SECTION 03300 - CAST-IN-PLACE CONCRETE

PART 1 - GENERAL

1.1 Design Criteria

A. Stamped Concrete
   1. No stamped concrete

B. Stained Concrete
   1. No exterior stained concrete

1.2 SUMMARY

A. This Section specifies cast-in-place concrete, including formwork, reinforcement, concrete materials, mix design, placement procedures, and finishes.

B. Cast in place concrete includes the following:
   1. Foundations and footings.
   2. Slabs-on-grade.
   3. Floor slabs.
   4. Concrete Toppings.
   5. Equipment pads and bases.

1.3 DEFINITIONS

A. Cementitious Materials: Portland cement alone or in combination with one or more of blended hydraulic cement, fly ash and other pozzolans, ground granulated blast-furnace slag, and silica fume.

1.4 SUBMITTALS

A. General: Submit the following in accordance with conditions of the contract and division 1 specification section.

B. Product Data: For each type of manufactured material and product indicated.

C. Design Mixes: For each concrete mix, include alternate mix designs when characteristics of materials, project conditions, weather, test results, or other circumstances warrant adjustments.
   1. Indicate amounts of mix water to be withheld for later addition at Project site.

D. Steel Reinforcement Shop Drawings: Details of fabrication, bending, and placement, prepared according to ACI 315, "Details and Detailing of Concrete Reinforcement." Include material, grade, bar schedules, stirrup spacing, bent bar diagrams, arrangement, and supports of concrete reinforcement. Include special reinforcement required for openings through concrete structures.

E. Welding Certificates: Copies of certificates for welding procedures and personnel.

F. Material Test Reports: WSU will hire a qualified test agency independently.
1. Inspecting agent must be notified 24 hours in advance by contractor.
2. Inspection agent information will be provided by WSU project manager.
3. Contractors are responsible for re-inspection costs.
4. Inspection must be completed while pouring concrete.
5. Inspection test report must be completed with each pour or every 50 yards, whichever is less.

G. Material Certificates: Signed by manufacturers certifying that each of the following items complies with requirements:
   1. Cementitious materials and aggregates.
   2. Form materials and form-release agents.
   3. Steel reinforcement and reinforcement accessories.
   4. Fiber reinforcement
   5. Admixtures.
   8. Adhesives.

1.5 QUALITY ASSURANCE

A. Installer Qualifications: An experienced installer who has completed concrete Work similar in material, design, and extent to that indicated for this Project and whose work has resulted in construction with a record of successful in-service performance.

B. Manufacturer Qualifications: A firm experienced in manufacturing ready-mixed concrete products complying with ASTM C 94 requirements for production facilities and equipment.
   1. Manufacturer must be certified according to the National Ready Mixed Concrete Association’s Certification of Ready Mixed Concrete Production Facilities.

C. Testing Agency Qualifications: An independent testing agency, acceptable to authorities having jurisdiction, qualified according to ASTM C 1077 and ASTM E 329 to conduct the testing indicated, as documented according to ASTM E 548.
   1. Personnel conducting field tests shall be qualified as ACI Concrete Field Testing Technician, Grade 1, according to ACI CP-1 or an equivalent certification program.

D. Source Limitations: Obtain each type or class of cementitious material of the same brand from the same manufacturer’s plant, each aggregate from one source, and each admixture from the same manufacturer, unless otherwise approved by WSU Project Manager.

E. Welding: Qualify procedures and personnel according to AWS D1.4, “Structural Welding Code—Reinforcing Steel.”

F. ACI Publications: Comply with the following, unless more stringent provisions are indicated:
   1. ACI 318, “Building Code Requirements for Reinforced Concrete”
   3. ACI 301, “Specification for Structural Concrete.”
   4. ACI 311, “Recommended Practice for Concrete Inspection”
   5. CRSI, “Manual of Standard Practice”
1.6 DELIVERY, STORAGE, AND HANDLING

A. Deliver, store, and handle steel reinforcement to prevent bending and damage.

PART 2 - PRODUCTS

2.1 FORM-FACING MATERIALS

A. Smooth-Formed Finished Architectural Concrete: Form-facing panels that will provide continuous, true, and smooth concrete surfaces. Furnish in largest practicable sizes to minimize number of joints.

1. Metal or other approved panel materials.
2. Exterior-grade plywood panels, suitable for concrete forms, complying with DOC PS 1, will be allowed for pours less than four cubic yards and shall comply with the following:
   a. High-density overlay, Class 1, or better.
   b. Plywood shall come from sources certified by the Forest Stewardship Council (FSC).

B. Rough-Formed Finished Concrete: Plywood, lumber, metal, or another approved material. Provide lumber dressed on at least two edges and one side for tight fit. Plywood shall come from sources certified by the Forest Stewardship Council (FSC).

C. Void Forms: Biodegradable paper surface, treated for moisture resistance, structurally sufficient to support weight of plastic concrete and other superimposed loads.

