

SECTION 03 41 00 - PRECAST STRUCTURAL CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:

- 1. Precast structural concrete.

- B. Related Requirements:

- 1. Section 03 30 00 "Cast-in-Place Concrete" for concrete topping and placing connection anchors in concrete.
- 2. Section 05 50 00 "Metal Fabrications" for other miscellaneous steel shapes.
- 3. Oregon Department of Transportation Standard Specifications for Construction 2024.

1.3 PREINSTALLATION MEETINGS

- A. Preinstallation Conference: Conduct conference at Project site.

1.4 ACTION SUBMITTALS

- A. Product Data: For each type of product.

- B. Design Mixtures: For each precast concrete mixture. Include compressive strength and, if required, water-absorption tests.

- C. Shop Drawings:

- 1. Include member locations, plans, elevations, dimensions, shapes and sections, openings, support conditions, and types of reinforcement, including special reinforcement.
- 2. Detail fabrication and installation of precast structural concrete units, including connections at member ends and to adjoining construction.
- 3. Indicate type, size, and length of welded connections by AWS standard symbols.
- 4. Detail loose and cast-in hardware, lifting and erection inserts, connections, and joints.

5. Indicate locations, tolerances, and details of anchorage devices to be embedded in or attached to structure or other construction.
6. Include and locate openings larger than 2 inches.
7. Indicate location of each precast structural concrete unit by same identification mark placed on panel.
8. Indicate relationship of precast structural concrete units to adjacent materials.
9. Indicate estimated camber for precast floor slabs with concrete toppings.
10. Indicate shim sizes and grouting sequence.
11. If design modifications are proposed to meet performance requirements and field conditions, submit design calculations and Shop Drawings. Do not adversely affect the appearance, durability, or strength of units when modifying details or materials and maintain the general design concept.

1.5 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For Installer and fabricator.
- B. Welding certificates.
- C. Material Certificates: For the following:
 1. Cementitious materials.
 2. Reinforcing materials and prestressing tendons.
 3. Admixtures.
 4. Bearing pads.
- D. Structural-steel shapes and hollow structural sections. Material Test Reports: For aggregates, by a qualified testing agency.
- E. Source quality-control reports.

1.6 QUALITY ASSURANCE

- A. Fabricator Qualifications: A firm that assumes responsibility for engineering precast structural concrete units to comply with performance requirements. Responsibility includes preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer for lifting, handling, and erection.
 1. Designated as a PCI-certified plant as follows:
 - a. Group C, Category C1 - Precast Concrete Products (no prestressed reinforcement), Category C2 - Prestressed Hollowcore and Repetitively Produced Products, Category C3 - Prestressed Straight Strand Structural Members and Category C4 - Prestressed Deflected Strand Structural Members.
- B. Installer Qualifications: A precast concrete erector qualified and designated by PCI's Certificate of Compliance, to erect Category S1 – Simple Structural Systems.

- C. Design Standards: Comply with ACI 318. ACI 201.2R “Guide to Durable Concrete” Sections 2.3 and 2.4, and design recommendations in PCI MNL 120 “PCI Design Handbook – Precast and Prestressed Concrete,” as applicable to types of precast structural concrete units indicated.
- D. Quality-Control Standard: For manufacturing procedures, testing requirements, and quality-control recommendations for types of units required, comply with PCI MNL 116, “Manual for Quality Control for Plants and Production of Structural Precast Concrete Products.”
- E. Welding Qualifications: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1/D1.1M, “Structural Welding Code - Steel.”
 - 2. AWS D1.4/D1.4M, “Structural Welding Code - Reinforcing Steel.”

1.7 COORDINATION

- A. Furnish loose connection hardware and anchorage items to be embedded in or attached to other construction before starting that Work. Provide locations, setting diagrams, templates, instructions, and directions, as required, for installation.

