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USACE / NAVFAC / AFCESA **UFGS-03150A (September 2003)**

Preparing Activity: USACE **Superseding**
UFGS-03150A (May 1998)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 25 June 2004

Latest change indicated by CHG tags
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DIVISION 03 - CONCRETE

SECTION 03150A

EXPANSION JOINTS, CONTRACTION JOINTS, AND WATERSTOPS

09/03

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SECTION 03150A

EXPANSION JOINTS, CONTRACTION JOINTS, AND WATERSTOPS
09/03

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NOTE: This guide specification covers the requirements for expansion joints, contraction joints and waterstops used in concrete construction. This guide will be used in conjunction with Section 03300A, CAST-IN-PLACE STRUCTURAL CONCRETE..

Comments and suggestions on this guide specification are welcome and should be directed to the technical proponent of the specification. A listing of technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.cations where text must be supplied by the designer.
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PART 1 GENERAL

1.1 REFERENCES

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NOTE: Issue (date) of references included in project specifications need not be more current than provided by the latest guide specification. Use of SpecsIntact automated reference checking is recommended for projects based on older guide specifications.
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The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the

basic designation only.

AMERICAN ASSOCIATION OF STATE HIGHWAY AND TRANSPORTATION OFFICIALS (AASHTO)

AASHTO T 111	(1983; R 2000) Inorganic Matter or Ash in Bituminous Materials

AMERICAN HARDBOARD ASSOCIATION (AHA)

AHA A135.4	(1995) Basic Hardboard

ASTM INTERNATIONAL (ASTM)

ASTM A 1011/A 1011M	(2003a) Steel, Sheet and Strip, Hot-Rolled, Carbon, Structural, High Strength Low-Alloy and High-Strength Low-Alloy With Improved Formability
ASTM A 109/A 109M	(2003) Steel, Strip, Carbon (0.25 Maximum Percent), Cold-Rolled
ASTM A 167	(1999) Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip
ASTM A 480/A 480M	(2003b) General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip
ASTM B 152/B 152M	(2000) Copper Sheet, Strip, Plate, and Rolled Bar
ASTM B 370	(1998) Copper Sheet and Strip for Building Construction
ASTM C 919	(2002) Use of Sealants in Acoustical Applications
ASTM C 920	(2002) Elastomeric Joint Sealants
ASTM D 1751	(1999) Preformed Expansion Joint Filler for Concrete Paving and Structural Construction (Nonextruding and Resilient Bituminous Types)
ASTM D 1752	(1984; R 1996e1) Preformed Sponge Rubber and Cork Expansion Joint Fillers for Concrete Paving and Structural Construction
ASTM D 1854	(2002) Jet-Fuel-Resistant Concrete Joint Sealer, Hot-Applied Elastic Type
ASTM D 2628	(1991; R 1998) Preformed Polychloroprene Elastomeric Joint Seals for Concrete Pavements
ASTM D 2835	(1989; R 1998) Lubricant for Installation of Preformed Compression Seals in Concrete

	Pavements
ASTM D 4	(1986; R 1998) Bitumen Content
ASTM D 412	(1998a; R 2002e1) Vulcanized Rubber and Thermoplastic Elastomers - Tension
ASTM D 471	(1998e1) Rubber Property - Effect of Liquids
ASTM D 5249	(1995; R 2000) Backer Material for Use with Cold-and Hot-Applied Joint Sealants in Portland-Cement Concrete and Asphalt Joints
ASTM D 5329	(1996) Sealants and Fillers, Hot-Applied, for Joints and Cracks in Asphaltic and Portland Cement Concrete Pavements
ASTM D 6	(1995; R 2000e1) Loss on Heating of Oil and Asphaltic Compounds

U.S. ARMY CORPS OF ENGINEERS (USACE)

COE CRD-C 513	(1974) Specifications for Rubber Waterstops
COE CRD-C 572	(1974) Specifications for Polyvinylchloride Waterstops

1.2 SUBMITTALS

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NOTE: Submittals must be limited to those necessary for adequate quality control. The importance of an item in the project should be one of the primary factors in determining if a submittal for the item should be required.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy projects.

Submittal items not designated with a "G" are considered as being for information only for Army projects and for Contractor Quality Control approval for Navy projects.

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Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.][for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Waterstops[; G][; G, [_____]]

Shop drawings and fabrication drawings provided by the manufacturer or prepared by the Contractor.

SD-03 Product Data

Preformed Expansion Joint Filler
Sealant
Waterstops

Manufacturer's literature, including safety data sheets, for preformed fillers and the lubricants used in their installation; field-molded sealants and primers (when required by sealant manufacturer); preformed compression seals; and waterstops. Manufacturer's recommended instructions for installing preformed fillers, field-molded sealants; preformed compression seals; and waterstops; and for splicing non-metallic waterstops.

SD-04 Samples

Lubricant for Preformed Compression Seals

Specimens identified to indicate the manufacturer, type of material, size and quantity of material, and shipment or lot represented. Each sample shall be a piece not less than 3 m 9 ft of 25 mm 1 inch nominal width or wider seal or a piece not less than 4 m 12 ft of compression seal less than 25 mm 1 inch nominal width. One L quart of lubricant shall be provided.

Field-Molded Type

Four liters One gallon of field-molded sealant and one L quart of primer (when primer is recommended by the sealant manufacturer) identified to indicate manufacturer, type of material, quantity, and shipment or lot represented.

Non-metallic Materials

Specimens identified to indicate manufacturer, type of material, size, quantity of material, and shipment or lot represented. Each sample shall be a piece not less than 300 mm 12 inch long cut from each 61 m 200 ft of finished waterstop furnished, but not less

than a total of 1 m 4 ft of each type, size, and lot furnished. One splice sample of each size and type for every 50 splices made in the factory and every 10 splices made at the job site. The splice samples shall be made using straight run pieces with the splice located at the mid-length of the sample and finished as required for the installed waterstop. The total length of each splice shall be not less than 300 mm 12 inches long.

