: Provide vapor retarder that is resistant to deterioration when tested according to ASTM E 154, as follows: Polyethylene sheet not less than 6 mils thick.
- F. Absorptive Cover: Burlap cloth made from jute or kenaf, weighing approximately 9 oz. per sq. yd., complying with AASHTO M 182, Class 2.
- G. Moisture-Retaining Cover: One of the following, complying with ASTM C 171.
 - 1. Waterproof paper.
 - 2. Polyethylene film.
 - 3. Polyethylene-coated burlap.
- H. Liquid Membrane-Forming Curing Compound: Liquid-type membrane-forming curing compound complying with ASTM C 309, Type I, Class A. Moisture loss not more than 0.55 kg/sq. meter when applied at 200 sq. ft./gal.
 - 1. Provide material that has a maximum volatile organic compound (VOC) rating of 350 mg per liter.
 - 2. Available Products: Subject to compliance with requirements, products that

may be incorporated in the Work include, but are not limited to, the following:

3. Products: Subject to compliance with requirements, provide one of the following:
 - a. A-H 3 Way Sealer, Anti-Hydro Co., Inc.
 - b. Spartan-Cote, The Burke Co.
 - c. Conspec #1, Conspec Marketing & Mfg. Co.
 - d. Sealco 309, Cormix Construction Chemicals.
 - e. Day-Chem Cure and Seal, Dayton Superior Corp.
 - f. Eucocure, Euclid Chemical Co.
 - g. Horn Clear Seal, A.C. Horn, Inc.
 - h. L&M Cure R, L&M Construction Chemicals, Inc.
 - i. Masterkure, Master Builders, Inc.
 - j. CS-309, W.R. Meadows, Inc.
 - k. Seal N Kure, Metalcrete Industries.
 - l. Kure-N-Seal, Sonneborn-Chemrex.
 - m. Stontop CS2, Stonhard, Inc.

I. Water-Based Acrylic Membrane Curing Compound: ASTM C 309, Type I, Class B.

1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:
2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Highseal, Conspec Marketing and Mfg. Co.
 - b. Sealco - VOC, Cormix Construction Chemicals.
 - c. Safe Cure and Seal, Dayton Superior Corp.
 - d. Aqua-Cure, Euclid Chemical Co.
 - e. Dress & Seal WB, L&M Construction Chemicals, Inc.
 - f. Masterkure 100W, Master Builders, Inc.
 - g. Vocomp-20, W.R. Meadows, Inc.
 - h. Metcure, Metalcrete Industries.
 - i. Stontop CS1, Stonhard, Inc.

J. Evaporation Control: Monomolecular film-forming compound applied to exposed concrete slab surfaces for temporary protection from rapid moisture loss.

1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:

2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Aquafilm, Conspec Marketing and Mfg. Co.
 - b. Eucobar, Euclid Chemical Co.
 - c. E-Con, L&M Construction Chemicals, Inc.
 - d. Confilm, Master Builders, Inc.
 - e. Waterhold, Metalcrete Industries.

K. Bonding Agent: Polyvinyl acetate or acrylic base.

1. Available Products: Subject to compliance with requirements, products that may be incorporated in the Work include, but are not limited to, the following:
2. Products: Subject to compliance with requirements, provide one of the following:
 - a. Polyvinyl Acetate (Interior Only):
 - 1) Superior Concrete Bonder, Dayton Superior Corp.
 - 2) Euco Weld, Euclid Chemical Co.
 - 3) Weld-Crete, Larsen Products Corp.
 - 4) Everweld, L&M Construction Chemicals, Inc.
 - 5) Herculox, Metalcrete Industries.
 - 6) Ready Bond, Symons Corp.
 - b. Acrylic or Styrene Butadiene:
 - 1) Acrylic Bondcrete, The Burke Co.
 - 2) Strongbond, Conspec Marketing and Mfg. Co.
 - 3) Day-Chem Ad Bond, Dayton Superior Corp.
 - 4) SBR Latex, Euclid Chemical Co.
 - 5) Daraweld C, W.R. Grace & Co.
 - 6) Hornweld, A.C. Horn, Inc.
 - 7) Everbond, L&M Construction Chemicals, Inc.
 - 8) Acryl-Set, Master Builders Inc.
 - 9) Intralok, W.R. Meadows, Inc.
 - 10) Acrylpave, Metalcrete Industries.
 - 11) Sonocrete, Sonneborn-Chemrex.
 - 12) Stonlock LB2, Stonhard, Inc.
 - 13) Strong Bond, Symons Corp.