D. Chamfer Strips: Wood, metal, PVC, or rubber strips, 3/4 by 3/4 inch (19 by 19 mm), minimum.

E. Form-Release Agent: Commercially formulated form-release agent that will not bond with, stain, or adversely affect concrete surfaces and will not impair subsequent treatments of concrete surfaces.


F. Form Ties: Factory-fabricated, removable or snap-off metal or glass-fiber-reinforced plastic form ties designed to resist lateral pressure of fresh concrete on forms and to prevent spalling of concrete on removal.

1. Furnish units that will leave no corrodible metal closer than 1 inch (25 mm) to the plane of the exposed concrete surface.
2. Furnish ties that, when removed, will leave holes not larger than 1 inch (25 mm) in diameter in concrete surface.

2.2 STEEL REINFORCEMENT

A. Reinforcing Bars: ASTM A 615/A 615M, Grade 60 (Grade 420), deformed. Grade 40 (A-706) shall be used for welded applications where noted in the drawings. All exterior concrete reinforcing bars shall be epoxy coated.
2.3 REINFORCEMENT ACCESSORIES

A. Bar Supports: Bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars in place. Manufacture bar supports according to CRSI's "Manual of Standard Practice" from steel wire, plastic, or precast concrete or fiber-reinforced concrete of greater compressive strength than concrete, and as follows:

1. For concrete surfaces exposed to view where legs of wire bar supports contact forms, use CRSI Class 1 plastic-protected or CRSI Class 2 stainless-steel bar supports.

B. Joint Dowel Bars: Plain-steel bars, ASTM A 615/A 615M, Grade 60. Cut bars true to length with ends square and free of burrs.

C. Fiber-mesh reinforcing.

2.4 CONCRETE MATERIALS

A. Portland Cement: ASTM C 150, Type 1 or 1A.
1. Fly Ash: ASTM C 618, Class F. Maximum loss on ignition is limited to 3%, with maximum variation of 1%.
2. Ground Granulated Blast-Furnace Slag: ASTM C 989, Grade 100 or 120.

B. Normal-Weight Aggregate: ASTM C 33, uniformly graded, and as follows:

1. Class: Severe weathering region, but not less than 3S.
2. Nominal Maximum Aggregate Size: ¾" to 1 inch maximum.
3. Combined Aggregate Gradation: Well graded from coarsest to finest with not more than 18 percent and not less than 8 percent retained on an individual sieve, except that less than 8 percent may be retained on coarsest sieve and on No. 50 sieve, and less than 8 percent may be retained on sieves finer than No. 50.


D. Water: Potable and complying with ASTM C 94.

2.5 ADMIXTURES

A. General: Admixtures certified by manufacturer to contain not more than 0.1 percent water-soluble chloride ions by mass of cementitious material and to be compatible with other admixtures and cementitious materials. Do not use admixtures containing calcium chloride.


C. Water-Reducing Admixture: ASTM C 494, Type A.

D. High-Range, Water-Reducing Admixture: ASTM C 494, Type F.

E. Water-Reducing and Accelerating Admixture: ASTM C 494, Type E.

F. Prohibited admixtures: An admixture containing calcium chloride is not permitted.
2.6 CURING MATERIALS

A. General: Curing compounds must be compatible with subsequent finish applications.

B. Evaporation Retarder: Waterborne, monomolecular film forming, manufactured for application to fresh concrete.

C. Absorptive Cover: AASHTO M 182, Class 2, burlap cloth made from jute or kenaf, weighing approximately 9 oz./sq. yd. dry.

D. Moisture-Retaining Cover: ASTM C 171, polyethylene film or white burlap-polyethylene sheet.

E. Water: Potable.

F. Clear, Solvent-Borne, Membrane-Forming Curing Compound: ASTM C 309, Type 1, Class B.

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

1. Evaporation Retarder:
   a. Cimfilm; Axim Concrete Technologies.
   b. Finishing Aid Concentrate; Burke Group, LLC (The).
   c. Spray-Film; ChemMasters.
   d. AquaFilm; Conspec Marketing & Manufacturing Co., Inc.
   e. Sure Film; Dayton Superior Corporation.
   f. Eucobar; Euclid Chemical Co.
   g. Vapor Aid; Kaufman Products, Inc.
   h. Lambo Skin; Lambert Corporation.
   i. E-Con; L&M Construction Chemicals, Inc.
   j. Confilm; Master Builders, Inc.
   k. Waterhold; Metalcrete Industries.
   l. Rich Film; Richmond Screw Anchor Co.
   m. SikaFilm; Sika Corporation.
   n. Finishing Aid; Symons Corporation.
   o. Certi-Vex EnviroAssist; Vexcon Chemicals, Inc.
   p. Approved equal.

