

CONSTRUCTION SPECIFICATION

VA-751. CORRUGATED METAL PIPE

1. SCOPE

The work will consist of furnishing and placing circular, arched or elliptical corrugated metal pipe and the necessary fittings as shown on the construction drawings.

2. MATERIALS

A. PIPE

Aluminum corrugated pipe and fittings will conform to the requirements of ASTM B745, B746, or B790 for the specified pipe sheet thickness, shape type, fabrication methods.

Metallic coated corrugated steel pipe and fittings will conform to the requirements of ASTM A760, A761, A875, A885, or A929 for the specified type, class, fabrication of pipe and coating.

Unless otherwise specified, circumferential shop riveted seams will have a maximum rivet spacing of 6 inches, except that 6 rivets will be sufficient for 12-inch diameter pipe.

When close riveted pipe is specified: (1) the pipe will be fabricated so that the rivet spacing in the circumferential seams will not exceed 3 inches, except that 12 rivets will be sufficient to secure the circumferential seams in 12-inch pipe, and (2) in those portions of the longitudinal seams that will be covered by the coupling bands, the rivets will have finished flat heads or the rivets and holes will be omitted and the seams will be connected by welding to provide a minimum of obstruction to the seating of the coupling bands.

Double riveting or double spot welding of pipe less than 42 inches in diameter may be required. If specified, the riveting or welding will be done in the manner specified for pipe 42 inches or greater in diameter.

B. COATINGS

Coatings described herein, unless otherwise specified, equally refer to the inside and outside pipe surfaces. When coatings in addition to metallic coatings are specified, they will conform to the requirements of ASTM A742, A762, and A849, for the specified type.

Polymer-coated pipe, unless otherwise specified on the construction drawings or in the construction specifications, will be coated on each side with a minimum thickness of 0.01 inches (10 mils), designated as grade 10/10 in ASTM A762.

C. COUPLING BANDS AND HARDWARE

Coupling bands are to be provided for each section of pipe. The hardware for fastening the coupling band tightly to the connecting pipe will be fabricated to permit tightening sufficiently to provide the required joint tensile strength and, if required, watertightness without failure of its fastening.

Hardware consisting of coupling bands and band fastening devices, such as connecting bolts, rods, lugs, and angles used in conjunction with zinc-coated iron or steel pipe, will be galvanized by the hot-dip method. Hardware used in conjunction with aluminum pipe and aluminum or aluminum-zinc alloy-coated iron and steel pipe will be of the same material as the pipe except that hot-dip galvanized or cadmium-plated fasteners may be used. The

surface of all band-fastening devices for pipe specified with bituminous or polymer coating will be coated with asphalt-mastic material meeting the requirements of ASTM A849. The coupling band will be coated similar to that specified for the pipe unless otherwise specified on the construction drawings.

Coupling bands will be installed to provide straight alignment of the connecting pipe ends. Unless otherwise specified, the bandwidth will be as specified in ASTM A760 and A762. The bands will be positioned to overlap adjacent pipe ends equally. The coupling bands will be corrugated to match the corrugations of the pipe section ends being connected.

Gaskets, if specified, are to be provided for each coupling band. The fabrication of coupling bands and fastening hardware, in addition to the above, will be sufficient to provide the required gasket seating without warping, twisting, or bending.

Gaskets provided for aluminum corrugated pipe, with connecting bands meeting requirements for special joints in erodible soil conditions, will be as specified in ASTM B745.

D. FITTINGS

a. STEEL PIPE

The coating of fittings will be the same as that specified for the contiguous corrugated coated pipe.

Welded surfaces and adjacent surfaces damaged during welding will be treated by removing all flux residue and weld splatter. The affected surfaces will be cleaned to bright metal by sand blasting, power disk sanding, or wire brushing. The cleaned area will extend at least 0.5 inch into the undamaged section of the coated area. Repair and coating application of damaged and uncoated pipe surface areas will be in accordance with ASTM A780.

b. ALUMINUM PIPE

The coating for fittings will be the same as that specified for the contiguous corrugated aluminum pipe.

Fittings that are welded during fabrication will be accomplished in a good workmanshiplike manner resulting in a continuous smooth surface finish. Aluminum welding electrodes used will conform to the requirements of American Welding Society (AWS) specification AWS A5.10, "Specification for Aluminum and Aluminum Alloy Welding Rods and Bare Electrodes." Welded surfaces and adjacent surfaces damaged during welding will be treated by removing all weld splatter. The affected surface will be cleaned to bright metal by sand blasting, power disk sanding, or wire brushing. The cleaned area will extend at least 0.5 inch into the undamaged section of coated area. Within 24 hours of completion of surface preparation all treated surfaces will be painted with two coats of a chromate rich primer and allowed to fully dry before exposure to weathering conditions.

Fabricated aluminum surfaces that will have contact with steel, iron, or other metals will be coated with a zinc-chromate primer and allowed to fully dry before final installation.