1.8 DELIVERY, STORAGE, AND HANDLING

- A. Support units during shipment on nonstaining shock-absorbing material in same position as during storage.
- B. Store units with adequate bracing and protect units to prevent contact with soil, to prevent staining, and to prevent cracking, distortion, warping or other physical damage.
 - 1. Store units with dunnage across full width of each bearing point unless otherwise indicated.
 - 2. Place adequate dunnage of even thickness between each unit.
 - 3. Place stored units so identification marks are clearly visible, and units can be inspected.
- C. Handle and transport units in a manner that avoids excessive stresses that cause cracking or damage.
- D. Lift and support units only at designated points indicated on Shop Drawings.

PART 2 - PRODUCTS

2.1 PRECAST PRESTRESSED VOIDED SLABS

- A. Design, fabrication, handling, and erection of precast concrete prestressed voided slabs, and all associated materials and accessories shall conform to the 2024 edition of the Oregon Department of Transportation Standard Specifications for Construction (ODOT

Spec). Refer to this Specification section where information is not provided in the ODOT Spec.

2.2 MOLD MATERIALS

- A. Molds: Rigid, dimensionally stable, non-absorptive material, warp and buckle free, that provides continuous precast concrete surfaces within fabrication tolerances indicated; nonreactive with concrete and suitable for producing required finishes.
 - 1. Mold-Release Agent: Commercially produced form-release agent that does not bond with, stain, or adversely affect precast concrete surfaces and does not impair subsequent surface or joint treatments of precast concrete.

2.3 REINFORCING MATERIALS

- A. Reinforcing Bars: ASTM A615/A615M, Grade 60, deformed.
- B. Low-Alloy-Steel Reinforcing Bars: ASTM A706/A706M, deformed.
- C. Galvanized Reinforcing Bars: ASTM A615/A615M, Grade 60 ASTM A706/A706M, deformed bars, with ASTM A767/A767M, Class II zinc coating. Galvanize after fabrication and bending.
- D. Epoxy-Coated Reinforcing Bars: ASTM A615/A615M, Grade 60, ASTM A706/A706M, deformed bars, ASTM A775/A775M epoxy coated, with less than 2 percent damaged coating in each 12-inch bar length.
- E. Supports: Suspend reinforcement from back of mold or use bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire reinforcement in place according to PCI MNL 116.

2.4 PRESTRESSING TENDONS

- A. Pretensioning Strand: ASTM A416/A416M, Grade 250 or Grade 270, uncoated, seven-wire, low-relaxation strand.
- B. Unbonded Post-Tensioning Strand: ASTM A416/A416M, Grade 270, uncoated, seven-wire, low-relaxation strand.
 - 1. Coat unbonded post-tensioning strand with post-tensioning coating complying with ACI 423.7 and sheath with polypropylene tendon sheathing complying with ACI 423.7. Include anchorage devices and coupler assemblies.
- C. Post-Tensioning Bars: ASTM A722/A722M, uncoated high-strength steel bar.

2.5 CONCRETE MATERIALS

- A. Portland Cement: ASTM C150/C150M, Type I or Type III, gray, unless otherwise indicated.
- B. Supplementary Cementitious Materials:
 - 1. Fly Ash: ASTM C618, Class C or F, with maximum loss on ignition of 3 percent.
 - 2. Metakaolin: ASTM C618, Class N.
 - 3. Silica Fume: ASTM C1240, with optional chemical and physical requirement.
 - 4. Ground Granulated Blast-Furnace Slag: ASTM C989, Grade 100 or 120.
- C. Normal-Weight Aggregates: Except as modified by PCI MNL 116, ASTM C33/C33M, with coarse aggregates complying with Class 4S or Class 4M. Stockpile fine and coarse aggregates for each type of exposed finish from a single source (pit or quarry) for Project.
- D. Water: Potable; free from deleterious material that may affect color stability, setting, or strength of concrete and complying with chemical limits of PCI MNL 116.
- E. Air-Entraining Admixture: ASTM C260, certified by manufacturer to be compatible with other required admixtures.
- F. Chemical Admixtures: Certified by manufacturer to be compatible with other admixtures and to not contain calcium chloride, or more than 0.15 percent chloride ions or other salts by weight of admixture.
 - 1. Water-Reducing Admixtures: ASTM C494/C494M, Type A.
 - 2. High-Range, Water-Reducing Admixture: ASTM C494/C494M, Type F.
 - 3. High-Range, Water-Reducing and Retarding Admixture: ASTM C494/C494M, Type G.
 - 4. Corrosion-Inhibiting Admixture: ASTM C1582/C1582M: Commercially formulated, anodic inhibitor or mixed cathodic and anodic inhibitor; capable of forming a protective barrier and minimizing chloride reactions with steel reinforcement in concrete.

