

Item 4094

Synthetic Fiber Reinforced Concrete Pipe



1. DESCRIPTION

Furnish and install synthetic fiber reinforced concrete pipe materials for precast synthetic fiber reinforced concrete pipe culverts.

This specification was developed specifically for the implementation monitoring study of synthetic fiber reinforced concrete pipe, and is not available for general use until the results of the implementation study have been reviewed by the Texas Department of Transportation.

2. MATERIALS

- 2.1. **Fabrication.** Fabrication plants must be approved by the Construction Division in accordance with [DMS-7310](#), "Reinforced Concrete Pipe and Machine-Made Precast Concrete Box Culvert Fabrication and Plant Qualification," before furnishing precast reinforced concrete pipe for Department projects. The Department's Material Producer List (MPL) has a list of approved reinforced concrete pipe plants.

Furnish material and fabricate reinforced concrete pipe in accordance with [DMS-7310](#), "Reinforced Concrete Pipe and Machine-Made Precast Concrete Box Culvert Fabrication and Plant Qualification," and [ASTM C1818](#), "Standard Specification for Synthetic Fiber Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe."

Use synthetic fibers that were successfully tested by an independent third-party laboratory per Section 9, "Synthetic Fiber-Concrete Matrix Qualification Testing" of ASTM C1818. Use the long-term serviceability factor resulting from this testing. Provide results of this testing to the Engineer when requested.

Test each pipe size and class per Section 10, "Pipe Proof of Design Testing" of ASTM C1818. Perform this testing for each wall thickness, concrete mix, and dosage of synthetic fibers used to produce a certain size and class of pipe.

Perform quality assurance three-edge bearing testing on synthetic fiber reinforced concrete pipe in accordance with ASTM C497, "Test Methods for Concrete Pipe, Manhole Sections, or Tile" and the provisions in Sections 11.3 and 11.4 of ASTM C1818. Perform this testing on one pipe per production run, or every 200 pieces of like size and class of pipe, whichever is less.

- 2.2. **Design.**

- 2.2.1. **General.** The class and D-load equivalents to produce the ultimate loads and service loads are shown in Table 1.

Table 1
Circular Pipe
ASTM C1818

Class	D-Load to produce the ultimate load (D_{ult}) ¹	D-Load to produce service load ($D_{service}$) ²
I	1,200	800
II	1,500	1000
III	2,025	1350
IV	3,000	2000
V	4,500	3000

1. Footnote 1. D_{ult} – The load the pipe is required to support in the three-edge bearing test expressed as a D-load (lb-force/linear ft/ft of diameter).

2. Footnote 2. $D_{service}$ – The maximum allowable load on the pipe after installation expressed as a D-load (lb-force/linear ft/ft of diameter).

2.3. **Marking.** Furnish each section of reinforced concrete pipe marked with the following information specified in [DMS-7310](#), “Reinforced Concrete Pipe and Machine-Made Precast Concrete Box Culvert Fabrication and Plant Qualification,” and [ASTM C1818](#), “Standard Specification for Synthetic Fiber Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe”.

- class or D-load (D_{ult}) of pipe,
- ASTM designation,
- date of manufacture,
- pipe size,
- type and commercial name of fiber
- amount of fiber used in lb. per cu. yd. (pcy)
- name or trademark of fabricator and plant location,
- designated fabricator’s approval stamp, and
- designation “SR” for pipe meeting sulfate-resistant concrete plan requirements (when applicable).

2.4. **Inspection.** Provide access for inspection of the finished pipe at the project site before and during installation.

2.5. **Causes for Rejection.** Individual section of pipe may be rejected for any of the conditions stated in the Annex of [DMS-7310](#), “Reinforced Concrete Pipe and Machine-Made Precast Concrete Box Culvert Fabrication and Plant Qualification,” and [ASTM C1818](#), “Standard Specification for Synthetic Fiber Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe. Exposure of synthetic fibers is not a cause for rejection.

2.6. **Repairs.** Make repairs if necessary as stated in the Annex of DMS-7310, “Reinforced Concrete Pipe and Machine-Made Precast Concrete Box Culvert Fabrication and Plant Qualification.”

2.7. **Jointing Materials.** Use any of the following materials for the making of joints unless otherwise shown on the plans. Furnish a manufacturer’s certificate of compliance for all jointing materials except mortar.

2.7.1. **Mortar.** Provide mortar for joints that meets the requirements of Section 464.3.3., “Jointing.”

