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	<p>JOB NO. J5I3132 Cooper County, MO Date Prepared: 1/8/2016</p>

Preliminary

JOB SPECIAL PROVISIONS (BRIDGE)

A. CONSTRUCTION REQUIREMENTS

1.0 Description. This provision contains general construction requirements for this project.

2.0 Construction Requirements. Plans for the existing structure(s) are included in the contract with the bridge plans for informational purposes only.

2.1 In order to assure the least traffic interference, the work shall be scheduled so that the bridge closure is for the absolute minimum amount of time required to complete the work. The bridge shall not be closed until material is available for continuous construction and the contractor is prepared to diligently pursue the work until the closed lane is opened to traffic.

2.2 Qualified special mortar shall be a qualified rapid set concrete patching material in accordance with [Sec 704](#). A qualified rapid set concrete patching material will not be permitted for repairing concrete deck (half-soling), deck repair with void tube replacement, full depth repair, modified deck repair and substructure repair (formed) unless a note on the bridge plans specifies that a qualified special mortar may be used.

2.3 Provisions shall be made to prevent any debris and materials from falling into the stream. Any debris and materials that falls below the bridge outside the limits mentioned previously and if determined necessary by the engineer, the debris shall be removed as approved by the engineer at the contractor's expense.

2.4 Any damage sustained to the remaining structure as a result of the contractor's operations shall be repaired or the material replaced as approved by the engineer at the contractor's expense.

2.5 Provisions shall be made to prevent damage to any existing utilities. Any damage sustained to the utilities as a result of the contractor's operations shall be the responsibility of the contractor. All costs of repair and disruption of service shall be as determined by the utility owners and as approved by the engineer.

2.6 A washer shall be required under head and nut when any reaming is performed for bolt installation.

2.7 SSPC-SP2 and SSPC-SP-3 surface preparation shall be in accordance with the environmental regulations in [Sec 1081](#) and collection of residue shall be in accordance with [Sec 1081](#) for collection of blast residue. SSPC-SP6, SSPC-SP10 and SSPC-SP-11 surface preparation shall be in accordance with the approved blast media and environmental regulations in [Sec 1081](#) and collection of blast residue shall be in accordance with [Sec 1081](#).

3.0 Coating Information.

3.1 Straps Removal. Exposed portions of straps for stay-in-place forms shall be removed prior to surface preparation. Straps need not be removed in areas that are not being painted. Flame cutting will not be permitted. The contractor shall exercise care not to damage the existing structure during removal. Any damage sustained to the remaining structure as a result of the contractor's operations shall be repaired or the material replaced as approved by the engineer at the contractor's expense.

3.2 Slab Drains and Stay-In-Place Forms. The stay-in-place forms, the slab drains and slab drain brackets shall not be recoated or overcoated or damaged during the painting operation.

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Any portion of the slab drain bracket that is blast cleaned shall be recoated with System G. Any damage sustained as a result of the contractor's operations shall be repaired or the material replaced as approved by the engineer at the contractor's expense.

3.3 Existing Bridge Information. The informational plans may be used by bidders in determining the amount of steel to be cleaned and painted/coated. Each bidder is expected to carefully examine the structure(s), investigate the condition of existing paint and to prepare their own estimate of quantities involved before submitting a bid. Surface preparation and applying field coatings to the structural steel will be based on the contract plan quantities. No final measurements will be made. The existing paint System S (Calcium Sulfonate) over System A (Red Lead).

3.4 Environmental Contact. Environmental Section may be contacted at the below address or phone number. The Missouri Department of Health may be contacted at 573-751-6102.

- (a) MoDOT - Design Division - Environmental Section
PO Box 270
105 W Capitol Ave, Jefferson City, MO 65102
Telephone (573) 526-4778

3.5 Approved Smelter and Hazardous Waste Treatment, Storage and Disposal Facility. The following is the approved smelter and hazardous waste treatment, storage and disposal facility:

Doe Run Company-Resource Recycling Division-Buick Facility
Highway KK
Boss, MO 65440
Telephone 573-626-4813

4.0 Method of Measurement. No measurement will be made.

5.0 Basis of Payment. Payment for the above described work will be considered completely covered by the contract unit price for other items included in the contract.