2.6 STEEL CONNECTION MATERIALS

- A. Carbon-Steel Shapes and Plates: ASTM A36/A36M.
- B. Carbon-Steel-Headed Studs: ASTM A108, Grade 1010 through 1020, cold finished, AWS D1.1/D1.1M, Type A or B, with arc shields and with minimum mechanical properties of PCI MNL 116.
- C. Carbon-Steel Plate: ASTM A283/A283M, Grade C.
- D. Malleable-Iron Castings: ASTM A47/A47M, Grade 32510 or Grade 35028.
- E. Carbon-Steel Castings: ASTM A27/A27M, Grade 60-30 (Grade 415-205).
- F. High-Strength, Low-Alloy Structural Steel: ASTM A572/A572M.

- G. Carbon-Steel Structural Tubing: ASTM A500/A500M, Grade B or Grade C.
- H. Wrought Carbon-Steel Bars: ASTM A675/A675M, Grade 65.
- I. Deformed-Steel Wire or Bar Anchors: ASTM A496/A496M or ASTM A706/A706M.
- J. Carbon-Steel Bolts and Studs: ASTM A307, Grade A (ASTM F568M, Property Class 4.6); carbon-steel, hex-head bolts and studs; carbon-steel nuts, ASTM A563 (ASTM A563M); and flat, unhardened steel washers, ASTM F844.
- K. Zinc-Coated Finish: For exterior steel items and items indicated for galvanizing, apply zinc coating by hot-dip process according to ASTM A123/A123M or ASTM A153/A153M.
 - 1. For steel shapes, plates, and tubing to be galvanized, limit silicon content of steel to less than 0.03 percent or to between 0.15 and 0.25 percent or limit sum of silicon and 2.5 times phosphorous content to 0.09 percent.
 - 2. Galvanizing Repair Paint: High-zinc-dust-content paint with dry film containing not less than 94 percent zinc dust by weight and complying with DOD-P-21035B or SSPC-Paint 20.
- L. Welding Electrodes: Comply with AWS standards.
- M. Precast Accessories: Provide clips, hangers, plastic or steel shims, and other accessories required to install precast structural concrete units.

2.7 STAINLESS STEEL CONNECTION MATERIALS

- A. Stainless Steel Plate: ASTM A666, Type 304, Type 316.

2.8 BEARING PADS

- A. Provide the following bearing pads for precast structural concrete units as recommended by precast fabricator for application:
 - 1. Elastomeric Pads: 1/2-inch by 6-inch by 4'-0" at each slab in accordance with Oregon Department of Transportation Standard Specification for Construction 2024, Section 02571.

2.9 GROUT MATERIALS

- A. Sand-Cement Grout: Portland cement, ASTM C150/C150M, Type I, and clean, natural sand, ASTM C144 or ASTM C404. Mix at ratio of 1 part cement to 2-1/2 to 3 parts sand, by volume, with minimum water required for placement and hydration. Water-soluble chloride ion content less than 0.06 percent by weight of cement when tested according to ASTM C1218/C1218M.
- B. Nonmetallic, Nonshrink Grout: Packaged, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents,

plasticizing and water-reducing agents, complying with ASTM C1107/C1107M, Grade A for drypack and Grades B and C for flowable grout and of consistency suitable for application within a 30-minute working time. Water-soluble chloride ion content less than 0.06 percent by weight of cement when tested according to ASTM C1218/C1218M.