2.4 PROPORTIONING AND DESIGNING MIXES

- A. Prepare design mixes for each type and strength of concrete by either laboratory trial batch or field experience methods as specified in ACI 301. For the trial batch method, use an independent testing agency acceptable to Contracting Officer for preparing and reporting proposed mix designs.
 - 1. Do not use the same testing agency for field quality control testing.
 - 2. Limit use of fly ash to not exceed 25 percent of cement content by weight.
- B. Submit written reports to Contracting Officer of each proposed mix for each class of concrete at least 15 days prior to start of Work. Do not begin concrete production until proposed mix designs have been reviewed by Contracting Officer.
- C. Design mixes to provide normal weight concrete with the following properties as indicated on drawings and schedules:

psi @ 28 days	water/cement ration (non air-entrained)	water/cement ratio (air-entrained)
6000	0.41	-----
5000	0.48	0.40
4000	0.57	0.48
3000	0.68	0.59
2000	0.82	0.74

- D. Water-Cement Ratio: Provide concrete for following conditions with maximum water-cement (W/C) ratios as follows:
 - 1. Subjected to freezing and thawing: water/cement ration 0.45.
 - 2. Subjected to de-icers/watertight: water/cement ration 0.40.
 - 3. Subjected to brackish water, salt spray, or de-icers: water/cement ratio 0.40.
- E. Slump Limits: Proportion and design mixes to result in concrete slump at point of placement as follows:
 - 1. Ramps, slabs, and sloping surfaces: Not more than 3 inches.
 - 2. Reinforced foundation systems: Not less than 1 inch and not more than 3 inches.
 - 3. Concrete containing high-range water-reducing admixture (superplasticizer): Not more than 8 inches after adding admixture to site-verified 2-to-3-inch slump concrete.

4. Other concrete: Not more than 4 inches.
- F. Design Concrete to provide the strengths indicate for each application:
- | | | |
|----|---|--|
| 1. | Caisson/Piers | 3000 psi (Section 02380) |
| 2. | Paving, sidewalks & exterior slab-on-grade | 3000 psi Air-entrained (Section 02520). |
| 3. | Aircraft parking | 700 psi Flexural Strength Air-entrained(Section 02521) |
| 4. | Grade Beams/Pedestal | 4000 psi |
| 5. | Slab-on-grade (interior)
(Note: Concrete strength indicated is compressive strength unless noted otherwise.) | 4000 psi |
- G. Adjustment to Concrete Mixes: Mix design adjustments may be requested by Contractor when characteristics of materials, job conditions, weather, test results, or other circumstances warrant, as accepted by Architect. Laboratory test data for revised mix design and strength results must be submitted to and accepted by Architect before using in Work.

2.5 ADMIXTURES

- A. Use water-reducing admixture or high-range water-reducing admixture (superplasticizer) in concrete, as required, for placement and workability.
- B. Use accelerating admixture in concrete slabs placed at ambient temperatures below 50 deg F (10 deg C).
- C. Use high-range water-reducing admixture in pumped concrete, concrete for heavy-use industrial slabs, architectural concrete, parking structure slabs, concrete required to be watertight, and concrete with water-cement ratios below 0.50.
- D. Use air-entraining admixture in exterior exposed concrete unless otherwise indicated. Add air-entraining admixture at manufacturer's prescribed rate to result in concrete at point of placement having total air content with a tolerance of plus or minus 1-1/2 percent within the following limits: Concrete structures and slabs exposed to freezing and thawing, de-icer chemicals, or hydraulic pressure:
1. 4.5 percent (moderate exposure); 5.5 percent (severe exposure) for 1-1/2-inch maximum aggregate.

2. 4.5 percent (moderate exposure); 6.0 percent (severe exposure) for 1-inch maximum aggregate.
 3. 5.0 percent (moderate exposure); 6.0 percent (severe exposure) for 3/4-inch maximum aggregate.
 4. 5.5 percent (moderate exposure); 7.0 percent (severe exposure) for 1/2-inch maximum aggregate.
- E. Use admixtures for water reduction and set accelerating or retarding in strict compliance with manufacturer's directions.

2.6 CONCRETE MIXING

- A. Job-Site Mixing: Mix concrete materials in appropriate drum-type batch machine mixer. For mixers of 1 cu. yd. or smaller capacity, continue mixing at least 1-1/2 minutes, but not more than 5 minutes after ingredients are in mixer, before any part of batch is released. For mixers of capacity larger than 1 cu. yd., increase minimum 1-1/2 minutes of mixing time by 15 seconds for each additional cu. yd. Provide batch ticket for each batch discharged and used in the Work, indicating Project identification name and number, date, mix type, mix time, quantity, and amount of water introduced.
- B. Ready-Mixed Concrete: Comply with requirements of ASTM C 94, and as specified. When air temperature is between 85 deg F (30 deg C) and 90 deg F (32 deg C), reduce mixing and delivery time from 1-1/2 hours to 75 minutes, and when air temperature is above 90 deg F (32 deg C), reduce mixing and delivery time to 60 minutes.