2. Clear, Solvent-Borne, Membrane-Forming Curing Compound:
   a. Day-Chem Cure and Seal; Dayton Superior Corporation.
   b. Cure & Seal 309; Kaufman Products Inc.
   c. L&M Dress & Seal 18; L&M Construction Chemicals, Inc.
   d. CS-309; W. R. Meadows, Inc.
   e. Seal N Kure; Metalcrete Industries.
   f. Kure-N-Seal; Sonneborn, Div. of ChemRex, Inc.
   g. Cure & Seal 14 percent; Symons Corporation.
   h. Clear Seal 150; Tamms Industries Co., Div. of LaPorte Construction Chemicals of North America, Inc.
   i. Approved equal.
2.7 RELATED MATERIALS

A. Joint-Filler Strips: ASTM D 1751, asphalt-saturated cellulosic fiber, or ASTM D 1752, cork or self-expanding cork.

B. Semi rigid epoxy joint filler: Refer to Section 7, joint sealants.

C. Bonding Agent: ASTM C 1059, Type II, non-redispersible, acrylic emulsion or styrene butadiene.

D. Epoxy-Bonding Adhesive: ASTM C 881, two-component epoxy resin, capable of humid curing and bonding to damp surfaces, of class and grade to suit requirements, and as follows:

   1. Type II, non-load bearing, for bonding freshly mixed concrete to hardened concrete.
   2. Types I and II, non-load bearing, for bonding hardened or freshly mixed concrete to hardened concrete.
   3. Types IV and V, load bearing, for bonding hardened or freshly mixed concrete to hardened concrete.

E. Reglets: Fabricate reglets of not less than 0.0217-inch (0.55-mm-) thick galvanized steel sheet. Temporarily fill or cover face opening of reglet to prevent intrusion of concrete or debris.

2.8 FIBER REINFORCEMENT

A. Synthetic Fiber: Monofilament polypropylene fibers engineered and designed for use in concrete slabs, pads and pavement complying with ASTM C 1116, Type III, 1/2 to 1-1/2 inches (13 to 38 mm) long, microfiber is unacceptable.

   1. Available Products:
      a. Monofilament Fibers:
         1) Axim Concrete Technologies; Fibrasol IIP.
         2) Euclid Chemical Company (The); Fiberstrand 100.
         3) FORTA Corporation; Forta Mono.
         5) Metalcreeate Industries; Polystrand 1000.
         6) SI Concrete Systems; Fibermix Stealth.
         7) Or approved equal

2.9 REPAIR MATERIALS

A. Repair Underlayment: Cement-based, polymer-modified, self-leveling product that can be applied in thicknesses from 1/8 inch (3.2 mm) and that can be feathered at edges to match adjacent floor elevations.

   1. Cement Binder: ASTM C 150, portland cement or hydraulic or blended hydraulic cement as defined in ASTM C 219.
   2. Primer: Product of underlayment manufacturer recommended for substrate, conditions, and application.
   3. Aggregate: Well-graded, washed gravel, 1/8 to 1/4 inch (3 to 6 mm) or coarse sand as recommended by underlayment manufacturer.
   4. Compressive Strength: Not less than 4100 psi (29 MPa) at 28 days when tested according to ASTM C 109/C 109M.
2.10 CONCRETE MIXES

A. Prepare design mixes for each type and strength of concrete determined by either laboratory trial mix or field test data bases, as follows:

1. Proportion normal-weight concrete according to ACI 211.1 and ACI 301.
2. Proportion lightweight structural concrete according to ACI 211.2 and ACI 301.

B. Use a qualified independent testing agency for preparing and reporting proposed mix designs for the laboratory trial mix basis.

C. Footings and Foundation Walls: Proportion normal-weight concrete mix as follows:

1. Compressive Strength (28 Days): 3000 psi (20.7 MPa) or as noted on the structural drawings.
2. Maximum water/cement ratio: 0.45
3. Maximum Slump: 4 inches (125 mm).

D. Slab-on-Grade: Proportion normal-weight concrete mix as follows:

1. Compressive Strength (28 Days): minimum 3000 psi, 4000 psi for vehicular access ways and equipment housekeeping pads or as noted on the structural drawings.
2. Maximum water/cement ratio: 0.45.
3. Maximum Slump: 4 inches (100 mm).
4. Synthetic Fiber: Uniformly disperse in concrete mixture at manufacturer’s recommended rate, but not less than 1.5 lb/cu. yd. (0.90 kg/cu. m).

E. Other structural concrete: Proportion normal-weight concrete mix as follows:

1. Compressive Strength (28 Days): as noted on the structural drawings.
2. Maximum water/cement ratio: 0.45.
3. Maximum Slump: 4 inches (125 mm).
4. Synthetic Fiber: Uniformly disperse in concrete mixture at manufacturer’s recommended rate, but not less than 1.5 lb/cu. yd. (0.90 kg/cu. m).