- C. Epoxy-Resin Grout: Two-component, mineral-filled epoxy resin; ASTM C881/C881M, of type, grade, and class to suit requirements.
 - 1. Face Size: 2-1/4 inches (57mm) high by 8 inches (203mm) long.

2.10 CONCRETE MIXTURES

- A. Prepare design mixtures for each type of precast concrete required in accordance with Section 03 30 00, Article 2.6.
- B. Design mixtures may be prepared by a qualified independent testing agency or by qualified precast plant personnel at precast structural concrete fabricator's option.
- C. Limit water-soluble chloride ions to maximum percentage by weight of cement permitted by ACI 318 or PCI MNL 116 when tested according to ASTM C1218/C1218M.
- D. C3A (tricalcium aluminate) content shall be a minimum of 4% but limited to a maximum of 10%.
- E. Normal-Weight Concrete Mixtures: Proportion by either laboratory trial batch or field test data methods according to ACI 211.1, with materials to be used on Project, to provide normal-weight concrete with the following properties:
 - 1. Compressive Strength (28 Days): Refer to Drawings.
 - 2. Maximum Water-Cementitious Materials Ratio: Refer to Drawings.
- F. Water Absorption: Limit water absorption to 6 percent by weight or 14 percent by volume, tested according to ASTM C642, except for boiling requirement.
- G. Add air-entraining admixture at manufacturer's prescribed rate to result in concrete at point of placement having an air content complying with PCI MNL 116.
- H. When included in design mixtures, add other admixtures to concrete mixtures according to manufacturer's written instructions.
- I. Concrete Mix Adjustments: Concrete mix design adjustments may be proposed if characteristics of materials, Project conditions, weather, test results, or other circumstances warrant.

2.11 MOLD FABRICATION

- A. Molds: Accurately construct molds, mortar tight, of sufficient strength to withstand pressures due to concrete-placement operations and temperature changes and for

prestressing and detensioning operations. Coat contact surfaces of molds with release agent before reinforcement is placed. Avoid contamination of reinforcement and prestressing tendons by release agent.

- B. Maintain molds to provide completed precast structural concrete units of shapes, lines, and dimensions indicated, within fabrication tolerances specified.
 - 1. Edge and Corner Treatment: Uniformly chamfered.

2.12 FABRICATION

- A. Cast-in Anchors, Inserts, Plates, Angles, and Other Anchorage Hardware: Fabricate anchorage hardware with sufficient anchorage and embedment to comply with design requirements. Accurately position for attachment of loose hardware, and secure in place during precasting operations. Locate anchorage hardware where it does not affect position of main reinforcement or concrete placement.
 - 1. Weld-headed studs and deformed bar anchors used for anchorage according to AWS D1.1/D1.1M and AWS C5.4, "Recommended Practices
 - 2. for Stud Welding."
- B. Furnish loose hardware items including steel plates, clip angles, seat angles, anchors, dowels, cramps, hangers, and other hardware shapes for securing precast structural concrete units to supporting and adjacent construction.
- C. Cast-in reglets, slots, holes, and other accessories in precast structural concrete units as indicated on the Contract Drawings.
- D. Cast-in openings larger than 6 inches in any dimension. Do not drill or cut openings or prestressing strand without Engineer's approval.
- E. Reinforcement: Comply with recommendations in PCI MNL 116 for fabricating, placing, and supporting reinforcement.
 - 1. Clean reinforcement of loose rust and mill scale, earth, and other materials that reduce or destroy the bond with concrete. When damage to epoxy-coated reinforcement exceeds limits specified or those in ASTM A775/A775M, whichever is stricter, repair with patching material compatible with coating material and epoxy coat bar ends after cutting.
 - 2. Accurately position, support, and secure reinforcement against displacement during concrete-placement and consolidation operations. Completely conceal support devices to prevent exposure on finished surfaces.
 - 3. Place reinforcing steel and prestressing strand to maintain at least 2-inch minimum concrete cover. Increase cover requirements for reinforcing steel to ACI 318 when units are exposed to corrosive environment or severe exposure conditions. Arrange, space, and securely tie bars and bar supports to hold reinforcement in position while placing concrete. Direct wire tie ends away from finished, exposed concrete surfaces.

