

Construction Specification

516. PIPELINE

1. SCOPE

The work shall consist of furnishing materials and installing all components of a pipeline, as outlined in this specification and the drawings.

2. MATERIALS

All materials used shall conform to the quality and grade noted on the plans, set forth in Section 5, or as otherwise listed below:

PIPE

If the pipe is stored on site, it should be protected from sunlight.

Pipe and fittings shall meet the requirements of one of the following types and standards, or as otherwise set forth in Section 5 or on the drawings.

- a. Steel Pipe. AWWA standard C200; ASTM standards A53, A134, A135 and A139, A858, and A865.
- b. Ductile Iron. AWWA standard C600; and ASTM standard A746.
- c. Aluminum (Tubing). ASTM standards B210, B241, and B313; ANSI standards H35.1 and H35.2.
- d. Corrugated Metal. ASTM standards A760 and B745; AASHTO standards M36, M196, and M245. Pipe bands or couplers shall meet the requirements of the applicable pipe specification, except that channel bands (for use with flanged pipe), smooth or flat bands, nor dimple bands shall be allowed.
- e. Polyvinyl chloride (PVC). ASTM standards D1784, D1785, D2241, D2466, F794, D2774; AASHTO standard M304; AWWA standards C900 or C905; and ASABE/ANSI standard S376.
- f. Acrylonitrile-butadiene-styrene (ABS). ASTM standards D1527 and D3965.
- g. Polyethylene (PE; commonly referred to as PE or HDPE, the primary difference being product density). ASTM standards D3350, F714, D2104, D2239, D2447, D2737, D3035, F405, F667, F771, F894, and D2774; AASHTO standard M294; AWWA standards C901 and C906; and ASABE/ANSI standard S376.

Pipe shall be marked as directed by the applicable reference standard(s) but shall have at a minimum: nominal pipe size, pipe material, dimensioning system (IPS, NPS, Sch, etc), thickness (pressure rating or substitute designation from which the pressure rating can be obtained), and manufacture's name or trademark.

Unless otherwise set forth in Section 5, pipe and fittings shall have a protective coating applied and shall conform to one of the following specifications, as applicable:

AWWA C104, AWWA C116, AWWA C203, AWWA C203, AWWA C209, AWWA C210, AWWA C213, AWWA C214, AWWA C218, ASTM A53, ASTM A123/A 123M, or ASTM A153/A

All joints and connections shall be constructed to withstand the design working pressure for the pipeline without leakage and shall leave the inside of the pipeline free of any obstruction which could reduce the pipe capacity below design requirements.

All fittings, such as couplers, reducers, bends, tees and endives shall be made of material that is recommended for use with the type of pipe specified and shall be

installed in accordance with the recommendations of the pipe manufacturer.

manufacturer's recommendations, Section 5 and/or the drawings.

Joints and connections for steel pipe shall meet the following requirements:

CONCRETE

Field joints shall be installed according to the manufacturer's recommendations. On buried pipelines, high-resistance joints between pipe lengths shall be electrically bridged with a welded, brazed, or soldered copper wire. If coated pipe is field welded, care shall be taken to avoid burning the protective coating. After joints are welded, they shall be covered with a coating equal in quality to that specified for the pipe and hardware.

Concrete used for thrust blocks shall have a minimum compressive strength, at 28 days, of 3000 psi. If the supplier cannot show evidence that a mix will meet strength requirements, a mix with a maximum net water content of seven gallons per bag (94 lbs) of cement, and a minimum cement content of five and a half (5.5) bags per cubic yard of concrete, may be used.

Plastic pressure pipe fittings shall conform to the following ASTM specifications, as applicable:

3. PIPE INSTALLATION

D 2464, D 2466, D 2467, D 2468, D 2609, D, D 3139, or D 3261

Pipelines shall be placed so that they are protected against hazards imposed by traffic, livestock, farm operations, freezing temperatures, or soil cracking. Other means of protection must be provided if the depth required for protection is impracticable because of shallow soils over rock or for other reasons. Abrupt changes in grade must be avoided to prevent rupture of the pipe. All special pipe installation requirements of the pipe manufacturer shall be followed.