PART 3 - EXECUTION

3.1 GENERAL

Coordinate the installation of joint materials, vapor retarder/barrier, and other related materials with placement of forms and reinforcing steel.

3.2 VAPOR RETARDER/BARRIER INSTALLATION

- A. General: Place vapor retarder/barrier sheeting in position with longest dimension parallel with direction of pour.
- B. Lap joints 6 inches and seal with manufacturer's recommended mastic or

pressure-sensitive tape.

3.3 PLACING REINFORCEMENT

- A. General: Comply with Concrete Reinforcing Steel Institute's recommended practice for "Placing Reinforcing Bars," for details and methods of reinforcement placement and supports and as specified. Avoiding cutting or puncturing vapor retarder/barrier during reinforcement placement and concreting operations. Repair damages before placing concrete.
- B. Clean reinforcement of loose rust and mill scale, earth, ice, and other materials that reduce or destroy bond with concrete.
- C. Accurately position, support, and secure reinforcement against displacement. Locate and support reinforcing by metal chairs, runners, bolsters, spacers, and hangers, as approved by Contracting Officer.
- D. Place reinforcement to maintain minimum coverages as indicated for concrete protection. Arrange, space, and securely tie bars and bar supports to hold reinforcement in position during concrete placement operations. Set wire ties so ends are directed into concrete, not toward exposed concrete surfaces.
- E. Install welded wire fabric in lengths as long as practicable. Lap adjoining pieces at least one full mesh and lace splices with wire. Offset laps of adjoining widths to prevent continuous laps in either direction.

3.4 JOINTS

- A. Construction Joints: Locate and install construction joints so they do not impair strength or appearance of the structure, as acceptable to Contracting Officer.
- B. Provide keyways at least 1-1/2 inches deep in construction joints in walls and slabs and between walls and footings. Bulkheads designed and accepted for this purpose may be used for slabs.
- C. Place construction joints perpendicular to main reinforcement. Continue reinforcement across construction joints except as indicated otherwise. Do not continue reinforcement through sides of strip placements.
- D. Use bonding agent on existing concrete surfaces that will be joined with fresh concrete.
- E. Waterstops: Provide waterstops in construction joints as indicated. Install waterstops to form continuous diaphragm in each joint. Support and protect

exposed waterstops during progress of Work. Field-fabricate joints in waterstops according to manufacturer's printed instructions.

- F. Isolation Joints in Slabs-on-Grade: Construct isolation joints in slabs-on-grade at points of contact between slabs-on-grade and vertical surfaces, such as column pedestals, foundation walls, grade beams, and other locations, as indicated. Joint fillers and sealants are specified in Division 7 Section "Joint Sealants."
- G. Contraction (Control) Joints in Slabs-on-Grade: Construct contraction joints in slabs-on-grade to form panels of patterns as shown. Use saw cuts 1/8 inch wide by one-fourth of slab depth or inserts 1/4 inch wide by one-fourth of slab depth, unless otherwise indicated. Joint fillers and sealants are specified in Division 7 Section "Joint Sealants."

3.5 INSTALLING EMBEDDED ITEMS

- A. General: Set and build into formwork anchorage devices and other embedded items required for other work that is attached to or supported by cast-in-place concrete. Use setting drawings, diagrams, instructions, and directions provided by suppliers of items to be attached.
- B. Install reglets to receive top edge of foundation sheet waterproofing and to receive through-wall flashings in outer face of concrete frame at exterior walls, where flashing is shown at lintels, relieving angles, and other conditions.
- C. Install dovetail anchor slots in concrete structures as indicated on drawings.
- D. Forms for Slabs: Set edge forms, bulkheads, and intermediate screed strips for slabs to achieve required elevations and contours in finished surfaces. Provide and secure units to support screed strips using strike-off templates or compacting-type screeds.

3.6 PREPARING FORM SURFACES

- A. General: Coat contact surfaces of forms with an approved, nonresidual, low-VOC, form-coating compound before placing reinforcement.
- B. Do not allow excess form-coating material to accumulate in forms or come into contact with in-place concrete surfaces against which fresh concrete will be placed. Apply according to manufacturer's instructions. Coat steel forms with a nonstaining, rust-preventative material. Rust-stained steel formwork is not acceptable.