B. RAPID SET CONCRETE PATCHING MATERIAL – VERTICAL AND OVERHEAD REPAIRS

1.0 Description. This specification covers cementitious concrete, polymer-modified concrete and polymer concrete that are suitable for repairing concrete surfaces on bridges or concrete structures, particularly under fast setting or special conditions. The repairs would involve vertical or overhead applications. The work shall consist of removing, furnishing, preparing, and placing materials at locations as shown on the plans or as directed by the engineer.

2.0 Material. All materials shall be in accordance with MoDOT specifications and as noted herein.

2.1 Aggregate For Extending Commercial Mixture. Coarse and fine aggregates shall be in accordance with [Sec 1005](#), except the requirements for gradation and percent passing the No. 200 sieve shall not apply. Coarse aggregate meeting Gradation E requirements shall be used for repairs greater than one inch (25 mm) in depth. Fine aggregate will be allowed for repairs

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less than one inch (25 mm). Aggregate specified, bagged, labeled and furnished by the rapid set concrete patching material manufacturer may also be used for mortar extension.

2.2 Material Applications. The contractor shall select and use the product most suitable for the work and field conditions in accordance with these specifications.

2.3 Curing. Rapid set concrete patching material shall be cured until the minimum compressive strength 1500 psi is attained using standard curing specifications, unless otherwise specified by the manufacturer.

2.4 Qualification and Project Acceptance.

2.4.1 Inspection. All materials shall be subject to inspection and sampling by MoDOT at the source of manufacture, intermediate shipping terminal or destination. MoDOT will be allowed free access to all facilities and records as required to conduct inspection and sampling.

2.4.2 Qualification. Prior to use, rapid set concrete patching materials need to be qualified.

2.4.2.1 Requested Information. The manufacturer shall submit with samples of the materials, a written request to Construction and Materials with the following information:

- (a) New Products Evaluation Form
- (b) Brand name of the product.
- (c) Certification that the material meets this specification.
- (d) Certified test results from an independent laboratory showing compliance with this specification.
- (e) Specific preparation instructions of repair area.
- (f) Specific mixing, handling and curing instructions.
- (g) Application type (i.e., vertical or overhead).

2.4.2.2 Field Evaluation. Final approval will be granted when the following requirements are met:

- (a) MoDOT report documenting two years of field performance on MoDOT system. The report will contain the placement date, field observations (semi annual), description of field performance and photographs of in-place material.
- (b) A manufacturer's representative shall be present during placement of the material to provide technical expertise.

2.4.2.2.3 Disqualification. If during the two year observation period the repair area(s) fails the product will not be added to the qualified list.

2.5 Qualified List. The listing of qualified products are available from Construction and Materials or on MoDOT's web site. New certified test results and samples shall be submitted any time the manufacturing process or the material formulation is changed. The material will be

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subject to removal from the qualified list if there is evidence of unsatisfactory performance or a change in manufacturing process or formulation, or when random sampling and testing of material offered for use indicates nonconformity with any of the requirements herein specified.

2.6 Certification. The contractor shall supply a manufacturer's certification to the engineer for each lot of material furnished. The certification shall include the name of the manufacturer, a manufacturer certification statement that the material supplied is the same as that qualified and listing the date of qualification.

2.7 Acceptance. Acceptance of the material will be based on the use of a qualified product, the manufacturer's certification that the material supplied is the same as that approved and upon the results of such tests as may be performed by the engineer.

3.0 Mixture. Unless otherwise specified, rapid set concrete patching material shall be approved commercial mixtures meeting [Sections 3.1 – 3.1.3.](#) Rapid set concrete patching materials shall be specifically designed for the application needed.

3.1 Commercial Mixtures. Rapid set concrete patching material in its sacked form and mixtures when properly prepared in accordance with the manufacturer's specifications, shall meet the minimum test requirements given in Table 1. Mixtures may be supplied, as required, as a patching mortar or as a patching mortar with aggregate extension. If the material is to be supplied with extender aggregate, this shall also pass the required tests in Table 1 using the maximum allowed amount of extender aggregate.

3.1.1 Mixture Requirements. Rapid set concrete patching material shall be single packaged dry mix requiring the addition of water or other liquid component just prior to mixing. The material shall not contain soluble chlorides as an ingredient of manufacture. The material shall be placed in accordance to the manufacturer's recommendations.