Solvents for solvent-welded plastic pipe joints shall conform to the following ASTM specifications, as applicable:

D 2235, D 2564, or D 2855

ABOVE GROUND INSTALLATIONS

Rubber gaskets for pipe joints shall conform to the requirements of ASTM F477.

For suspension installations the pipe supports (saddle, rack, stand, hanger, etc.) shall meet design specifications and manufacturer's or industry recommendations. Unless otherwise specified on the drawings, pipe shall (1) be supported a minimum of one foot above the ground, (2) have two layers of felt strips placed between the pipe and the support, and (3) have graphite lubricant placed between the pipe and the felt strip. Treated wood shall be used for timber supports.

VALVES AND OTHER APPURTENANCES

The pipeline valves and appurtenances shall be of the size, type, material and pressure rating as shown on the drawings. If not specified in the design, pressure ratings shall equal or exceed that of the pipe.

Pressure relief valves shall be stamped with the pressure at which the valve starts to open. Adjustable valves shall be sealed or otherwise altered to insure that the setting marked on the valve is not changed.

All other appurtenances, such as valve housings, shall be made of non-corrosive material and shall be according to

Unless otherwise specified on the drawings, above ground pipelines with restrained joints (e.g., welded steel or banded CMP) shall have: (1) expansion couplers installed at a spacing not to exceed 400 feet, (2) a maximum distance between a coupler and a fixed or anchored location of 200 feet, and

(3) couplers that provide for a minimum of 4 inches of travel distance.

For installations designed for laying the pipe across naturally occurring terrain, the pipe shall be firmly and uniformly bedded throughout its entire length. For corrugated metal pipe the bedding shall facilitate pipe installation so that at least the bottom 25% of the pipe circumference shall be in contact with the pipe. Unless otherwise specified on the design, bedding material shall be imported if the ground surface will result in point loads or unacceptable abrasion on the pipe (e.g., bedrock or rock outcrops). Blocking or mounding shall not be used to bring the pipe up to final grade. Unless otherwise specified on the drawings, supports/saddles specifications as described above shall be followed.

The pipe shall not be handled in a manner to cause damage to the pipe and its coating. The pipe shall not be rolled or dragged on the ground. The pipe shall be placed onto above ground supports by the use of canvas slings or padded cables. Individual joints of pipe shall be inspected and any damaged pipe shall be removed and replaced.

UNDERGROUND INSTALLATIONS

a. Trench Construction

Trench depth and depth of cover shall be as specified on the drawings.

Trench width at any point below the top of the pipe should be only wide enough to permit the pipe to be easily placed and joined and to allow the initial backfill to be safely and properly placed and compacted. The minimum trench width is dependent on backfill placing and compacting equipment, but for typical manual installation clearance on either side of the pipe shall be 9 inches unless the trench is precision excavated with a semicircular bottom that closely fits the pipe. In that case, the minimum clearance on either side of the pipe shall be 6 inches. The maximum trench width shall be no greater than the minimum required by backfill placing and compacting equipment, but for typical manual installation shall be 30 inches greater than the outside diameter of the pipe (i.e., maximum clearance between the pipe and trench wall shall be 15 inches).

Trenches more than 5 feet deep shall be shored, sloped, or benched to provide safe and stable trench walls. Unless otherwise specified on the drawings trenches shall be constructed according to Figures 1 through 5; or as provided in OSHA Construction Safety Regulations, Subpart P, Excavations, Appendix B – Sloping and Benching.

Where rock, hardpan, cobbles or other hard material which might prevent the pipe from being uniformly supported is encountered in the bottom of the trench, the trench shall be undercut a minimum of four inches below final grade. The trench shall then be brought back to grade with appropriate backfill material placed and compacted to provide proper bedding.