3.7 CONCRETE PLACEMENT

- A. Inspection: Before placing concrete, inspect and complete formwork installation, reinforcing steel, and items to be embedded or cast in. Notify other trades to permit installation of their work.
- B. General: Comply with ACI 304, "Guide for Measuring, Mixing, Transporting, and Placing Concrete," and as specified.
- C. Deposit concrete continuously or in layers of such thickness that no new concrete will be placed on concrete that has hardened sufficiently to cause seams or planes of weakness. If a section cannot be placed continuously, provide construction joints as specified. Deposit concrete to avoid segregation at its final location.
- D. Placing Concrete in Forms: Deposit concrete in forms in horizontal layers no deeper than 24 inches and in a manner to avoid inclined construction joints. Where placement consists of several layers, place each layer while preceding layer is still plastic to avoid cold joints.
 - 1. Consolidate placed concrete by mechanical vibrating equipment supplemented by hand-spading, rodding, or tamping. Use equipment and procedures for consolidation of concrete complying with ACI 309.
 - 2. Do not use vibrators to transport concrete inside forms. Insert and withdraw vibrators vertically at uniformly spaced locations no farther than the visible effectiveness of the machine. Place vibrators to rapidly penetrate placed layer and at least 6 inches into preceding layer. Do not insert vibrators into lower layers of concrete that have begun to set. At each insertion, limit duration of vibration to time necessary to consolidate concrete and complete embedment of reinforcement and other embedded items without causing mix to segregate.
- E. Placing Concrete Slabs: Deposit and consolidate concrete slabs in a continuous operation, within limits of construction joints, until completing placement of a panel or section.
 - 1. Consolidate concrete during placement operations so that concrete is thoroughly worked around reinforcement, other embedded items and into corners.
 - 2. Bring slab surfaces to correct level with a straightedge and strike off. Use bull floats or darbies to smooth surface free of humps or hollows. Do not disturb slab surfaces prior to beginning finishing operations.
 - 3. Maintain reinforcing in proper position on chairs during concrete placement.
- F. Cold-Weather Placement: Comply with provisions of ACI 306 and as follows.

Protect concrete work from physical damage or reduced strength that could be caused by frost, freezing actions, or low temperatures.

- G. When air temperature has fallen to or is expected to fall below 40 deg F (4 deg C), uniformly heat water and aggregates before mixing to obtain a concrete mixture temperature of not less than 50 deg F (10 deg C) and not more than 80 deg F (27 deg C) at point of placement.
1. Do not use frozen materials or materials containing ice or snow. Do not place concrete on frozen subgrade or on subgrade containing frozen materials.
 2. Do not use calcium chloride, salt, or other materials containing antifreeze agents or chemical accelerators unless otherwise accepted in mix designs.
- H. Hot-Weather Placement: When hot weather conditions exist that would impair quality and strength of concrete, place concrete complying with ACI 305 and as specified.
1. Cool ingredients before mixing to maintain concrete temperature at time of placement to below 90 deg F (32 deg C). Mixing water may be chilled or chopped ice may be used to control temperature, provided water equivalent of ice is calculated to total amount of mixing water. Using liquid nitrogen to cool concrete is Contractor's option.
 2. Cover reinforcing steel with water-soaked burlap if it becomes too hot, so that steel temperature will not exceed the ambient air temperature immediately before embedding in concrete.
 3. Fog spray forms, reinforcing steel, and subgrade just before placing concrete. Keep subgrade moisture uniform without puddles or dry areas.
 4. Use water-reducing retarding admixture when required by high temperatures, low humidity, or other adverse placing conditions, as acceptable to Contracting Officer.

3.8 FINISHING FORMED SURFACES

- A. Rough-Formed Finish: Provide a rough-formed finish on formed concrete surfaces not exposed to view in the finished Work or concealed by other construction. This is the concrete surface having texture imparted by form-facing material used, with tie holes and defective areas repaired and patched, and fins and other projections exceeding 1/4 inch in height rubbed down or chipped off.
- B. Smooth-Formed Finish: Provide a smooth-formed finish on formed concrete

surfaces exposed to view or to be covered with a coating material applied directly to concrete, or a covering material applied directly to concrete, such as waterproofing, dampproofing, painting, or another similar system. This is an as-cast concrete surface obtained with selected form-facing material, arranged in an orderly and symmetrical manner with a minimum of seams. Repair and patch defective areas with fins and other projections completely removed and smoothed.