F. Lightweight mix – elevated Slabs:

1. Compressive Strength (28 Days): as noted on the structural drawings.
2. Maximum water/cement ratio: 0.45.
3. Maximum Slump: 4 inches (125 mm).

G. Cementitious Materials: Limit percentage, by weight, of cementitious materials other than portland cement in concrete as follows:

1. Fly Ash: 15 percent.

H. Maximum Water-Cementitious Materials Ratio: 0.50 for concrete required to have low water permeability.

I. Maximum Water-Cementitious Materials Ratio: 0.45 for concrete exposed to deicers or subject to freezing and thawing while moist.

J. Do not air entrain concrete to trowel-finished interior floors and suspended slabs. Do not allow entrapped air content to exceed 3 percent.
K. Air Content: Add air-entraining admixture at manufacturer’s prescribed rate to result in concrete at point of placement having an air content as follows within a tolerance of plus 1 or minus 1.5 percent, unless otherwise indicated:

   1. Air Content: 5.5 percent.

L. Limit water-soluble, chloride-ion content in hardened concrete to 0.15 percent by weight of cement.

M. Admixtures: Use admixtures according to manufacturer’s written instructions and as approved by WSU Project Manager.

   1. Use water-reducing admixture or high-range water-reducing admixture (superplasticizer) in concrete, as required, for placement and workability.
   2. Use water-reducing and retarding admixture when required by high temperatures, low humidity, or other adverse placement conditions.
   3. Use water-reducing admixture in pumped concrete, concrete for heavy-use industrial slabs and parking structure slabs, concrete required to be watertight, and concrete with a water-cementitious materials ratio below 0.50.

2.11 FABRICATING REINFORCEMENT

A. Fabricate steel reinforcement according to CRSI’s “Manual of Standard Practice.”

2.12 CONCRETE MIXING

A. Ready-Mixed Concrete: Measure, batch, mix, and deliver concrete according to ASTM C 94 and ASTM C 1116, and furnish batch ticket information.

   1. When air temperature is between 85 and 90 deg F (30 and 32 deg C), reduce mixing/delivery, and pour time from 1-1/2 hours to 75 minutes; when air temperature is above 90 deg F (32 deg C), reduce mixing/delivery, and pour time to 60 minutes.

PART 3 - EXECUTION

3.1 FORMWORK

A. Design, erect, shore, brace, and maintain formwork, according to ACI 301, to support vertical, lateral, static, and dynamic loads, and construction loads that might be applied, until concrete structure can support such loads.

B. Construct formwork so concrete members and structures are of size, shape, alignment, elevation, and position indicated, within tolerance limits of ACI 117.

C. Limit concrete surface irregularities, designated by ACI 347R as abrupt or gradual, as follows:

   1. Class A, 1/8 inch (3 mm).

D. Construct forms tight enough to prevent loss of concrete mortar.
E. Fabricate forms for easy removal without hammering or prying against concrete surfaces. Provide crush or wrecking plates where stripping may damage cast concrete surfaces. Provide top forms for inclined surfaces steeper than 1.5 horizontal to 1 vertical. Kerf wood inserts for forming keyways, reglets, recesses, and the like, for easy removal.

1. Do not use rust-stained steel form-facing material.

F. Set edge forms, bulkheads, and intermediate screed strips for slabs to achieve required elevations and slopes in finished concrete surfaces. Provide and secure units to support screed strips; use strike-off templates or compacting-type screeds.

G. Provide temporary openings for cleanouts and inspection ports where interior area of formwork is inaccessible. Close openings with panels tightly fitted to forms and securely braced to prevent loss of concrete mortar. Locate temporary openings in forms at inconspicuous locations.

H. Chamfer all exterior corners and edges of permanently exposed concrete, except for walkways and stairs, or as directed by WSU Project Manager.

I. Form openings, chases, offsets, sinkages, keyways, reglets, blocking, screeds, and bulkheads required in the work. Coordinate sizes and locations from trades providing such items.

J. Clean forms and adjacent surfaces to receive concrete. Remove chips, wood, sawdust, dirt, and other debris just before placing concrete.

K. Retighten forms and bracing before placing concrete, as required, to prevent mortar leaks and maintain proper alignment.

L. Coat contact surfaces of forms with form-release agent, according to manufacturer’s written instructions, before placing reinforcement.

M. All radial concrete shall be formed to create a clean arc. Straight segments will not be allowed.

3.2 EMBEDDED ITEMS

A. Place and secure anchorage devices and other embedded items required for adjoining work that is attached to or supported by cast-in-place concrete. Use Setting Drawings, templates, diagrams, instructions, and directions furnished with items to be embedded.

1. Install anchor bolts, accurately located, to elevations required.

3.3 REMOVING AND REUSING FORMS

A. General: Formwork, for sides of beams, walls, columns, and similar parts of the Work, that does not support weight of concrete 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 hard enough to not be damaged by form-removal operations and provided curing and protection operations are maintained.