More than one pipe may be placed in a common trench. In such cases with typical manual installation the minimum and maximum clearances shall apply, and the minimum distance between pipes shall be 12 inches to facilitate safe and proper backfill installation.

b. Bedding

The pipe shall be firmly and uniformly bedded throughout its entire length. Bedding material, if necessary, shall be placed and spread in uniform layers and in such a manner as to fill the trench so there are no unfilled spaces (air pockets) below the pipe. For pipe with bell joints, holes shall be dug in the bedding at the bells to permit the body of the pipe to be in contact with the bedding along its entire length. Blocking or mounding shall not be used to bring the pipe up to final grade.

The pipe shall not be dropped into the trench or handled in a manner to cause damage. PVC pipe shall not be handled when the temperature is less than 20°F or greater than 100°F. PE pipe shall not be handled when the temperature is less than 10°F or greater than 110°F. The pipe shall be allowed to come within a few degrees of the temperature it will have after it is completely backfilled before placing fill other than that needed for shading or before connecting the pipe to other facilities. Individual joints of pipe shall be inspected and any damaged pipe shall be removed and replaced.

Thrust blocks shall be formed against a solid trench wall. They shall be of the minimum size and materials as specified on the drawings.

The thrust block cavity shall be in undisturbed soil or previously placed compacted backfill that yields an acceptable allowable bearing pressure. The cavity shall be formed with soil or wood to hold the freshly placed concrete without displacement until an initial set has occurred.

When excavation beyond the designated trench widths and depths, as shown on the drawings or specified in Section 5 of this specification, occurs at locations where installation of concrete thrust blocks is required, the contractor shall install an alternative thrust block provision.

The concrete thrust block shall have a thickness, length, and depth as shown on the drawings or specified in Section 5. Backfill shall be placed on all sides of the thrust block and to the sides of the excavation.

c. Backfill

Initial Backfill. Unless otherwise specified in the design solid wall pipe 18 inches nominal diameter or less the initial backfill material may be fine grained soil. This may be the on site trench excavated materials as long as any unsuitable materials are removed; it must be free of rocks, gravels, frozen materials larger than 1 inch or earth clods greater than 2 inch in diameter. Unless otherwise specified in the design, for solid wall pipe greater than 18 inches nominal diameter and corrugated, ribbed, or profile wall pipe, the initial backfill material shall be (1) angular 1 to ¼ inch size crush stone with a maximum of 10 percent cohesive fines or (2) sand and gravels (Soil types GW, GP, SW, and SP) with a maximum particle size of 1 inch containing a maximum of 12 percent of noncohesive fines. Sands shall have a maximum of 45 percent passing the # 40 sieve.

Unless otherwise specified in the design, initial backfill shall be placed in lifts no greater than 8 inches deep before being

compacted. For typical manual installation, each lift shall be worked to eliminate any unfilled spaces and compacted with appropriate tamping equipment and significant effort. When backfilling is done by mechanical means the initial fill shall first be worked to eliminate any voids.

The initial backfill materials shall be placed in a manner so as not to displace, deform or damage the pipe.

When water packing is used, the pipe shall be filled with water. The initial backfill, before wetting, shall be of sufficient depth to ensure complete coverage of the pipe with backfill after consolidation has taken place. Water packing shall be accomplished by adding water to diked reaches of the trench in such quantity as to thoroughly saturate the initial backfill. After the backfill is saturated, the fill shall be consolidated by rodding or with a vibrator. The wetted fill shall be allowed to dry until firm before completing the final backfill. The pipeline shall remain full of water until after the final backfill is placed.

Final Backfill. The final backfill material shall be free of rocks, frozen clods or other debris larger than 1 inch in diameter within 6 inches of the pipe and 6 inches in particle size for the remaining portion of the final backfill unless otherwise specified in the design. The material shall be placed and spread in approximately uniform layers so there are no unfilled spaces in the backfill. Rolling equipment shall not be used until a minimum of 18 inches of compacted backfill material has been placed over the top of the pipe

Final backfill shall result in a finished trench surface that is smooth, slightly rounded so that the trench surface is higher than the surrounding ground, free of rocks greater in size than the surrounding surface, and has a clean and finished appearance.

Plastic pipelines may be placed by plow-in equipment if soils are suitable and rocks and boulders will not damage the pipe.