Table 1 (English Unit)				
Physical Test Property	<u>Specification</u>	Requirement for cementitious concrete	Requirement for polymer-modified concrete	Requirement for polymer concrete
Bond Strength by Slant Shear	ASTM C882/C928 ²	min. 1000 psi @ 24hrs. & min. 1500 psi @ 7 days	n/a	min. 1000 psi @ 24hrs. & min. 1500 psi @ 7 days
Linear Coefficient of Thermal Expansion ¹ (for bagged mortar only, without extension aggregate)	ASTM C531	n/a	n/a	4 – 8 X 10-6 in/in/deg F
Resistance to Rapid Freezing & Thawing	AASHTO T161 or ASTM C666	80% min. using Procedure B ³ (300 Cycles)	80% min. using Procedure B ³ (300 Cycles)	n/a
Compressive Strength	AASHTO T22 or ASTM C39	1500 psi @ 3 hr & 3000 psi @ 24 hr	1500 psi @ 3 hr & 3000 psi @ 24 hr	n/a
Rapid Chloride	AASHTO T277 or	1000 coulombs	1000 coulombs	1000 coulombs

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Permeability	ASTM C1202	@ 28 days	@ 28 days	@ 28 days
Length Change	AASHTO T 160 or ASTM C157	In water Storage (+0.15) In air storage (-0.15)	In water storage (+0.15) In air storage (-0.15)	n/a
Color		gray	gray	gray

¹ Not required for extended mixtures if the mortar passes this requirement.

² ASTM C882 shall be performed on non-water based materials. ASTM C928 shall be performed on water-based materials.

³ Procedure A may be used in lieu of Procedure B

3.1.2 Construction Requirements. The manufacturer shall provide with the bagged mixture, specifications for the mixing procedure, amount and kind of liquid to be added, and the amount of aggregate extension allowed, if any. All mixing, handling and curing practices recommended by the manufacturer shall be followed and will be considered a part of these specifications.

3.1.3 Removal from Qualified List. All mixtures shall be approved before use. Reoccurring failures of any mixture for any reason will be cause for removal from the qualified list.

3.2 Vertical Repair.. A qualified rapid set concrete patching material approved for vertical use may be used when specified on the plans and as approved by the engineer. The engineer will make field cylinders to verify the 1500 psi (10 MPa) minimum strength. The material shall adhere to the concrete surface without sagging.

3.3 Overhead Repair. A qualified rapid set concrete patching material approved for overhead use may be used when specified on the plans and as approved by the engineer. The material shall be placeable in layers of at least 1 inch on overhead applications without the use of formwork or anchoring devices. The material shall adhere to the concrete surface without sagging. The engineer will make field cylinders to verify the 1500 psi (10 MPa) minimum strength.

4.0 Construction Requirements.

4.1 Mixing. Rapid set concrete patching material shall be mixed and finished according to the manufacturer's recommendation.

4.2 Preparation of Repair Area. Deteriorated, damaged or defective concrete as shown on the plans, required by the specifications or as directed by the engineer, shall be removed. All exposed reinforcement shall be thoroughly cleaned as shown on the plans, required by the specifications or as directed by the engineer. Unless otherwise specified by the commercial mixture manufacturer, the existing surface shall be damp and all free water shall be removed prior to placement of the required material.

4.3 Bonding Agent. A bonding agent may be used if recommended by the rapid set concrete patching material manufacturer.

5.0 Method of Measurement. No measurement will be made for rapid set concrete patching material.

6.0 Basis of Payment. Rapid set concrete patching material will be paid for at the contract unit price for other items and will be considered full compensation for all labor, equipment and material to complete the described work.

C. RAPID SET CONCRETE PATCHING MATERIAL – HORIZONTAL REPAIRS

1.0 Description. This specification covers cementitious concrete, polymer-modified concrete and polymer concrete that are suitable for repairing concrete surfaces on bridges or roadways, particularly under fast setting or special conditions. The repairs would involve horizontal applications. The work shall consist of removing, furnishing, preparing, and placing materials at locations as shown on the plans or as directed by the engineer.

2.0 Material. All materials shall be in accordance with MoDOT specifications and as noted herein.

2.1 Aggregate For Extending Commercial Mixture. Coarse and fine aggregates shall be in accordance with [Sec 1005](#), except the requirements for gradation and percent passing the No. 200 sieve shall not apply. Coarse aggregate meeting Gradation E requirements shall be used for repairs greater than one inch (25 mm) in depth. Fine aggregate will be allowed for repairs less than one inch (25 mm). Aggregate specified, bagged, labeled and furnished by the rapid set concrete patching material manufacturer may also be used for mortar extension.