B. Leave formwork, for slabs, and other structural elements, that supports weight of concrete in place until concrete has achieved the following:

1. At least 70 percent of 28-day design compressive strength.
2. Determine compressive strength of in-place concrete by testing representative field- or laboratory-cured test specimens according to ACI 301.
3. Remove forms only if shores have been arranged to permit removal of forms without loosening or disturbing shores.

C. 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-release agent with each new pour.

D. When forms are reused, clean surfaces, remove fins and laitance, and tighten to close joints. Align and secure joints to avoid offsets. Do not use patched forms for exposed concrete surfaces unless approved by WSU Project Manager.

3.4 STEEL REINFORCEMENT

A. General: Comply with CRSI's "Manual of Standard Practice" for placing reinforcement.

B. Clean reinforcement of loose rust and mill scale, earth, ice, and other foreign materials.

C. Accurately position, support, and secure reinforcement against displacement. Locate and support reinforcement with bar supports to maintain minimum concrete cover. Do not tack weld crossing reinforcing bars.

1. Shop- or field-weld reinforcement according to AWS D1.4, where indicated.

D. Set wire ties with ends directed into concrete, not toward exposed concrete surfaces.

3.5 JOINTS

A. General: Construct joints true to line with faces perpendicular to surface plane of concrete.

B. Construction Joints: Install so strength and appearance of concrete are not impaired, at locations indicated or as approved by WSU Project Manager.

1. Place joints perpendicular to main reinforcement. Continue reinforcement across construction joints, unless otherwise indicated.

2. Form from preformed galvanized steel, plastic keyway-section forms, or bulkhead forms with keys, unless otherwise indicated. Embed keys at least 1-1/2 inches (38 mm) into concrete.

3. Space vertical joints in walls as indicated. Locate joints beside piers integral with walls, near corners, and in concealed locations where possible.

4. Use epoxy-bonding adhesive at locations where fresh concrete is placed against hardened or partially hardened concrete surfaces.

C. Contraction (Control) Joints in Slabs-on-Grade: Form weakened-plane contraction joints, sectioning concrete into areas as indicated. Construct contraction joints for a depth equal to at least one-fourth of concrete thickness, as follows:

1. Sawed Joints: Form contraction joints with power saws equipped with shatterproof abrasive or diamond-rimmed blades. Cut 1/8-inch- (3-mm-) wide joints into concrete when cutting action will not tear, abrade, or otherwise damage surface and before concrete develops random contraction cracks.

D. Isolation (Expansion) Joints in Slabs-on-Grade: After removing formwork, install joint-filler strips at slab junctions with vertical surfaces, such as column pedestals, foundation walls, grade beams, and other locations, as indicated.
1. Extend joint-filler strips full width and depth of joint, terminating flush with finished concrete surface, unless otherwise indicated.
2. Terminate full-width joint-filler strips not less than 1/2 inch (12 mm) or more than 1 inch (25 mm) below finished concrete surface where joint sealants, specified in Division 7 Section "Joint Sealants," are indicated.
3. Install joint-filler strips in lengths as long as practicable. Where more than one length is required, lace or clip sections together.

E. Dowel Joints: Install dowel sleeves and dowels or dowel bar and support assemblies at joints where indicated.

1. Use dowel sleeves or lubricate or asphalt-coat one-half of dowel length to prevent concrete bonding to one side of joint.

3.6 CONCRETE PLACEMENT

A. Before placing concrete, verify that installation of formwork, reinforcement, and embedded items is complete and that required inspections have been performed.

B. Before placing concrete, water may be added at Project site, subject to limitations of ACI 301.

1. Batch tickets to specifically note quantity of water which may be added.

2. Do not add water to concrete after adding high-range water-reducing admixtures to mix.

C. Deposit concrete continuously or in layers of such thickness that no new concrete will be placed on concrete that has hardened enough to cause seams or planes of weakness. If a section cannot be placed continuously, provide construction joints as specified. Deposit concrete to avoid segregation.

D. Deposit concrete in forms in horizontal layers no deeper than 24 inches (600 mm) and in a manner to avoid inclined construction joints. Place each layer while preceding layer is still plastic, to avoid cold joints.

1. Consolidate placed concrete with mechanical vibrating equipment. Use equipment and procedures for consolidating concrete recommended by ACI 309R.

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 vibrator. Place vibrators to rapidly penetrate placed layer and at least 6 inches (150 mm) into preceding layer. Do not insert vibrators into lower layers of concrete that have begun to lose plasticity. 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 constituents to segregate.

E. Deposit and consolidate concrete for floors and slabs in a continuous operation, within limits of construction joints, until placement of a panel or section is complete.

1. Consolidate concrete during placement operations so concrete is thoroughly worked around reinforcement and other embedded items and into corners.


