



Designation: C1504 – 20

Standard Specification for Manufacture of Precast Reinforced Concrete Three-Sided Structures for Culverts and Storm Drains¹

This standard is issued under the fixed designation C1504; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers single-cell precast conventionally reinforced concrete three-sided structures intended to be used for the construction of culverts and for the conveyance of storm water.

1.2 A complete metric companion to Specification C1504 has been developed—C1504M; therefore, no metric equivalents are presented in this specification.

NOTE 1—This specification is primarily a manufacturing and purchasing specification. The successful performance of this product depends upon the proper selection of the geometric section, bedding, backfill, and care that the installation conforms to the construction specifications. The purchaser of the precast reinforced concrete three-sided structure specified herein is cautioned that proper correlation of the loading conditions and the field requirements with the geometric section specified and provisions for inspection at the construction site are required.

1.3 The values stated in inch-pound units are to be regarded as standard. No other units of measurement are included in this standard.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

A1064/A1064M Specification for Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete

A615/A615M Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement

A706/A706M Specification for Deformed and Plain Low-Alloy Steel Bars for Concrete Reinforcement

C31/C31M Practice for Making and Curing Concrete Test Specimens in the Field

C33/C33M Specification for Concrete Aggregates

C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens

C150/C150M Specification for Portland Cement

C260/C260M Specification for Air-Entraining Admixtures for Concrete

C309 Specification for Liquid Membrane-Forming Compounds for Curing Concrete

C494/C494M Specification for Chemical Admixtures for Concrete

C497 Test Methods for Concrete Pipe, Concrete Box Sections, Manhole Sections, or Tile

C595/C595M Specification for Blended Hydraulic Cements

C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete

C822 Terminology Relating to Concrete Pipe and Related Products

C989/C989M Specification for Slag Cement for Use in Concrete and Mortars

C1017/C1017M Specification for Chemical Admixtures for Use in Producing Flowing Concrete

C1116/C1116M Specification for Fiber-Reinforced Concrete

C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete

2.2 AASHTO Standard:

AASHTO LRFD Bridge Design Specification³

2.3 ACI Standard:

ACI 318 Building Code Requirements for Structural Concrete and Commentary⁴

3. Terminology

3.1 *Definitions*—For definitions of terms relating to geometric sections, see Terminology **C822**.

¹ This specification is under the jurisdiction of ASTM Committee C13 on Concrete Pipe and is the direct responsibility of Subcommittee C13.07 on Acceptance Specifications and Precast Concrete Box Sections.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ American Association of State Highway and Transportation Officials (AASHTO), 444 N. Capitol St., NW, Suite 249, Washington, DC 20001.

⁴ Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333-9094, http://www.concrete.org.

*A Summary of Changes section appears at the end of this standard

4. Types

4.1 Precast reinforced concrete three-sided structures manufactured in accordance with this specification shall be designated by span, rise, and design earth cover.

5. Basis of Acceptance

5.1 Acceptability of the three-sided sections produced in accordance with Section 7 shall be determined by the results of the concrete compressive strength tests described in Section 10, by the material requirements described in Section 6, and by inspection of the finished three-sided sections.

5.2 Three-sided sections shall be considered ready for acceptance when they conform to the requirements of this specification.

6. Materials

6.1 *Reinforced Concrete*—The reinforced concrete shall consist of cementitious materials, mineral aggregates, admixture, if used, and water, in which steel has been embedded in such a manner that the steel and concrete act together.

6.2 Cementitious Materials:

6.2.1 *Cement*—Cement shall conform to the requirements for portland cement of Specification C150/C150M or shall be portland blast-furnace slag cement, portland-limestone cement, or portland-pozzolan cement conforming to the requirements of Specification C595/C595M, except that the pozzolan constituent in the Type IP portland pozzolan cement shall be fly ash.

6.2.2 *Fly Ash*—Fly ash shall conform to the requirements of Specification C618, Class F or Class C.