2.2 Material Applications. The contractor shall select and use the product most suitable for the work and field conditions in accordance with these specifications.

2.3 Curing. Rapid set concrete patching material shall be cured until the minimum compressive strength 3200 psi is attained using standard curing specifications, unless otherwise specified by the manufacturer.

2.4 Qualification and Project Acceptance.

2.4.1 Inspection. All materials shall be subject to inspection and sampling by MoDOT at the source of manufacture, intermediate shipping terminal or destination. MoDOT will be allowed free access to all facilities and records as required to conduct inspection and sampling.

2.4.2 Qualification. Prior to use, rapid set concrete patching material shall be qualified. In order to become qualified, a material shall have completed testing through AASHTO's National Transportation Product Evaluation Program (NTPEP). The manufacturer shall contact the AASHTO/NTPEP coordinator to obtain the testing location for the rapid setting concrete patching material.

2.4.2.1 Requested Information. The manufacturer shall submit with samples of the materials, a written request to Construction and Materials with the following information:

- (a) Brand name of the product.
- (b) Certification that the material meets this specification.
- (c) NTPEP test results showing compliance with this special provision.
- (d) Specific mixing, handling and curing instructions.

- (e) Application type (i.e., bridge or roadway).

2.4.2.2 Qualified List. Upon approval by the engineer, the brand name and manufacturer will be placed on a qualified list of rapid set concrete patching materials. The listing of qualified materials is available from Construction and Materials or on MoDOT's web site. New certified test results and samples shall be submitted any time the manufacturing process or the material formulation is changed. The material will be subject to removal from the qualified list if there is evidence of unsatisfactory performance or a change in manufacturing process or formulation, or when random sampling and testing of material offered for use indicates nonconformity with any of the requirements herein specified.

2.4.3 Provisional Approval. Provisional approval may be granted provided the following requirements have been met:

- (c) New Products Evaluation Form
- (d) Certified test results from an independent laboratory showing compliance with this special provision.
- (e) Documentation prepared by MoDOT covering two years of field performance on MoDOT's system. MoDOT will need to approve the location of the test site. Documentation will contain the placement date, field observations (semi annual), description of field performance and photographs of in-place material.
- (f) During placement the manufacturer's representative shall be present on the project to provide technical expertise.

2.4.3.1 Disqualification. If during the two year observation period the repair area(s) fails provisional approval will not be granted. Repair area(s) experiencing any cracking, debonding or spalling will be considered a failure.

2.4.3.2 Length of Provisional Approval. Provisional approval will be granted for three years or until NTPEP testing is completed.

2.5 Certification. The contractor shall supply a manufacturer's certification to the engineer for each lot of material furnished. The certification shall include the name of the manufacturer, a manufacturer certification statement that the material supplied is the same as that qualified and listing the date of qualification.

2.6 Acceptance. Acceptance of the material will be based on the use of a qualified or provisionally approved material, the manufacturer's certification that the material supplied is the same as that approved and upon the results of such tests as may be performed by the engineer.

3.0 Mixture. Unless otherwise specified, rapid set concrete patching material shall be approved commercial mixtures meeting [Sections 3.1 – 3.1.3](#) or deck repair cementitious mortar meeting [Section 3.2](#). Rapid set concrete patching materials shall be specifically designed for the application needed.

3.1 Commercial Mixtures. Rapid set concrete patching material in its sacked form and mixtures when properly prepared in accordance with the manufacturer's specifications, shall

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meet the minimum test requirements given in Table 1. Mixtures may be supplied, as required, as a patching mortar or as a patching mortar with aggregate extension. If the material is to be supplied with extender aggregate, this shall also pass the required tests in Table 1 using the maximum allowed amount of extender aggregate.

3.1.2 Mixture Requirements. Rapid set concrete patching material shall be single packaged dry mix requiring the addition of water or other liquid component just prior to mixing. The material shall be capable of ½ inch (13 mm) to full depth repair and require no bonding agent. The material shall not contain soluble chlorides as an ingredient of manufacture. The material shall be placed in accordance to the manufacturer's recommendations.