- C. Smooth-Rubbed Finish: Provide smooth-rubbed finish on scheduled concrete surfaces that have received smooth-formed finish treatment not later than 1 day after form removal. Moisten concrete surfaces and rub with carborundum brick or another abrasive until producing a uniform color and texture. Do not apply cement grout other than that created by the rubbing process.
- D. Grout-Cleaned Finish: Provide grout-cleaned finish on scheduled concrete surfaces that have received smooth-formed finish treatment.
 - 1. Combine one part portland cement to one and one-half parts fine sand by volume, and a 50:50 mixture of acrylic or styrene butadiene-based bonding admixture and water to form the consistency of thick paint. Blend standard portland cement and white portland cement in amounts determined by trial patches so that final color of dry grout will match adjacent surfaces.
 - 2. Thoroughly wet concrete surfaces, apply grout to coat surfaces, and fill small holes. Remove excess grout by scraping and rubbing with clean burlap. Keep damp by fog spray for at least 36 hours after rubbing.
- E. Related Unformed Surfaces: At tops of walls, horizontal offsets, and similar unformed surfaces adjacent to formed surfaces, strike-off smooth and finish with a texture matching adjacent formed surfaces. Continue final surface treatment of formed surfaces uniformly across adjacent unformed surfaces unless otherwise indicated.

3.9 MONOLITHIC SLAB FINISHES

- A. Scratch Finish: Apply scratch finish to monolithic slab surfaces to receive concrete floor topping or mortar setting beds for tile and other bonded applied cementitious finish flooring material, and where indicated. After placing slabs, finish surface to tolerances of F(F) 15 (floor flatness) and F(L) 13 (floor levelness) measured according to ASTM E 1155. Slope surfaces uniformly to drains where required. After leveling, roughen surface before final set with stiff brushes, brooms, or rakes.
- B. Float Finish: Apply float finish to monolithic slab surfaces to receive trowel finish and other finishes as specified; slab surfaces to be covered with membrane or elastic waterproofing, membrane or elastic roofing; and where indicated. After screeding, consolidating, and leveling concrete slabs, do not work surface until ready for

floating. Begin floating, using float blades or float shoes only, when surface water has disappeared, or when concrete has stiffened sufficiently to permit operation of power-driven floats, or both. Consolidate surface with power-driven floats or by hand-floating if area is small or inaccessible to power units. Finish surfaces to tolerances of F(F) 18 (floor flatness) and F(L) 15 (floor levelness) measured according to ASTM E 1155. Cut down high spots and fill low spots. Uniformly slope surfaces to drains. Immediately after leveling, refloat surface to a uniform, smooth, granular texture.

- C. Trowel Finish: Apply a trowel finish to monolithic slab surfaces exposed to view and slab surfaces to be covered with resilient flooring, carpet, ceramic tile, paint, or another thin film-finish coating system. After floating, begin first trowel-finish operation using a power-driven trowel. Begin final troweling when surface produces a ringing sound as trowel is moved over surface. Consolidate concrete surface by final hand-troweling operation, free of trowel marks, uniform in texture and appearance, and finish surfaces to tolerances of F(F) 20 (floor flatness) and F(L) 17 (floor levelness) measured according to ASTM E 1155. Grind smooth any surface defects that would telegraph through applied floor covering system.
- D. Trowel and Fine Broom Finish: Where ceramic tile is to be installed with thin-set mortar, apply a trowel finish as specified, then immediately follow by slightly scarifying the surface with a fine broom.
- E. Nonslip Broom Finish: Apply a nonslip broom finish to exterior concrete platforms, steps, and ramps, and elsewhere as indicated. Immediately after float finishing, slightly roughen concrete surface by brooming with fiber-bristle broom perpendicular to main traffic route. Coordinate required final finish with Contracting Officer before application.

3.10 MISCELLANEOUS CONCRETE ITEMS

- A. Filling In: Fill in holes and openings left in concrete structures for passage of work by other trades, unless otherwise shown or directed, after work of other trades is in place. Mix, place, and cure concrete as specified to blend with in-place construction. Provide other miscellaneous concrete filling shown or required to complete Work.
- B. Curbs: Provide monolithic finish to interior curbs by stripping forms while concrete is still green and by steel-troweling surfaces to a hard, dense finish with corners, intersections, and terminations slightly rounded.
- C. Equipment Bases and Foundations: Provide machine and equipment bases and foundations as shown on drawings. Set anchor bolts for machines and equipment to template at correct elevations, complying with diagrams or templates of manufacturer furnishing machines and equipment.