- F. Reinforce precast structural concrete units to resist handling, transportation, and erection stresses.
- G. Prestress tendons for precast structural concrete units by either pretensioning or post-tensioning methods. Comply with PCI MNL 116.
 - 1. Delay detensioning or post-tensioning of precast, prestressed structural concrete units until concrete has reached its indicated minimum design release compressive strength as established by test cylinders cured under same conditions as concrete unit.
 - 2. Detension pretensioned tendons either by gradually releasing tensioning jacks or by heat cutting tendons, using a sequence and pattern to prevent shock or unbalanced loading.
 - 3. If concrete has been heat cured, detension while concrete is still warm and moist to avoid dimensional changes that may cause cracking or undesirable stresses.
 - 4. Protect strand ends and anchorages with bituminous, zinc-rich, or epoxy paint to avoid corrosion and possible rust spots.
 - 5. Protect strand ends and anchorages with a minimum of 2-inch- thick, nonmetallic, nonshrink, grout mortar and sack rub surface. Coat or spray the inside surfaces of pocket with bonding agent before installing grout.
- H. Comply with requirements in PCI MNL 116 and in this Section for measuring, mixing, transporting, and placing concrete. After concrete batching, no additional water may be added.
- I. Place concrete in a continuous operation to prevent cold joints or planes of weakness from forming in precast concrete units.
- J. Thoroughly consolidate placed concrete by vibration without dislocating or damaging reinforcement and built-in items, and minimize pour lines, honeycombing, or entrapped air voids on surfaces. Use equipment and procedures complying with PCI MNL 116.
- K. Comply with PCI MNL 116 procedures for hot- and cold-weather concrete placement.
- L. Identify pickup points of precast structural concrete units and orientation in structure with permanent markings, complying with markings indicated on Shop Drawings. Imprint or permanently mark casting date on each precast structural concrete unit on a surface that does not show in finished structure.
- M. Cure concrete, according to requirements in PCI MNL 116, by moisture retention without heat or by accelerated heat curing using live steam or radiant heat and moisture. Cure units until compressive strength is
- N. high enough to ensure that stripping does not have an effect on performance or appearance of final product.
- O. Discard and replace precast structural concrete units that do not comply with requirements, including structural, manufacturing tolerance, and appearance, unless repairs meet requirements in PCI MNL 116 and meet Engineer's approval.

2.13 FABRICATION TOLERANCES

- A. Fabricate precast structural concrete units to shapes, lines, and dimensions indicated so each finished unit complies with PCI MNL 116 product dimension tolerances as well as position tolerances for cast-in items.

2.14 COMMERCIAL FINISHES

- A. Standard Grade: Normal plant-run finish produced in molds that impart a smooth finish to concrete. Surface holes smaller than 1/2 inch caused by air bubbles, normal color variations, form joint marks, and minor chips and spalls are permitted. Fill air holes greater than 1/4 inch in width that occur more than once per 2 sq. in.. Major or unsightly imperfections, honeycombs, or structural defects are not permitted. Limit joint offsets to 1/8 inch.
- B. Screed or float finish unformed surfaces. Strike off and consolidate concrete with vibrating screeds to a uniform finish. Hand screed at projections. Normal color variations, minor indentations, minor chips, and spalls are permitted. Major imperfections, honeycombing, or defects are not permitted.