3. Screed slab surfaces with a straightedge and strike off to correct elevations.

4. Slope surfaces uniformly to drains where required.
5. Begin initial floating using bull floats or darbies to form a uniform and open-textured surface plane, free of humps or hollows, before excess moisture or bleedwater appears on the surface. Do not further disturb slab surfaces before starting finishing operations.

F. Cold-Weather Placement: Comply with ACI 306.1 and as follows. Protect concrete work from physical damage or reduced strength that could be caused by frost, freezing actions, or low temperatures.

1. When air temperature has fallen to or is expected to fall below 40 deg F (4.4 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.
2. Do not use frozen materials or materials containing ice or snow. Do not place concrete on frozen subgrade or on subgrade containing frozen materials.
3. Do not use calcium chloride, salt, or other materials containing antifreeze agents or chemical accelerators, unless otherwise specified and approved in mix designs.

G. Hot-Weather Placement: Place concrete according to recommendations in ACI 305R and as follows, when hot-weather conditions exist:

1. Cool ingredients before mixing to maintain concrete temperature below 90 deg F (32 deg C) at time of placement. Chilled mixing water 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 steel reinforcement with water-soaked burlap so steel temperature will not exceed ambient air temperature immediately before embedding in concrete.
3. Fog-spray forms, steel reinforcement, and subgrade just before placing concrete. Keep subgrade moisture uniform without standing water, soft spots, or dry areas.

3.7 FINISHING FORMED SURFACES

A. Rough-Formed Finish: As-cast concrete texture imparted by form-facing material with tie holes and defective areas repaired and patched. Remove fins and other projections exceeding ACI 347R limits for class of surface specified.

B. Smooth-Formed Finish: As-cast concrete texture imparted by form-facing material, arranged in an orderly and symmetrical manner with a minimum of seams. Repair and patch tie holes and defective areas. Remove fins and other projections exceeding 1/8 inch (3 mm) in height.

1. Apply to concrete surfaces exposed to public view or to be covered with a coating or covering material applied directly to concrete, such as waterproofing, dampproofing, veneer plaster, or painting.

C. Rubbed Finish: Apply the following to smooth-formed finished as-cast concrete, all exposed concrete vertical walls and where indicated:

1. Smooth-Rubbed Finish: Not later than one 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. 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.

3.8 FINISHING FLOORS AND SLABS

A. General: Comply with recommendations in ACI 302.1R for screeding, restraightening, and finishing operations for concrete surfaces. Do not wet concrete surfaces.

B. Scratch Finish: While still plastic, texture concrete surface that has been screeded and bull-floated or darbied. Use stiff brushes, brooms, or rakes.

1. Apply scratch finish to surfaces indicated and to surfaces to receive mortar setting beds for tile floor finishes.

C. Float Finish: Consolidate surface with power-driven floats or by hand floating if area is small or inaccessible to power driven floats. Re-straighten, cut down high spots, and fill low spots. Repeat float passes and re-straightening until surface is left with a uniform, smooth, granular texture.

1. Apply float finish to surfaces indicated, to surfaces to receive trowel finish.

D. Trowel Finish: After applying float finish, apply first trowel finish and consolidate concrete by hand or power-driven trowel. Continue troweling passes and re-straighten until surface is free of trowel marks and uniform in texture and appearance. Grind smooth any surface defects that would telegraph through applied coatings or floor coverings.

1. Apply a trowel finish to surfaces indicated and to floor and slab surfaces exposed to view or to be covered with resilient flooring, carpet, tile set over a cleavage membrane, or thin film-finish coating system.

2. Do not air entrain concrete to trowel-finished interior floors and suspended slabs. Do not allow entrapped air content to exceed 3 percent.

E. Trowel and Fine-Broom Finish: Apply a partial trowel finish, stopping after second troweling, to surfaces indicated and to surfaces where tile is to be installed. Immediately after second troweling, and when concrete is still plastic, slightly scarify surface with a fine broom.

F. Broom Finish: Apply a broom finish to exterior concrete platforms, steps, and ramps, and elsewhere as indicated.

1. Immediately after float finishing, slightly roughen trafficked surface by brooming with fiber-bristle broom perpendicular to main traffic route. Coordinate required final finish with Architect before application.

G. Finish surfaces to the following tolerances, measured within 24 hours:

1. Finish and measure surface so gap at any point between concrete surface and an unlevelled freestanding 10-foot- (3.05-m-) long straightedge, resting on two high spots and placed anywhere on the surface, does not exceed the following:
   a. 1/8 inch (3.2 mm).

3.9 MISCELLANEOUS CONCRETE ITEMS

A. Filling In: Fill in holes and openings left in concrete structures, unless otherwise indicated, after work of other trades is in place. Mix, place, and cure concrete, as specified, to blend with in-
B. Equipment Bases and Foundations: Provide machine and equipment bases and foundations as shown on Drawings. Set anchor bolts for machines and equipment at correct elevations, complying with diagrams or templates of manufacturer furnishing machines and equipment.