3.11 CONCRETE CURING AND PROTECTION

- A. General: Protect freshly placed concrete from premature drying and excessive cold or hot temperatures. In hot, dry, and windy weather protect concrete from rapid moisture loss before and during finishing operations with an evaporation-control material. Apply according to manufacturer's instructions after screeding and bull floating, but before power floating and troweling.
- B. Start initial curing as soon as free water has disappeared from concrete surface after placing and finishing. Weather permitting, keep continuously moist for not less than 7 days.
- C. Curing Methods: Cure concrete by curing compound, by moist curing, by moisture-retaining cover curing, or by combining these methods, as specified.
- D. Provide moisture curing by the following methods:
 - 1. Keep concrete surface continuously wet by covering with water.
 - 2. Use continuous water-fog spray.
 - 3. Cover concrete surface with specified absorptive cover, thoroughly saturate cover with water, and keep continuously wet. Place absorptive cover to provide coverage of concrete surfaces and edges, with a 4-inch lap over adjacent absorptive covers.
- E. Provide moisture-retaining cover curing as follows: Cover concrete surfaces with moisture-retaining cover for curing concrete, placed in widest practicable width with sides and ends lapped at least 3 inches and sealed by waterproof tape or adhesive. Immediately repair any holes or tears during curing period using cover material and waterproof tape.
- F. Apply curing compound on exposed interior slabs and on exterior slabs, walks, and curbs as follows:
 - 1. Apply curing compound to concrete slabs as soon as final finishing operations are complete (within 2 hours and after surface water sheen has disappeared). Apply uniformly in continuous operation by power spray or roller according to manufacturer's directions. Recoat areas subjected to heavy rainfall within 3 hours after initial application. Maintain continuity of coating and repair damage during curing period.
 - 2. Use membrane curing compounds that will not affect surfaces to be covered with finish materials applied directly to concrete.

- G. Curing Formed Surfaces: Cure formed concrete surfaces, including underside of beams, supported slabs, and other similar surfaces, by moist curing with forms in place for the full curing period or until forms are removed. If forms are removed, continue curing by methods specified above, as applicable.
- H. Curing Unformed Surfaces: Cure unformed surfaces, including slabs, floor topping, and other flat surfaces, by applying the appropriate curing method. Final cure concrete surfaces to receive finish flooring with a moisture-retaining cover, unless otherwise directed.

3.12 REMOVING FORMS

General: Formwork not supporting weight of concrete, such as walls, columns, and similar parts of the work, may be removed after cumulatively curing at not less than 50 deg F (10 deg C) for 24 hours after placing concrete, provided concrete is sufficiently hard to not be damaged by form-removal operations, and provided curing and protection operations are maintained.

3.13 REUSING FORMS

- A. Clean and repair surfaces of forms to be reused in the Work. Split, frayed, delaminated, or otherwise damaged form-facing material will not be acceptable for exposed surfaces. Apply new form-coating compound as specified for new formwork.
- B. When forms are extended for successive concrete placement, thoroughly clean surfaces, remove fins and laitance, and tighten forms to close joints. Align and secure joint to avoid offsets. Do not use patched forms for exposed concrete surfaces except as acceptable to Contracting Officer.

3.14 CONCRETE SURFACE REPAIRS

- A. Patching Defective Areas: Repair and patch defective areas with cement mortar immediately after removing forms, when acceptable to Contracting Officer.
- B. Mix dry-pack mortar, consisting of one part portland cement to 2-1/2 parts fine aggregate passing a No. 16 mesh sieve, using only enough water as required for handling and placing.
 - 1. Cut out honeycombs, rock pockets, voids over 1/4 inch in any dimension, and holes left by tie rods and bolts down to solid concrete but in no case to a depth less than 1 inch. Make edges of cuts perpendicular to the concrete

surface. Thoroughly clean, dampen with water, and brush-coat the area to be patched with bonding agent. Place patching mortar before bonding agent has dried.

2. For surfaces exposed to view, blend white portland cement and standard portland cement so that, when dry, patching mortar will match surrounding color. Provide test areas at inconspicuous locations to verify mixture and color match before proceeding with patching. Compact mortar in place and strike-off slightly higher than surrounding surface.
- C. Repairing Formed Surfaces: Remove and replace concrete having defective surfaces if defects cannot be repaired to satisfaction of Contracting Officer. Surface defects include color and texture irregularities, cracks, spalls, air bubbles, honeycomb, rock pockets, fins and other projections on the surface, and stains and other discolorations that cannot be removed by cleaning. Flush out form tie holes and fill with dry-pack mortar or precast cement cone plugs secured in place with bonding agent. Repair concealed formed surfaces, where possible, containing defects that affect the concrete's durability. If defects cannot be repaired, remove and replace the concrete.
- D. Repairing Unformed Surfaces: Test unformed surfaces, such as monolithic slabs, for smoothness and verify surface tolerances specified for each surface and finish. Correct low and high areas as specified. Test unformed surfaces sloped to drain for trueness of slope and smoothness by using a template having the required slope.
1. Repair finished unformed surfaces containing defects that affect the concrete's durability. Surface defects include crazing and cracks in excess of 0.01 inch wide or that penetrate to the reinforcement or completely through nonreinforced sections regardless of width, spalling, popouts, honeycombs, rock pockets, and other objectionable conditions.
 2. Correct high areas in unformed surfaces by grinding after concrete has cured at least 14 days.
 3. Correct low areas in unformed surfaces during or immediately after completing surface finishing operations by cutting out low areas and replacing with patching mortar. Finish repaired areas to blend into adjacent concrete. Proprietary underlayment compounds may be used when acceptable to Contracting Officer.
 4. Repair defective areas, except random cracks and single holes not exceeding 1 inch in diameter, by cutting out and replacing with fresh concrete. Remove defective areas with clean, square cuts and expose reinforcing steel with at least 3/4-inch clearance all around. Dampen concrete surfaces in contact with patching concrete and apply bonding agent. Mix patching concrete of same materials to provide concrete of same type or class as