Table 1 (English Unit)				
Physical Test Property	<u>Specification</u>	Requirement for cementitious concrete	Requirement for polymer-modified concrete	Requirement for polymer concrete
Bond Strength by Slant Shear ¹	ASTM C882/C928 ³	min. 1000 psi @ 24hrs. & min. 1500 psi @ 7 days	n/a	min. 1000 psi @ 24hrs. & min. 1500 psi @ 7 days
Linear Coefficient of Thermal Expansion ^{1, 2} (for bagged mortar only, without extension aggregate)	ASTM C531	n/a	n/a	4 – 8 X 10-6 in/in/deg F
Resistance to Rapid Freezing & Thawing ¹	AASHTO T161 or ASTM C666	80% min. using Procedure B ⁵ (300 Cycles)	80% min. using Procedure B ⁵ (300 Cycles)	n/a
Compressive Strength ¹	AASHTO T22 or ASTM C39	3200 psi @ 3 hr & 4000 psi @ 7 days	3200 psi @ 3 hr & 4000 psi @ 7 days	n/a
Rapid Chloride Permeability ¹	AASHTO T277 or ASTM C1202	<u>Bridge Decks</u> 1000 coulombs @ 28 days <u>Roadway</u> 2000 coulombs @ 28 days	<u>Bridge Deck</u> 1000 coulombs @ 28 days <u>Roadway</u> 2000 coulombs @ 28 days	<u>Bridge Deck</u> 1000 coulombs @ 28 days <u>Roadway</u> 2000 coulombs @ 28 days
Length Change ^{1, 4}	AASHTO T 160 or ASTM C157	In water Storage (+0.15) In air storage (-0.15)	In water storage (+0.15) In air storage (-0.15)	n/a
Color		gray	gray	gray

¹The commercial mix test values can be located in the AASHTO's National Transportation Product Evaluation Program (NTPEP) reports for Laboratory Evaluations of Rapid Set Concrete Patching Materials. Data for provisionally approved materials is located at the Construction and Materials Division.

²Not required for extended mixtures if the mortar passes this requirement.

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³ ASTM C882 shall be performed on non-water based materials. ASTM C928 shall be performed on water-based materials.

⁴ As modified by ASTM C928.

⁵ Procedure A may be used in lieu of Procedure B

3.1.2 Construction Requirements. The manufacturer shall provide with the bagged mixture, specifications for the mixing procedure, amount and kind of liquid to be added, and the amount of aggregate extension allowed, if any. All mixing, handling and curing practices recommended by the manufacturer shall be followed and will be considered a part of these specifications.

3.1.3 Removal from Qualified List. All mixtures shall be approved before use. Reoccurring failures of any mixture for any reason will be cause for removal from the qualified list.

3.2 Deck Repair Concrete. A qualified rapid set concrete patching material indicated for horizontal use and intended for patching concrete bridge decks may be used when specified on the plans and as approved by the engineer. If this option is selected, the contractor shall provide a trial mix to determine the total cure time needed to achieve a compressive strength of 3200 psi (22 MPa). Compressive specimens shall be prepared in accordance with current MoDOT test methods and cured to simulate actual field conditions. Testing of compressive specimens shall be performed by methods and at facilities acceptable to the engineer. The repaired deck shall not be opened to traffic until at least 4 hours after the last placement of deck repair concrete, the established cure time has elapsed and until such concrete has achieved a compressive strength of 3200 psi (22 MPa). A new trial mix may be required if the engineer determines the field conditions vary substantially from trial mix conditions. The engineer will make field cylinders to verify the 3200 psi (22 MPa) minimum strength.

4.0 Construction Requirements.

4.1 Mixing. Rapid set concrete patching material shall be mixed and finished according to the manufacturer's recommendation.

4.2 Preparation of Repair Area. Deteriorated, damaged or defective concrete as shown on the plans, required by the specifications or as directed by the engineer, shall be removed. All exposed reinforcement shall be thoroughly cleaned as shown on the plans, required by the specifications or as directed by the engineer. Unless otherwise specified by the commercial mixture manufacturer, the existing surface shall be damp and all free water shall be removed prior to placement of the required material.

4.3 Bonding Agent. A bonding agent may be used if recommended by the rapid set concrete patching material manufacturer.

5.0 Method of Measurement. No measurement will be made for rapid set concrete patching material.

6.0 Basis of Payment. Rapid set concrete patching material will be paid for at the contract unit price for other items and will be considered full compensation for all labor, equipment and material to complete the described work.