3.10 CONCRETE PROTECTION AND CURING

A. General: Protect freshly placed concrete from premature drying and excessive cold or hot temperatures. Comply with ACI 306.1 for cold-weather protection and with recommendations in ACI 305R for hot-weather protection during curing.

B. Evaporation Retarder: Apply evaporation retarder to unformed concrete surfaces if hot, dry, or windy conditions cause moisture loss approaching 0.2 lb/sq. ft. x h (1 kg/sq. m x h) before and during finishing operations. Apply according to manufacturer’s written instructions after placing, screeding, and bull floating or darbying concrete, but before float finishing.

C. Formed Surfaces: Cure formed concrete surfaces, including underside of beams, supported slabs, and other similar surfaces. If forms remain during curing period, moist cure after loosening forms. If removing forms before end of curing period, continue curing by one or a combination of the following methods:
   a. Water.
   b. Continuous water-fog spray.
   c. Absorptive cover, water saturated, and kept continuously wet. Cover concrete surfaces and edges with 12-inch (300-mm) lap over adjacent absorptive covers.

D. Unformed Surfaces: Begin curing immediately after finishing concrete. Cure unformed surfaces, including floors and slabs, concrete floor toppings, walks and pavement, and other surfaces, by one or a combination of the following methods:
   1. Moisture Curing: Keep surfaces continuously moist for not less than seven days with the following materials:
      a. Water.
      b. Continuous water-fog spray.
      c. Absorptive cover, water saturated, and kept continuously wet. Cover concrete surfaces and edges with 12-inch (300-mm) lap over adjacent absorptive covers.
   2. Moisture-Retaining-Cover Curing: Cover concrete surfaces with moisture-retaining cover for curing concrete, placed in widest practicable width, with sides and ends lapped at least 12 inches (300 mm), and sealed by waterproof tape or adhesive. Cure for not less than seven days. Immediately repair any holes or tears during curing period using cover material and waterproof tape.
      a. Moisture cure or use moisture-retaining covers to cure concrete surfaces to receive floor coverings.
      b. Moisture cure or use moisture-retaining covers to cure concrete surfaces to receive penetrating liquid floor treatments.
      c. Cure concrete surfaces to receive floor coverings with either a moisture-retaining cover or a curing compound that the manufacturer recommends for use with floor coverings.
3. Curing Compound: Apply uniformly in continuous operation by power spray or roller according to manufacturer's written instructions. Recoat areas subjected to heavy rainfall within three hours after initial application. Maintain continuity of coating and repair damage during curing period.

3.11 JOINT FILLING

A. Prepare, clean, and install joint filler according to manufacturer's written instructions.

1. Defer joint filling until construction traffic has permanently ceased.

B. Remove dirt, debris, saw cuttings, curing compounds, and sealers from joints; leave contact faces of joint clean and dry.

C. Install semirigid epoxy joint filler full depth in saw-cut joints and at least 2 inches (50 mm) deep in formed joints. Overfill joint and trim joint filler flush with top of joint after hardening.

3.12 CONCRETE SURFACE REPAIRS

A. Defective Concrete: Repair and patch defective areas when approved by WSU Project Manager. Remove and replace concrete that cannot be repaired and patched to WSU Project Manager’s approval.

B. Patching Mortar: Mix dry-pack patching mortar, consisting of one part portland cement to two and one-half parts fine aggregate passing a No. 16 (1.2-mm) sieve, using only enough water for handling and placing.

C. Repairing Formed Surfaces: Surface defects include color and texture irregularities, cracks, spalls, air bubbles, honeycombs, rock pockets, fins and other projections on the surface, and stains and other discolorations that cannot be removed by cleaning.

1. Immediately after form removal, cut out honeycombs, rock pockets, and voids more than 1/2 inch (13 mm) in any dimension in solid concrete but not less than 1 inch (25 mm) in depth. Make edges of cuts perpendicular to concrete surface. Clean, dampen with water, and brush-coat holes and voids with bonding agent. Fill and compact with patching mortar before bonding agent has dried. Fill form-tie voids with patching mortar or cone plugs secured in place with bonding agent.

2. Repair defects on surfaces exposed to view by blending white portland cement and standard portland cement so that, when dry, patching mortar will match surrounding color. Patch a test area 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.

3. Repair defects on concealed formed surfaces that affect concrete's durability and structural performance as determined by WSU Project Manager.

D. Repairing Unformed Surfaces: Test unformed surfaces, such as floors and slabs, for finish and verify surface tolerances specified for each surface. Correct low and high areas. Test surfaces sloped to drain for trueness of slope and smoothness; use a sloped template.

1. Repair finished surfaces containing defects. Surface defects include spalls, popouts, honeycombs, rock pockets, crazing and cracks in excess of 0.01 inch (0.25 mm) wide or that penetrate to reinforcement or completely through unreinforced sections regardless of width, and other objectionable conditions.
2. After concrete has cured at least 14 days, correct high areas by grinding.