All disturbed areas shall be revegetated according to the recommendations for permanent seeding as stated in Conservation Practice Standard PA342, Critical Area Planting and/or the Pennsylvania Agronomy Guide.

4. BASIS OF ACCEPTANCE

The acceptability of the pipeline shall be determined by inspections to check compliance with all the provisions of this standard and specifications including the design of the line, the pipe, and pipe marking, the appurtenances, and the minimum installation requirements.

The pipeline shall be pressure tested for leaks. Before pressure testing, the joints of the assembled pipeline shall be allowed to set as recommended by the manufacturer and all concrete thrust blocks shall be in place and allowed to cure for a minimum of 3 days.

Pipeline shall be pressure tested by one of the following methods:

- a. Before backfilling, fill the pipe with water and test at the design working head or at a minimum head of 10 ft., whichever is greater. All leaks must be repaired, and the test must be repeated before backfilling.
- b. Pressure test at the working pressure for 2 hours. The allowable leakage shall not be greater than one gallon per diameter inch per mile. If the test exceeds this rate, the defect must be repaired until retests show that the leakage is within the allowable limits, but all visible leaks must be repaired.

If water is not available to complete a test, the installer shall provide a guarantee stating they will return and fix leaks that are found when the pipe is initially filled with water.

All materials shall conform to these minimum requirements and to the tests prescribed in the applicable ASTM Specification. If requested by the engineer, a qualified testing laboratory must certify with supporting test results that the pipe meets the requirements specified in this specification. The seal of approval of a recognized laboratory on pipe bearing the

ASTM or AWWA designations may be accepted for this certification.

The installing contractor shall certify that the materials and installation comply with the requirements of these specifications. He shall furnish a written guarantee against defective workmanship and materials to cover a period of not less than one year. The installing contractor shall furnish a copy of the certification and guarantee, which will be made a part of the supporting records of the pipeline.