2.7.2. **Cold-Applied, Plastic Asphalt Sewer Joint Compound.** Provide a material that consists of natural or processed asphalt base, suitable volatile solvents, and inert filler. Ensure the consistency is such that the ends of the pipe can be coated with a layer of the compound up to 1/2 in. thick by means of a trowel. Provide a joint compound that cures to a firm, stiff plastic condition after application. Provide a material of a uniform mixture. Stir any small separation found in the container into a uniform mix before using.

Provide a material that meets the requirements of Table 2 when tested in accordance with [Tex-526-C](#).

Table 2
Cold-Applied, Plastic Asphalt Sewer Joint Compound Material Requirements

Composition	Analysis
Asphalt base, 100%–% volatiles–% ash, % by weight	28–45
Volatiles, 212°F evaporation, 24 hr., % by weight	10–26
Mineral matter, determined as ash, % by weight	30–55
Consistency, cone penetration, 150 q, 5 sec., 77°F	150–275

2.7.3. **Rubber Gaskets.** Provide gaskets that conform to ASTM C1619 Class A or C. Meet the requirements of ASTM C443 for design of the pipe joints and permissible variations in dimensions.

- 2.7.4. **Pre-Formed Flexible Joint Sealants.** Pre-formed flexible joint sealants may be used for sealing joints of tongue-and-groove concrete pipe. Provide flexible joint sealants that meet the requirements of ASTM C990. Use flexible joint sealants that do not depend on oxidizing, evaporating, or chemical action for its adhesive or cohesive strength. Supply in extruded rope form of suitable cross-section. Provide a size of the pre-formed flexible joint sealant in accordance with the manufacturer's recommendations and large enough to properly seal the joint. Protect flexible joint sealants with a suitable wrapper able to maintain the integrity of the jointing material when the wrapper is removed.

3. CONSTRUCTION

- 3.1. **Excavation, Shaping, Bedding, and Backfill.** Excavate, shape, bed, and backfill in accordance with Item 400, "Excavation and Backfill for Structures," except where jacking, boring, or tunneling methods are permitted. Jack, bore, or tunnel the pipe in accordance with Item 476, "Jacking, Boring, or Tunneling Pipe or Box" are not allowed. Immediate backfilling is permitted if joints consist of materials other than mortar. Take special precautions in placing and compacting the backfill to avoid any movement of the pipe or damage to the joints. Do not use heavy earth-moving equipment to haul over the structure until a minimum of 4 ft. of permanent or temporary compacted fill has been placed over the structure unless otherwise shown on the plans or permitted in writing. Remove and replace pipe damaged by the Contractor at no expense to the Department.
- 3.2. **Laying Pipe.** Start the laying of pipe on the bedding at the outlet end with the spigot or tongue end pointing downstream, and proceed toward the inlet end with the abutting sections properly matched, true to the established lines and grades unless otherwise authorized. Fit, match, and lay the pipe to form a smooth, uniform conduit. Cut cross trenches in the foundation to allow the barrel of the pipe to rest firmly upon the bedding where bell-and-spigot pipe is used. Cut cross trenches no more than 2 in. larger than the bell ends of the pipe. Lower sections of pipe into the trench without damaging the pipe or disturbing the bedding and the sides of the trench. Carefully clean the ends of the pipe before the pipe is placed. Prevent the earth or bedding material from entering the pipe as it is laid. Lay the pipe in the trench, when elliptical pipe with circular reinforcing or circular pipe with elliptical reinforcing is used, so the markings for the top or bottom are not more than 5° from the vertical plane through the longitudinal axis of the pipe. Remove and re-lay, without extra compensation, pipe that is not in alignment or shows excessive settlement after laying.

Lay multiple lines of synthetic fiber reinforced concrete pipe with the centerlines of the individual barrels parallel. Use the clear distances between outer surfaces of adjacent pipes shown in Table 3 unless otherwise shown on the plans.

Table 3
Minimum Clear Distance between Pipes

Equivalent Diameter	Min Clear Distance
18 in.	9 in.
24 in.	11 in.
30 in.	1 ft. 1 in.
36 in.	1 ft. 3 in.
42 in.	1 ft. 5 in.
48 in.	1 ft. 7 in.
54 in.	1 ft. 11 in.
60 to 84 in.	2 ft.