6.2.3 *Slag Cement*—Slag cement shall conform to the requirements of Grade 100 or 120 of Specification C989/C989M.

6.2.4 *Allowable Combinations of Cementitious Materials*—The combination of cementitious materials used in concrete shall be one of the following:

- 6.2.4.1 Portland cement only,
- 6.2.4.2 Portland blast-furnace slag cement only,
- 6.2.4.3 Portland-pozzolan cement only,
- 6.2.4.4 Portland-limestone cement only,
- 6.2.4.5 A combination of portland cement or portland-limestone cement and fly ash,
- 6.2.4.6 A combination of portland cement or portland-limestone cement and slag cement,
- 6.2.4.7 A combination of portland cement or portland-limestone cement, slag cement, and fly ash.
- 6.2.4.8 A combination of portland-pozzolan cement and fly ash.

6.3 *Aggregates*—Aggregates shall conform to Specification C33/C33M, except that the requirements for gradation shall not apply.

6.4 *Admixtures*—The following admixtures and blends are allowable:

- 6.4.1 Air-entraining admixture conforming to Specification C260/C260M;
- 6.4.2 Chemical admixture conforming to Specification C494/C494M;

6.4.3 Chemical admixture for use in producing flowing concrete conforming to Specification C1017/C1017M; and

6.4.4 Chemical admixture or blend approved by the owner.

6.4.5 *Air Entraining Admixtures*—Air entraining will be required on all products produced with positive slump, wet-cast concrete and shall conform to the requirements of Specification C260/C260M.

6.5 *Steel Reinforcement*—Reinforcement shall consist of welded wire reinforcement conforming to Specification A1064/A1064M for steel wire and welded wire reinforcement, plain and deformed, for concrete. For circumferential reinforcement, deformed and plain steel bars for reinforced concrete are permitted conforming to Specification A706/A706M or A615/A615M, Grade 60, and longitudinal distribution reinforcement shall consist of welded wire reinforcement or deformed billet-steel bars conforming to Specification A706/A706M or A615/A615M, Grade 60.

NOTE 2—This specification does not address reinforcement with prestressing strand or any other form of pre-tensioning or post-tensioning.

6.6 *Fibers*—Synthetic fibers and nonsynthetic fibers shall be allowed to be used, at the manufacturer's option, in concrete pipe as a nonstructural manufacturing material. Synthetic fibers (Type II and Type III) and nonsynthetic fiber (Type I) designed and manufactured specifically for use in concrete and conforming to the requirements of Specification C1116/C1116M shall be accepted.

6.7 *Water*—Water used in the production of concrete shall be potable or non-potable water that meets the requirements of Specification C1602/C1602M.

7. Design

7.1 *Design Criteria*—The three-sided section's dimensions and reinforcement details shall be as required by design, in accordance with Section 3, 5 and 12.14 of the American Association of State Highway and Transportation Officials (AASHTO) LRFD Bridge Design Specifications. The minimum concrete compressive strength shall be 5000 psi, and the minimum steel yield strength shall be 65 000 psi for welded-wire reinforcement and 60 000 psi for deformed billet-steel bars.

7.2 *Placement of Reinforcement*—The minimum cover of concrete over the circumferential reinforcing diameter shall be 1 in. for bar reinforcement and welded wire reinforcement for all structures up to 12 ft in span, and 1.5 in. for longer spans subject to the provisions of Section 11 for both bar reinforcement and welded wire reinforcement. The clear distance of the end circumferential wires shall be not less than ½ in. nor more than 2 in. from the ends of each section. For three-sided sections covered by less than 2 ft of fill, minimum cover for the reinforcement in the top of the top slab shall be 2-in., subject to the provisions of Section 11. Reinforcement shall be assembled utilizing any combination of single or multiple layers of welded-wire reinforcement, not to exceed three layers or utilizing single or multiple layers of deformed billet steel bars, not to exceed two layers. The welded-wire reinforcement on 7.3 shall be composed of circumferential and longitudinal wires meeting the spacing requirements of 7.3 and shall