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D. CLEAN AND EPOXY SEAL

1.0 Description. In order to protect the bridge superstructure concrete from deicing chemicals and other contaminants, loose and delaminated concrete shall be removed and an epoxy seal shall be applied to the concrete in the area of curb outlets and the vertical face of the curbs in accordance with the bridge plans and this job special provision.

2.0 Construction Requirements. After repairs to the slab has been performed and the concrete fully cured as required by the epoxy manufacturer's written recommendations, the epoxy sealing preparation and applying the epoxy to these areas shall be in accordance with [Sec 704](#). The areas to be cleaned and epoxy sealed shall be as follows:

- (a) Deck surface and vertical faces inside the curb outlets.
- (b) Outside edge of the deck to 12 inches on each side of the curb outlets.
- (c) Superstructure concrete area directly below the curb outlets from the edge of the deck to the edge of the top flange of the girder and to 12 inches on each side of the curb outlets.
- (d) Vertical face of the curbs for the entire length of the bridge.

3.0 Method of Measurement. The area to be cleaned and epoxy sealed will be computed to the nearest square foot. Final measurement will not be made except for authorized changes during construction or if appreciable errors are found in the contract quantity.

4.0 Basis of Payment. Payment for the above described work, including all material, equipment, labor and any other incidental work necessary to complete this item, will be based on the contract plan quantities and will be considered completely covered by the contract unit price for "Clean and Epoxy Seal". Any change in the contract plan quantities, based on approved change orders, will be paid for at the contract unit price.

E. CLEANING, LUBRICATING AND COATING EXISTING BEARINGS

1.0 Description. This work shall consist of raising and supporting the existing girders as required to inspect, clean, lubricate and coat existing bearings as specified on the plans and as directed by the engineer.

2.0 Construction Requirements.

2.1 Raising and Supporting the Superstructure. Before commencing operations, the contractor shall submit to the engineer for review the method and sequence of operation proposed to be used in performing this work. The contractor shall exercise caution when supporting the structural steel and shall raise the girders the minimum extent necessary to perform this work. Raising the girders at the bents and piers shall be done simultaneously to prevent any damage to the adjoining steel and concrete deck. The lifting operation shall be done only when authorized, but such authorization shall not relieve the contractor of responsibility for the safety of the operation or for damage to the structure. Any damage caused by the contractor's operations shall be repaired at the contractor's expense as approved by the engineer.

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2.2 Bearing Inspection and Repair. After the structural members are supported, each bearing shall be inspected for deterioration. Any or all portions of the deteriorated bearings shall be replaced as determined by the engineer. When required to remove a bearing, removal of the bearing shall cause no damage to the existing anchor bolts in the concrete beam. Prior to removal or disassembly, all bearings shall be match marked for reassembly at ends of each piece by stamping an identification number in the metal with a steel stencil. All existing bearing material determined to be replaced shall be disposed of by the contractor in accordance with [Sec 202](#).

2.3 Cleaning, Lubricating and Coating. Bearings shall be cleaned in accordance with [Sec 1081](#). After cleaning and just prior to resetting the bearings, contact surfaces between the bearing pin and cradle shall be given a heavy coat of a graphite grease with a minimum of twenty percent graphite. After bearings are reset, the bearings shall receive a final cleaning and a prime coat. The final coat shall be applied when the existing structural steel is coated. Coating of bearings shall be as indicated for coating existing steel as specified in the contract documents.

3.0 Method of Measurement. Measurement for cleaning, lubricating and coating existing bearings will be made per each.

4.0 Basis of Payment. When required, payment for furnishing any new bearing material will be in accordance with [Sec 109](#). Payment for the above described work, including all material, equipment, labor and any other incidental work necessary to complete this item, will be considered completely covered by the contract unit price for "Cleaning, Lubricating and Coating Bearing".

F. STRUCTURAL STEEL REQUIREMENTS

1.0 Description. This provision contains general structural steel requirements for this project.

2.0 Material. All material shall be in accordance with Division 1000, Material Details, and specifically as shown below. The gray epoxy-mastic primer (non-aluminum) shall be compatible with concrete and produce a dry film thickness of no less than 3 mils (75 µm).