5. ADDITIONAL CONDITIONS WHICH APPLY TO THIS PROJECT ARE:

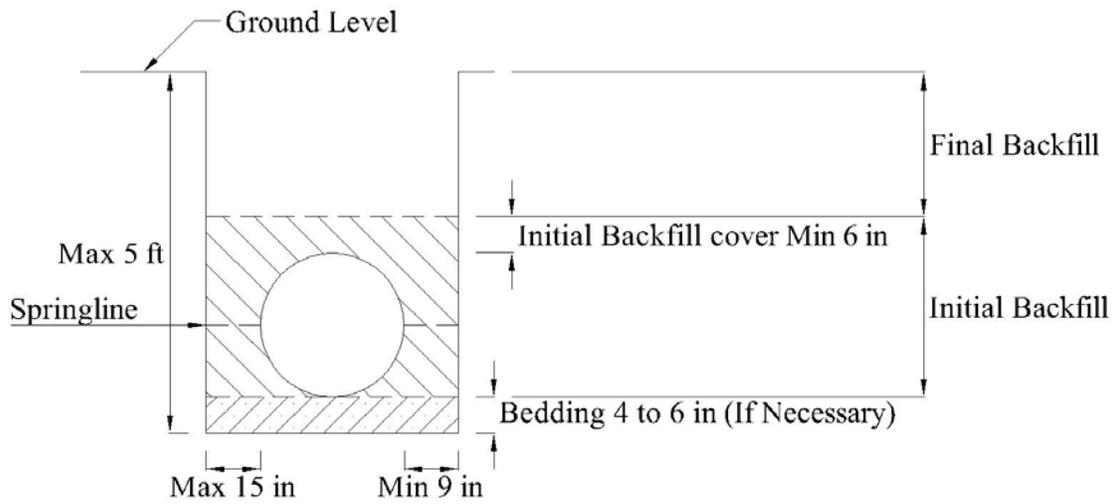


Figure 1. Typical Trench with flat bottom, Manual Installation of Backfill

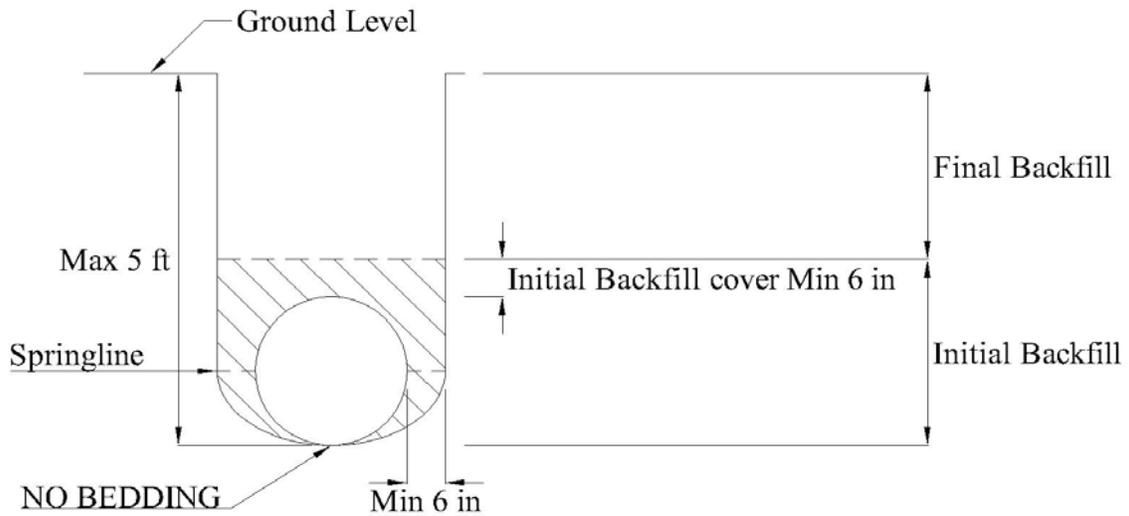


Figure 2. Typical Trench with semi-circular bottom, Manual Installation of Backfill

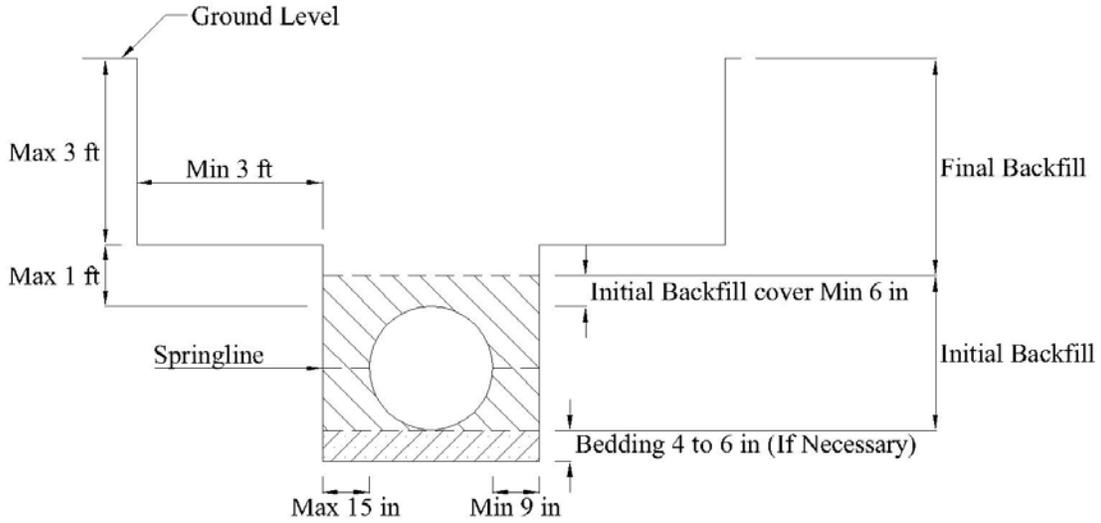


Figure 3. Trench Depth 5 to 10 feet: Benching System.