2.15 SOURCE QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified testing agency to evaluate precast structural concrete fabricator's quality-control and testing methods.
 - 1. Allow testing agency access to material storage areas, concrete production equipment, concrete placement, and curing facilities. Cooperate with testing agency and provide samples of materials and concrete mixtures as may be requested for additional testing and evaluation.
- B. Testing: Test and inspect precast structural concrete according to PCI MNL 116 requirements.
- C. Strength of precast structural concrete units is considered deficient if units fail to comply with ACI 318 requirements for concrete strength.
- D. If there is evidence that strength of precast concrete units may be deficient or may not comply with ACI 318 requirements, employ a qualified testing agency to obtain, prepare, and test cores drilled from hardened concrete to determine compressive strength according to ASTM C42/C42M.
 - 1. A minimum of three representative cores shall be taken from units of suspect strength, from locations directed by Engineer.
 - 2. Test cores in an air-dry condition or, if units are wet under service conditions, test cores after immersion in water in a wet condition.
 - 3. Strength of concrete for each series of three cores is considered satisfactory if average compressive strength is equal to at least 85 percent of 28-day design compressive strength and no single core is less than 75 percent of 28-day design compressive strength.

4. Report test results in writing on same day that tests are performed, with copies to Engineer, Contractor, and precast concrete fabricator. Test reports include the following:
 - a. Project identification name and number.
 - b. Date when tests were performed.
 - c. Name of precast concrete fabricator.
 - d. Name of concrete testing agency.
 - e. Identification letter, name, and type of precast concrete unit(s) represented by core tests; design compressive strength; type of break; compressive strength at breaks, corrected for length-diameter ratio; and direction of applied load to core in relation to horizontal plane of concrete as placed.
- E. Patching: If core test results are satisfactory and precast structural concrete units comply with requirements, clean and dampen core holes and solidly fill with same precast concrete mixture that has no coarse aggregate.
- F. Finish: Grout, and finish to match adjacent precast concrete surfaces.
- G. Defective Units: Discard and replace precast structural concrete units that do not comply with requirements, including strength and manufacturing tolerances. Chipped, spalled, or cracked units may be repaired, subject to Engineer's approval.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting structural frame conditions for compliance with requirements for installation tolerances, bearing surface tolerances, and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.
- C. Do not install precast concrete units until supporting, cast-in-place concrete has attained minimum allowable design compressive strength and until supporting steel or other structure is structurally ready to receive loads from precast concrete units.

3.2 INSTALLATION

- A. Install clips, hangers, bearing pads, and other accessories required for connecting precast structural concrete units to supporting members and backup materials.
- B. Erect precast structural concrete level, plumb, and square within specified allowable tolerances. Provide temporary structural framing, shoring, and bracing as required to maintain position, stability, and alignment of units until permanent connections are complete.