Item	Section
Structural Steel Construction	712
Gray Epoxy-Mastic Primer (non-aluminum)	1045
Structural Steel Fabrication	1080
Coating of Structural Steel	1081

3.0 Construction Requirements.

3.1 Before fabrication of new metalwork, the contractor shall make the necessary measurements in the field to verify dimensions of the existing structure where new members are affected. Any deviation of the dimensions shown on the plans shall be called to the engineer's attention. The contractor shall be responsible for developing all required dimensional adjustments and coordinating the implementation of the dimensional adjustments with all involved fabricators and subcontractors.

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3.2 Prior to erection of the new structural steel, the steel that is to remain shall be carefully inspected for irregularities. If such irregularities are found, the irregularities shall be brought to the attention of the engineer.

3.3 Holes in the new diaphragm or cross frame connection plates and angles may be used as a template for drilling the holes in the existing material.

3.4 A minimum edge distance shall be maintained for all field drilled holes. The minimum edge distance for bolts shall be as shown in table below measured from the centerline of holes.

Bolt Diameter	Minimum Edge Distance
inch (mm)	inch (mm)
3/4 (19.0)	1-1/4 (32)
7/8 (22.2)	1-1/2 (38)
1 (25.4)	1-3/4 (45)

3.5 The surfaces of existing steel that will become faying surfaces for new connections shall be cleaned according to the manufacturer's recommendation and with a minimum of SSPC-SP-3 surface preparation and coated with one prime coat of Gray Epoxy-Mastic Primer (non-aluminum) in accordance with [Sec 1081](#).

3.6 Exposed girder areas that are not a faying surfaces or not covered by concrete that are scratched, damaged by the contractor or by field welding operations shall be touched up with Gray Epoxy-Mastic Primer (non-aluminum) in accordance with [Sec 1081](#). The areas shall receive the coating system as shown on the plans.

G. NON-DESTRUCTIVE TESTING

1.0 Description. This work shall consist of performing non-destructive testing on the welds of all existing top flange cover plates.

2.0 Construction Requirements.

2.1 After the concrete deck is removed, the steel that is to remain will be inspected by the engineer. In addition to this inspection, the welds and adjacent base metal at the ends of the top cover plates shall have non-destructive (magnetic particle) testing performed. Non-destructive testing shall be done by an acceptable testing agency. The contractor shall provide the engineer with documentation of the testing agency and the qualifications of personnel performing the testing. The documentation and qualifications shall be submitted to the State Bridge Engineer for acceptance. Personnel performing the tests shall be qualified for SNT-TC-1A Level II.

2.2 The length of weld to be tested and the base metal, one inch either side of the weld, shall be cleaned of all rust prior to the testing. On cover plates with square ends, the weld shall be tested one inch from each corner along the ends of the cover plate plus 6 inches back along the side from each corner of the plate. On cover plates with tapered ends, the weld shall be tested along the end of the cover plate, along tapered edges and 6 inches back along the cover plate from end of taper.

2.3 If fatigue cracks are found, the cracks are expected to be very small and may be located in the base metal at the toe of the welds. Any cracks discovered by testing, regardless of length,

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shall be marked and reported to the engineer. All repairs shall be made by a MoDOT certified welder. Any repair work and retesting of the repair work required, as a result of this inspection, will be paid for in accordance with [Sec 109](#). This shall not relieve the contractor from responsibility to repair any damage caused by this work at the contractor's expense. Any delay or inconvenience caused by this inspection requirement will be non-compensable and effect on time of performance non-excusable.

3.0 Method of Measurement. Measurement of non-destructive testing will be to the nearest linear foot. The extent of non-destructive testing may vary from the estimated quantities, but the contract unit price shall prevail regardless of the variation. Final measurements will not be made except for authorized changes during construction, or where appreciable errors are found in the contract quantity. The revision or correction will be computed and added to or deducted from the contract quantity.

4.0 Basis of Payment. Accepted quantities of non-destructive testing will be paid for at the contract unit price. Payment for the above described work, including all material, equipment, labor and any other incidental work necessary to complete this item, will be considered completely covered by the contract unit price for Non-Destructive Testing.

H. RIVET REMOVAL AND REPLACEMENT

1.0 Description. This work shall consist of the safe removal of rivets in a manner that does not damage surrounding material and replaced with high strength bolts or as directed by the engineer.