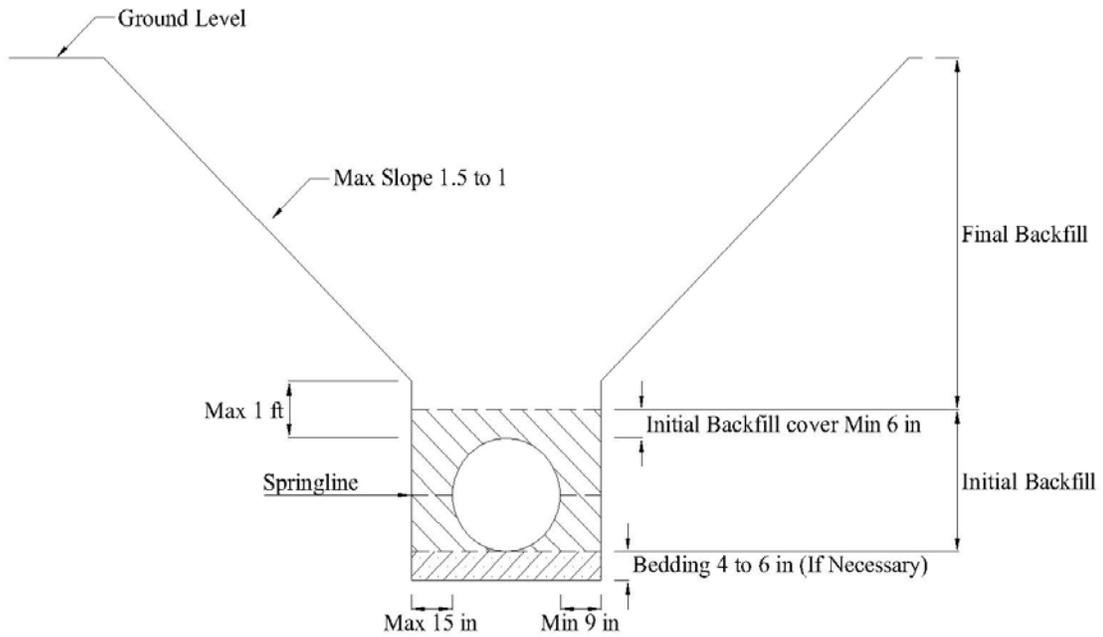


Figure 4. Trench Depth 5 to 10 feet: Vertically-sided lower portion with sloped upper portion

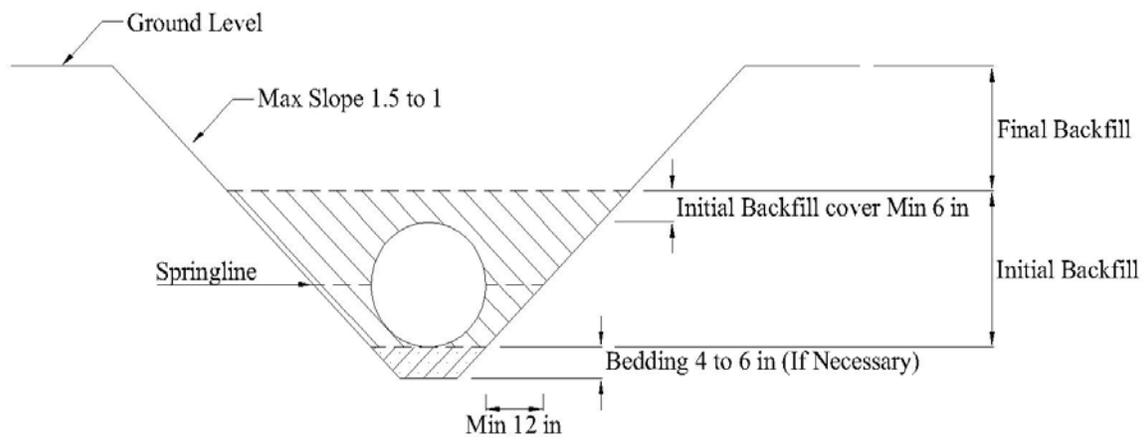


Figure 5. Trench Depth 5 to 12 feet: Sloped walls