original concrete. Place, compact, and finish to blend with adjacent finished concrete. Cure in same manner as adjacent concrete.

- E. Repair isolated random cracks and single holes 1 inch or less in diameter by dry-pack method. Groove top of cracks and cut out holes to sound concrete and clean of dust, dirt, and loose particles. Dampen cleaned concrete surfaces and apply bonding compound. Place dry-pack before bonding agent has dried. Compact dry-pack mixture in place and finish to match adjacent concrete. Keep patched area continuously moist for at least 72 hours.
- F. Perform structural repairs with prior approval of Contracting Officer for method and procedure, using specified epoxy adhesive and mortar.
- G. Repair methods not specified above may be used, subject to acceptance of Contracting Officer.

3.15 QUALITY CONTROL TESTING DURING CONSTRUCTION

- A. Sampling and testing for quality control during concrete placement includes the following:
 - 1. Sampling Fresh Concrete: ASTM C 172, except modified for slump to comply with ASTM C 94.
 - a. Slump: ASTM C 143; one test at point of discharge for each day's pour of each type of concrete; additional tests when concrete consistency seems to have changed.
 - b. Air Content: ASTM C 173, volumetric method for lightweight or normal weight concrete; ASTM C 231, pressure method for normal weight concrete; one for each day's pour of each type of air-entrained concrete.
 - c. Concrete Temperature: ASTM C 1064; one test hourly when air temperature is 40 deg F (4 deg C) and below, when 80 deg F (27 deg C) and above, and one test for each set of compressive-strength specimens.
 - d. Compression Test Specimen: ASTM C 31; one set of four standard cylinders for each compressive-strength test, unless otherwise directed. Mold and store cylinders for laboratory-cured test specimens except when field-cured test specimens are required.
 - e. Compressive-Strength Tests: ASTM C 39; one set for each day's pour exceeding 5 cu. yd. plus additional sets for each 50 cu. yd. more than the first 25 cu. yd. of each concrete class placed in any one day; one specimen tested at 7 days, two specimens tested at 28 days, and one specimen retained in reserve for later testing if required.

2. When frequency of testing will provide fewer than five strength tests for a given class of concrete, conduct testing from at least five randomly selected batches or from each batch if fewer than five are used.
 3. When total quantity of a given class of concrete is less than 50 cu. yd., Contracting Officer may waive strength testing if adequate evidence of satisfactory strength is provided.
 4. When strength of field-cured cylinders is less than 85 percent of companion laboratory-cured cylinders, evaluate current operations and provide corrective procedures for protecting and curing the in-place concrete.
 5. Strength level of concrete will be considered satisfactory if averages of sets of three consecutive strength test results equal or exceed specified compressive strength and no individual strength test result falls below specified compressive strength by more than 500 psi.
- B. Test results will be reported in writing to Contracting Officer, ready-mix producer, and Contractor within 24 hours after tests. Reports of compressive strength tests shall contain the Project identification name and number, date of concrete placement, name of concrete testing service, concrete type and class, location of concrete batch in structure, design compressive strength at 28 days, concrete mix proportions and materials, compressive breaking strength, and type of break for both 7-day tests and 28-day tests.
- C. Nondestructive Testing: Impact hammer, sonoscope, or other nondestructive device may be permitted but shall not be used as the sole basis for acceptance or rejection.
- D. Additional Tests: The testing agency will make additional tests of in-place concrete when test results indicate specified concrete strengths and other characteristics have not been attained in the structure, as directed by Contracting Officer. Testing agency may conduct tests to determine adequacy of concrete by cored cylinders complying with ASTM C 42, or by other methods as directed at no additional cost to the government.

END OF SECTION 03300

SECTION 03355

SPECIAL CONCRETE FINISHES

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

Drawings and general provisions of Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes mechanically processed special concrete finishes applied to cast-in-place concrete surfaces.
- B. Work comprises application of special finishes to concrete surfaces, as follows:
 - 1. Abrasive blast finish.
 - 2. Bushhammer finish.
 - 3. Scrubbed finish.
- C. Cast-In-Place Concrete is specified in another Division 3 Section.