2.0 Material. All material shall be in accordance with Division 1000, Material Details, and specifically as follows:

Item	Section
Disposal of Material	202
Structural Steel Construction	712
Structural Steel Fabrication	1080

3.0 Construction Requirements.

3.1 The contractor shall submit to the engineer for approval the proposed method for rivet removal. Rivet removal will not be permitted until the removal method has been approved and demonstrated successfully in the judgment of the engineer. In the event that the engineer determines that rivet removal work is resulting in damage to the existing steel, the contractor shall cease rivet removal operations until a new proposed method has been demonstrated and approved by the engineer.

3.2 Unless otherwise noted, all bolts shall be the same diameter as the rivets being replaced. High strength bolt installation shall be in accordance with [Sec 712](#). All high strength bolts that replace rivets shall have a washer under the head and nut. Rivets shall be replaced one at a time. If the bolts will not fit the existing rivet holes, the holes may be carefully reamed to accommodate the bolts. For field drilling and reaming of the existing holes, no flame drilling will be permitted.

JOB SPECIAL PROVISIONS (BRIDGE)

3.3 Rivets on intermediate diaphragms and cross frames that connect girders or stringers under different construction stage slab pours shall have the rivets removed and replaced with high strength bolts installed snug tight and in accordance with [Sec 712](#). The high strength bolts shall be tightened after both adjacent slab pours have been completed.

3.4 Any damage to the existing structure due to contractor's rivet removal and replacement operations or field drilling operations shall be repaired or replaced at the contractor's expense and to the satisfaction of the engineer.

4.0 Method of Measurement. The extent of rivet removal and replacement may vary from the estimated quantity but the contract unit price shall prevail regardless of the variation. The rivet removal and replacement will be measured per each.

5.0 Basis of Payment. Accepted quantity of rivet removal and replacement will be paid for at the contract unit price. Payment for the above described work, including all material, equipment, labor and any other incidental work necessary to complete this item, will be considered completely covered by the contract unit price for "Rivet Removal and Replacement".

I. OPEN CELL FOAM JOINT

1.0 Description. This work shall consist of providing and installing an open cell foam joint system. The system shall be supplied and installed in accordance with the plans, this specification and the manufacturer's requirements.

2.0 Materials.

2.1 Acceptance. All material will be inspected and accepted in accordance with this specification and [Sec 106](#). *Emseal BEJS is a pre-qualified product.*

2.2 Joint System Components. All components of the system shall be supplied by one manufacturer. The joint system shall be comprised of the following 3 components.

1. Cellular polyurethane foam impregnated with 100% hydrophobic polymer, water based emulsion and factory coated, on the roadway surface, with highway-grade, fuel resistant silicone.
2. Field-applied epoxy adhesive primer.
3. Field-applied silicone sealant bands that seal the gap between the edge of the deck and the silicone topping on the joint.

2.3 General Movement Requirements. The seal shall have a working range of 50% in tension and 50% in compression. Changes in plane and direction shall be executed using factory fabricated watertight transition assemblies on inside and outside corners for 45 degrees and 90 degrees.

2.4 Seal Properties. The seal shall be able to meet the following properties:

Property	Requirement
Temperature Service Range, ASTM C 711	-40° F to 185° F
Bleeding	None at 180° F @ 50% compression for 3 hrs
UV Resistance, ASTM G 155	No Changes at 2000 hrs
Polymer impregnation agent	Free of any waxes or asphalts

2.5 Adhesive Properties. The epoxy adhesive shall be a 100% solids, two component moisture sensitive modified epoxy adhesive which meets ASTM C 881.

2.6 Sealant Properties. The silicone sealant shall be a one part, cold applied chemically curing silicone joint sealant which meets ASTM D 5893.

3.0 Construction Requirements. The contractor shall have a manufacturer's representative on site for the joint installation. The representative shall be responsible for ensuring the surface preparation and joint installation are done in accordance with the manufacturer's requirements.

4.0 Method of Measurement. Final measurement will not be made except for authorized changes during construction or where significant errors are found in the contract quantity. The open cell foam joint will be measured to the nearest linear foot based on measurement from roadway face of curb to roadway face of curb along the centerline of the joint. No measurement will be made of portions of the joint that extend past the roadway face of curbs.

5.0 Basis of Payment. Open cell foam joint, including all material, coating, equipment, labor, fabrication, installation and any other incidental work necessary to complete this work, will be paid for at the contract unit price for Open Cell Foam Joint.