1. Install temporary steel or plastic spacing shims or bearing pads as precast structural concrete units are being erected. Tack weld steel shims to each other to prevent shims from separating.
 2. Maintain horizontal and vertical joint alignment and uniform joint width as erection progresses.
 3. Remove projecting lifting devices and grout fill voids within recessed lifting devices flush with surface of adjacent precast surfaces when recess is exposed.
 4. For bull rail beam used for conduit routing, align routings to match existing routing between units and tape butt joint at end of units.
- C. Connect precast structural concrete units in position by bolting, welding, grouting, or as otherwise indicated on Shop Drawings. Remove temporary shims, wedges, and spacers as soon as practical after connecting and grouting are completed.
- D. Do not permit connections to disrupt continuity of roof flashing. Field cutting of precast units is not permitted without approval of the Engineer.
- E. Fasteners: Do not use drilled or powder-actuated fasteners for attaching accessory items to precast, prestressed concrete units.
- F. Welding: Comply with applicable requirements in AWS D1.1/D1.1M and AWS D1.4/D1.4M for welding, welding electrodes, appearance, quality of welds, and methods used in correcting welding work.
1. Protect precast structural concrete units and bearing pads from damage by field welding or cutting operations, and provide noncombustible shields as required.
 2. Clean weld-affected steel surfaces with chipping hammer followed by brushing, and apply a minimum 4.0-mil- thick coat of galvanized repair paint to galvanized surfaces according to ASTM A780.
 3. Visually inspect welds and remove, reweld, or repair incomplete and defective welds.
- G. At bolted connections, use lock washers, tack welding, or other approved means to prevent loosening of nuts after final adjustment.
1. Where slotted connections are used, verify bolt position and tightness. For sliding connections, properly secure bolt but allow bolt to move within connection slot.
 2. For friction connections, apply specified bolt torque and check 25 percent of bolts at random by calibrated torque wrench.
- H. Grouting: Grout connections and joints and open spaces at keyways, connections, and joints where required or indicated on Shop Drawings. Retain grout in place until hard enough to support itself. Alternatively, pack spaces with stiff dry-pack grout material, tamping until voids are completely filled.
1. Place grout and finish smooth, level, and plumb with adjacent concrete surfaces.
 2. Fill joints completely without seepage to other surfaces.
 3. Trowel top of grout joints on roofs smooth and uniform. Finish transitions between different surface levels not steeper than 1 to 12.

4. Promptly remove grout material from exposed surfaces before it affects finishes or hardens.
5. Keep grouted joints damp for not less than 24 hours after initial set.

3.3 ERECTION TOLERANCES

- A. Erect precast structural concrete units level, plumb, square, and in alignment without exceeding the noncumulative erection tolerances of PCI MNL 135.
- B. Minimize variations between adjacent slab members by jacking, loading, or other method recommended by fabricator and approved by Engineer.

3.4 FIELD QUALITY CONTROL

- A. Special Inspections: Owner will engage a qualified special inspector to perform the following special inspections:
 1. Erection of precast structural concrete members.
- B. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.
- C. Visually inspect field welds and test according to ASTM E165 or to ASTM E709 and ASTM E1444. High-strength bolted connections are subject to inspections.
- D. Testing agency will report test results promptly and in writing to Engineer, Contractor and Owner.
- E. Repair or remove and replace work where tests and inspections indicate that it does not comply with specified requirements.
- F. Additional testing and inspecting, at Contractor's expense, shall be performed to determine compliance of replaced or additional work with specified requirements.
- G. Prepare test and inspection reports.

3.5 REPAIRS

- A. Repair precast structural concrete units if permitted by Engineer.
 1. Repairs may be permitted if structural adequacy, serviceability, durability, and appearance of units have not been impaired.
- B. Mix patching materials and repair units so cured patches blend with color, texture, and uniformity of adjacent exposed surfaces and show no apparent line of demarcation between original and repaired work, when viewed in typical daylight illumination from a distance of 40 feet.

- C. Prepare and repair damaged galvanized coatings with galvanizing repair paint according to ASTM A780.
- D. Wire brush, clean, and paint damaged prime-painted components with same type of shop primer.
- E. Remove and replace damaged precast structural concrete units that cannot be repaired or when repairs do not comply with requirements as determined by Engineer.

3.6 CLEANING

- A. Clean mortar, plaster, weld slag, and other deleterious material from concrete surfaces and adjacent materials immediately.
- B. Clean exposed surfaces of precast concrete units after erection and completion of joint treatment to remove weld marks, other markings, dirt, and stains.
 - 1. Perform cleaning procedures, if necessary, according to precast concrete fabricator's written recommendations. Clean soiled precast concrete surfaces with detergent and water, using stiff fiber brushes and sponges, and rinse with clean water. Protect other work from staining or damage due to cleaning operations.
 - 2. Do not use cleaning materials or processes that could change the appearance of exposed concrete finishes or damage adjacent materials.

END OF SECTION