3. Correct low areas scheduled to receive floor coverings with a repair underlayment. Prepare, mix, and apply repair underlayment and primer according to manufacturer's written instructions to produce a smooth, uniform, plane, and level surface. Feather edges to match adjacent floor elevations.

4. Correct other low areas scheduled to remain exposed with a repair topping. Cut out low areas to ensure a minimum repair topping depth of 1/4 inch (6 mm) to match adjacent floor elevations. Prepare, mix, and apply repair topping and primer according to manufacturer's written instructions to produce a smooth, uniform, plane, and level surface.

5. Repair defective areas, except random cracks and single holes 1 inch (25 mm) or less in diameter, by cutting out and replacing with fresh concrete. Remove defective areas with clean, square cuts and expose steel reinforcement with at least 3/4 inch (19 mm) clearance all around. Dampen concrete surfaces in contact with patching concrete and apply bonding agent. Mix patching concrete of same materials and mix as original concrete except without coarse aggregate. Place, compact, and finish to blend with adjacent finished concrete. Cure in same manner as adjacent concrete.

6. Repair random cracks and single holes 1 inch (25 mm) or less in diameter with patching mortar. Groove top of cracks and cut out holes to sound concrete and clean off dust, dirt, and loose particles. Dampen cleaned concrete surfaces and apply bonding agent. Place patching mortar before bonding agent has dried. Compact patching mortar and finish to match adjacent concrete. Keep patched area continuously moist for at least 72 hours.

E. Perform structural repairs of concrete, subject to WSU Project Manager's approval, using epoxy adhesive and patching mortar.

F. Repair materials and installation not specified above may be used, subject to WSU Project Manager's approval.

3.13 FIELD QUALITY CONTROL

A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to sample materials, perform tests, and submit test reports during concrete placement according to requirements specified in this Article.

B. Testing Services: Testing of composite samples of fresh concrete obtained according to ASTM C 172 shall be performed according to the following requirements:

1. Testing Frequency: Obtain at least one composite sample for each 50 cu. yd. (38 cu. m) or fraction thereof of each concrete mix placed each day.
   a. When frequency of testing will provide fewer than five compressive-strength tests for each concrete mix, testing shall be conducted from at least five randomly selected batches or from each batch if fewer than five are used.

2. Slump: ASTM C 143; one test at point of placement for each composite sample, but not less than one test for each day's pour of each concrete mix. Perform additional tests when concrete consistency appears to change.

3. Air Content: ASTM C 231, pressure method, for normal-weight concrete; ASTM C 173, volumetric method, for structural lightweight concrete; one test for each composite sample, but not less than one test for each day's pour of each concrete mix.

4. Concrete Temperature: ASTM C 1064; one test hourly when air temperature is 40 deg F (4.4 deg C) and below and when 80 deg F (27 deg C) and above, and one test for each composite sample.

5. Unit Weight: ASTM C 567, fresh unit weight of structural lightweight concrete; one test for each composite sample, but not less than one test for each day's pour of each concrete mix.
6. Compression Test Specimens: ASTM C 31/C 31M; cast and laboratory cure one set of six standard cylinder specimens for each composite sample.
   a. Cast and field cure one set of six standard cylinder specimens for each composite sample.

7. Compressive-Strength Tests: ASTM C 39; test one laboratory-cured specimens at 7 days, 14 days, and at 28 days.
   a. Test one field-cured specimens at 7 days, 14 days, and 28 days.
   b. A compressive-strength test shall be reported on the field break and not the lab break.

C. When strength of field-cured cylinders is less than 85 percent of companion laboratory-cured cylinders, Contractor shall evaluate operations and provide corrective procedures for protecting and curing in-place concrete.

D. Strength of each concrete mix will be satisfactory if every average of any three consecutive compressive-strength tests equals or exceeds specified compressive strength and no compressive-strength test value falls below specified compressive strength by more than 500 psi (3.4 MPa).

E. Test results shall be reported in writing to WSU Project Manager, concrete manufacturer, and Contractor within 48 hours of testing. Reports of compressive-strength tests shall contain Project identification name and number, date of concrete placement, name of concrete testing and inspecting agency, location of concrete batch in Work, design compressive strength at 28 days, concrete mix proportions and materials, compressive breaking strength, and type of break for 7-day, 14-day, and 28-day tests.

F. Nondestructive Testing: Impact hammer, sonoscope, or other nondestructive device may be permitted by WSU Project Manager but will not be used as sole basis for approval or rejection of concrete.

G. Additional Tests: Testing and inspecting agency shall make additional tests of concrete when test results indicate that slump, air entrainment, compressive strengths, or other requirements have not been met, as directed by WSU Project Manager. Testing and inspecting agency may conduct tests to determine adequacy of concrete by cored cylinders complying with ASTM C 42 or by other methods as directed by WSU Project Manager.