- 3.3. **Jointing.** Make available an appropriate rolling device similar to an automobile mechanic's "creeper" for conveyance through small-size pipe structures.
- 3.3.1. **Joints Sealed with Hydraulic Cement Mortar.** Use Type S mortar meeting the requirements of ASTM C270. Clean and wet the pipe ends before making the joint. Plaster the lower half of the bell or groove and the upper half of the tongue or spigot with mortar. Pack mortar into the joint from both inside and outside the pipe after the pipes are tightly jointed. Finish the inside smooth and flush with adjacent joints of pipe. Form a bead of semicircular cross-section over tongue-and-groove joints outside the pipe, extending at least 1 in. on each side of the joint. Form the mortar for bell-and-spigot joints to a 45° fillet between the outer edge of the bell and the spigot. Cure mortar joints by keeping the joints wet for at least 48 hr. or until the backfill

has been completed, whichever comes first. Place fill or backfill once the mortar jointing material has cured for at least 6 hr. Conduct jointing only when the atmospheric temperature is above 40°F. Protect mortared joints against freezing by backfilling or other approved methods for at least 24 hr.

Driveway culverts do not require mortar banding on the outside of the pipe.

Furnish pipes, with approval, that are large enough for a person to enter with the groove between 1/2 in. and 3/4 in. longer than the tongue. Such pipe may be laid and backfilled without mortar joints. Clean the space on the interior of the pipe between the end of the tongue and the groove of all foreign material, thoroughly wet and fill with mortar around the entire circumference of the pipe, and finish flush after the backfilling has been completed.

- 3.3.2. **Joints Using Cold-Applied, Plastic Asphalt Sewer Joint Compound.** Ensure both ends of the pipes are clean and dry. Trowel or otherwise place a 1/2-in. thick layer of the compound in the groove end of the pipe covering at least 2/3 of the joint face around the entire circumference. Shove home the tongue end of the next pipe with enough pressure to make a tight joint. Remove any excess mastic projecting into the pipe after the joint is made. Backfill after the joint has been inspected and approved.
- 3.3.3. **Joints Using Rubber Gaskets.** Make the joint assembly according to the recommendations of the gasket manufacturer. Make joints watertight when using rubber gaskets. Backfill after the joint has been inspected and approved.
- 3.3.4. **Joints Using Pre-Formed Flexible Joint Sealants.** Install pre-formed flexible joint sealants in accordance with the manufacturer's recommendations. Place the joint sealer so no dirt or other deleterious materials come in contact with the joint sealing material. Pull or push home the pipe with enough force to properly seal the joint. Remove any joint material pushed out into the interior of the pipe that would tend to obstruct the flow. Store pre-formed flexible joint sealants in an area warmed naturally or artificially to above 70°F in an approved manner when the atmospheric temperature is below 60°F. Apply flexible joint sealants to pipe joints immediately before placing pipe in trench, and connect pipe to previously laid pipe. Backfill after the joint has been inspected and approved.
- 3.4. **Connections and Stub Ends.** Make connections of synthetic fiber concrete pipe to existing pipes, pipe storm drains, or storm drain appurtenances as shown on the plans.

Mortar or concrete the bottom of existing structures if necessary to eliminate any drainage pockets created by the connections. Repair any damage to the existing structure resulting from making the connections.

Finish stub ends for connections to future work not shown on the plans by installing watertight plugs into the free end of the pipe.

Fill lift holes with concrete, mortar, or precast concrete plugs after the pipe is in place.

4. MEASUREMENT

This Item will be measured by the foot. Measurement will be made between the ends of the pipe barrel along the flow line, not including safety end treatments. Safety end treatments will be measured in accordance with Item 467, "Safety End Treatment." Measurement of spurs, branches, or new connecting pipe will be made from the intersection of the flow line with the outside surface of the pipe into which it connects. Where inlets, headwalls, catch basins, manholes, junction chambers, or other structures are included in lines of pipe, the length of pipe tying into the structure wall will be included for measurement, but no other portion of the structure length or width will be included.

For multiple pipes, the measured length will be the sum of the lengths of the barrels.

This is a plans quantity measurement Item. The quantity to be paid is the quantity shown in the proposal unless modified by Article 9.2., "Plans Quantity Measurement." Additional measurements or calculations will be made if adjustments of quantities are required.

5. PAYMENT

The work performed and materials furnished in accordance with this Item and measured as provided under "Measurement" will be paid for at the unit price bid for "Synthetic Fiber Reinforced Concrete Pipe" of the size and class (**D_{service}**) specified. This price is full compensation for constructing, furnishing, transporting, placing, and joining pipes; shaping the bed; cutting pipes on skew or slope; connecting to new or existing structures; breaking back, removing, and disposing of portions of the existing structure; replacing portions of the existing structure; cutting pipe ends on skew or slope; and equipment, labor, tools, and incidentals.

Protection methods for excavations greater than 5 ft. deep will be measured and paid for as required under Item 402, "Trench Excavation Protection," or Item 403, "Temporary Special Shoring." Excavation, shaping, bedding, and backfill will be paid for in accordance with Item 400, "Excavation and Backfill for Structures."