1.3 SUBMITTALS

- A. General: Submit the following in accordance with Conditions of Contract and Division 1 Specification Sections.
- B. Samples not less than 12 by 12 inches size of each type of special concrete finish, indicating materials and methods used to produce finishes. The government will review color and texture.

1.4 QUALITY ASSURANCE

- A. Requirements of Regulatory Agencies: Comply with air pollution regulations of governing authorities.
- B. Job Mock-Up: Apply surface finishes to sample concrete units or project control

mock-up in presence of Contracting Officer's Representative. Provide workmanship and procedures.

PART 2 - PRODUCTS

2.1 MATERIALS

Use materials and methods for project work as used to produce sample finishes acceptable to Government.

PART 3 - EXECUTION

3.1 GENERAL

- A. Perform abrasive blasting within 24 to 72 hours after casting. Coordinate with formwork construction, concrete placement schedule, and formwork removal to ensure that surfaces to be blast finished are blasted at same age for uniform results.
- B. Allow concrete to cure not less than 14 days before commencing bushhammer surface finish operations.
- C. Protect adjacent materials and finishes from dust, dirt and other surface or physical damage during finishing operations. Provide protections as required and remove from site at completion of work.
- D. Repair or replace other work damaged by finishing operations, as directed by Government.

3.2 ABRASIVE BLAST FINISH

- A. General: Apply abrasive blasted finish to concrete surfaces where indicated.
- B. Surface Continuity: Perform abrasive blast finishing in as continuous an operation as possible, utilizing same work crew to maintain continuity of finish on each surface or area of work. Maintain patterns of variances in depths of blast as shown on drawings.
- C. Depth of Cut: Use an abrasive grit of proper type and gradation to expose aggregate and surrounding matrix surfaces as follows:
 - 1. Brush: Remove cement matrix to expose face of fine aggregate; no reveal.

2. Light: Expose fine aggregate with occasional exposure of coarse aggregate; maximum 1/16-inch reveal.
 3. Medium: Generally expose coarse aggregate; 1/4-inch reveal.
 4. Heavy: Expose and reveal coarse aggregate to a maximum projection of 1/3 of the diameter; 3/8-inch to 1/2-inch reveal.
- D. Abrasive Blasting: Abrasive blast corners and edge of patterns carefully, using back-up boards, to maintain uniform corner or edge line. Determine type of nozzle, nozzle pressure, and blasting techniques required to match Government approved finish. Construction Joints: Use technique acceptable to Government to achieve uniform treatment of construction joints.
- E. Acid Cleaning: After abrasive blasting to required depth is completed, apply a weak acid wash to clean abrasive-blasted surfaces to match Government approved finish. Thoroughly neutralize and flush acid from surfaces with water under pressure. Protect adjacent materials/finishes from acid wash.

3.3 BUSHHAMMER FINISH

- A. General: Apply bushhammer finish to concrete surfaces where indicated.
- B. Surface Continuity: Perform bushhammer finishing in a continuous operation as possible, utilizing same work crew to maintain continuity of finish on each surface or area of work. Maintain patterns or variances of cut as shown on drawings.
- C. Surface Cut: Maintain depth of cut and general aggregate exposure to match Government approved finish. Use power hammerheads for large, flat surfaces and hand hammers for small areas, at corners and edges, and for restricted locations where power tools cannot reach.
- D. Acid Cleaning: After bushhammering to required finish, apply weak acid wash to clean exposed aggregate surfaces to match Government approved finish. Thoroughly neutralize and flush acid from finished surfaces.

3.4 SCRUBBED CONCRETE FINISH

- A. General: Apply scrubbed finish to concrete surfaces where indicated. Coordinate form removal as specified in "Cast-In-Place Concrete."
- B. Wet concrete surface thoroughly and scrub with stiff fiber or wire brushes, using water freely, until top mortar surface is removed and aggregate uniformly exposed.

Rinse scrubbed surfaces with clean water. Remove only enough concrete mortar from surfaces to match Government approved finished.

- C. Use a weak acid solution while scrubbing if concrete becomes too hard to produce required finish with normal scrubbing procedures. Remove acid from finished surface by flushing with clean water. Protect adjacent surfaces and finishes from damage by acid cleaning.

3.5 CLEAN UP AND PROTECTION

- A. Maintain control of concrete chips, dust, and debris in each area of work. Clean up and remove such material at completion of each day of operation. Prevent migration of airborne materials by use of tarpaulins, wind breaks, and similar containing devices.
- B. Cooperate with other trades for protection of special finishes.

END OF SECTION 03355