E. FABRICATION

Fabrication of appurtenant sections will be performed as shown on the construction drawings. The items may consist of inlet sections, outlet sections, end sections, elbows, skew or beveled sections, rod reinforced ends, cut-off collars, or headwalls. Fabrication of these appurtenant sections will be made from metallic-coated material identical to that from which the attached pipe is fabricated. Fabrication will be of a quality and finished workmanship equal to that required for the pipe.

3. HANDLING THE PIPE

The contractor will furnish such equipment as is necessary to place the pipe without damaging the pipe or coating. The pipe will be transported and handled in such a manner as to prevent bruising, scaling or breaking of the spelter coating or bituminous coating.

4. LAYING AND BEDDING THE PIPE

Unless otherwise specified, the pipe will be installed in accordance with the manufacturer's recommendations. The pipe will be installed with the outside laps of circumferential joints pointing upstream and with longitudinal laps at the sides near the vertical mid-height of the pipe.

Field welding of corrugated galvanized iron or steel pipe is not permitted. The pipe sections will be joined with fabricator-supplied coupling bands meeting the specified joint requirements. The coupling will be installed as recommended by the fabricator.

The trench or foundation width on which the pipe will be laid should be at least two times the pipe diameter, or the pipe diameter plus two feet whichever is greater.

The pipe will be firmly and uniformly bedded throughout its full length to the depth and in the manner specified on the construction drawings.

Perforated pipe will be installed with the perforations down and oriented symmetrically about a vertical centerline. Perforations will be clear of any obstructions at the time the pipe is installed in its final position.

The pipe will be loaded sufficiently during backfilling to prevent displacement from line and grade and to maintain full contact with the bedding during the placement operations. Backfill around the pipe will be placed in layers not more than 4 inches thick before compaction. Each layer of backfill will be compacted with power tampers or hand tamping to the same density requirements as specified for the adjacent embankment. Unless otherwise specified, backfill over and around the pipe will be brought up uniformly on all sides and will extend a minimum of 2 feet over the pipe before earth moving equipment is allowed over the pipe. Special care will be taken not to disturb the grade and alignment during backfill operations.

5. STRUTTING

When required, struts or horizontal ties will be installed in the manner specified on the construction drawings. Struts and ties will remain in position until the backfill has been placed above the top of the pipe to a height of 5 feet or the pipe diameter, whichever is greater, or to the surface of the completed earth backfill when the fill height is less than 5 feet above the top of the pipe. The contractor will remove the struts or ties following completion of the earth backfill requirements that apply.

6. EMBEDMENT IN CONCRETE

Special treatment will be provided to the pipe surface when embedded or attached to concrete and the pipe material is aluminum or aluminum-coated and aluminum-zinc alloy-coated. Potential contact surfaces in contact with concrete and masonry surfaces will be coated with two coats of a bituminous paint of the cutback type. Placement of the pipe will be such that direct metal-to-metal contact with other metallic material, such as embedded steel reinforcement or water control gates, is prevented.

7. REPAIR OF DAMAGED COATINGS

Any damage to the metallic coating will be repaired by cleaning the damaged surface area by sand blasting, power disk sanding, or wire brushing. All loose and cracked coating, dirt, and any products of corrosion will be removed before application of paint. Oil and grease material will be removed by use of a solvent. The surface will be clean and dry during the painting period and until the coating has completely dried.

Painting will be accomplished by one of the following options based upon installed exposure conditions of the pipe as determined by the engineer.

Normal exterior or interior atmospheric exposure:

- a. Zinc dust - zinc oxide primer, ASTM D79 and D520
- b. Single package, moisture cured urethane primer in silver metallic color, or
- c. Zinc-rich cold galvanized compound, brush, or aerosol application

Submergence in water exposure:

- a. Zinc dust - zinc oxide primer, ASTM D79 and D520
- b. Zinc dust paint, ASTM D4146

When the metallic coating is damaged in any individual area larger than 12 square inches or if more than 0.2 percent of the total surface area of a single pipe section is damaged, that section of pipe will be rejected.

Breaks or scuffs in bituminous coatings that are less than 36 square inches in area will be repaired by applying two coats of hot-asphaltic paint or a coating of cold-applied bituminous mastic. The repair coating will be a minimum of 0.05 inch thick after hardening and will bond securely and permanently to the pipe and coating. The material will meet the minimum physical requirements for bituminous coating in ASTM A849 and A885. Whenever individual breaks exceed 36 square inches in area or when the total area of breaks exceeds 0.5 percent of the total surface area of an individual pipe section, that section of pipe will be rejected.

Bituminous coating damaged by welding of coated pipe or pipefittings will be repaired as specified in this section for breaks or scuffs in bituminous coatings.

Breaks or scuffs in polymer coatings that are less than 36 square inches in area will be repaired by the application of a polymer material similar to and compatible with the durability, adhesion, and appearance of the original polymer coating, as described in ASTM A742 or A762. The repair coating will be a minimum thickness of 0.010 inch (10 mils) after drying. Whenever individual breaks exceed 36 square inches in area or when the total area of breaks exceeds 0.5 percent of the total surface area of the individual pipe section, that section of pipe will be rejected.