SD-07 Certificates

Preformed Expansion Joint Filler
Sealant
Waterstops

Certificates of compliance stating that the joint filler and sealant materials and waterstops conform to the requirements specified.

1.3 DELIVERY AND STORAGE

Material delivered and placed in storage shall be stored off the ground and protected from moisture, dirt, and other contaminants. Sealants shall be delivered in the manufacturer's original unopened containers. Sealants whose shelf life has expired shall be removed from the site.

PART 2 PRODUCTS

2.1 CONTRACTION JOINT STRIPS

Contraction joint strips shall be 3 mm 1/8 inch thick tempered hardboard conforming to AHA A135.4, Class 1. In lieu of hardboard strips, rigid polyvinylchloride (PVC) or high impact polystyrene (HIPS) insert strips specifically designed to induce controlled cracking in slabs on grade may be used. Such insert strips shall have removable top section.

2.2 PREFORMED EXPANSION JOINT FILLER

Expansion joint filler shall be preformed material conforming to ASTM D 1751 or ASTM D 1752. Unless otherwise indicated, filler material shall be 10 mm 3/8 inch thick and of a width applicable for the joint formed. Backer material, when required, shall conform to ASTM D 5249.

2.3 SEALANT

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NOTE: Types of joint material should be shown. Elastomeric joint seals (ASTM D 2628) will be used in compression type joints. For slabs receiving considerable fuel spillage, the hot-applied jet-fuel resistant type should be used when a thermoplastic elastomeric rubber (TPE-R) waterstop is not specified.
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Joint sealant shall conform to the following:

2.3.1 Preformed Polychloroprene Elastomeric Type

ASTM D 2628.

2.3.2 Lubricant for Preformed Compression Seals

ASTM D 2835.

2.3.3 Field-Molded Type

ASTM C 920, Type M, Grade P or NS, Class 25, Use [T] [NT] for horizontal joints. Type M, Grade NS, Class 25, Use NT for vertical joints. Bond breaker material shall be polyethylene tape, coated paper, metal foil or similar type materials. The back-up material shall be compressible, non-shrink, nonreactive with sealant, and non-absorptive material type such as extruded butyl or polychloroprene rubber.

2.3.4 Hot-Applied Jet-Fuel Resistant Type

ASTM D 1854 tested in accordance with ASTM D 5329.

2.4 WATERSTOPS

Intersection and change of direction waterstops shall be shop fabricated.

2.4.1 Flexible Metal

Copper waterstops shall conform to ASTM B 152/B 152M and ASTM B 370, O60 soft anneal temper and 0.686 mm (20 oz mass per sq ft) 20 oz mass per sq ft sheet thickness. Stainless steel waterstops shall conform to ASTM A 167 and ASTM A 480/A 480M, UNS S30453 (Type 304L), and 0.9525 mm 20 gauge thick strip.

2.4.2 Rigid Metal

Flat steel waterstops shall conform to ASTM A 109/A 109M, No. 2 (half hard) temper, No. 2 edge, No. 1 (matte or dull) finish or ASTM A 1011/A 1011M, Grade 40.

2.4.3 Non-Metallic Materials`

Non-metallic waterstops shall be manufactured from a prime virgin resin; reclaimed material is not acceptable. The compound shall contain plasticizers, stabilizers, and other additives to meet specified requirements. Rubber waterstops shall conform to COE CRD-C 513. Polyvinylchloride waterstops shall conform to COE CRD-C 572. Thermoplastic elastomeric rubber waterstops shall conform to ASTM D 471.

2.4.4 Non-Metallic Hydrophilic

Swellable strip type compound of polymer modified chloroprene rubber that swells upon contact with water shall conform to ASTM D 412 as follows: Tensile strength 2.9 MPa 420 psi minimum; ultimate elongation 600 percent minimum. Hardness shall be 50 minimum on the type A durometer and the volumetric expansion ratio in distilled water at 20 degrees C 70 degrees F shall be 3 to 1 minimum.

2.4.5 Preformed Elastic Adhesive

Preformed plastic adhesive waterstops shall be produced from blends of refined hydrocarbon resins and plasticizing compounds reinforced with inert mineral filler, and shall contain no solvents, asbestos, irritating fumes

or obnoxious odors. The compound shall not depend on oxidizing, evaporating, or chemical action for its adhesive or cohesive strength.

2.4.5.1 Chemical Composition

The chemical composition of the sealing compound shall meet the requirements shown below:

PERCENT BY WEIGHT

COMPONENT	MIN.	MAX.	TEST
Bitumen (Hydrocarbon plastic)	50	70	ASTM D 4
Inert Mineral Filler	30	50	AASHTO T 111
Volatile Matter		2	ASTM D 6

2.4.5.2 Adhesion Under Hydrostatic Pressure

The sealing compound shall not leak at the joints for a period of 24 hours under a vertical 2 m 6 foot head pressure. In a separate test, the sealing compound shall not leak under a horizontal pressure of 65 kPa 10 psi which is reached by slowly applying increments of 13 kPa 2 psi every minute.

2.4.5.3 Sag of Flow Resistance

Sagging shall not be detected when tested as follows: Fill a wooden form 25 mm 1 inch wide and 150 mm 6 inches long flush with sealing compound and place in an oven at 58 degrees C 135 degrees F in a vertical position for 5 days.

2.4.5.4 Chemical Resistance

The sealing compound when immersed separately in a 5% solution of caustic potash, a 5% solution of hydrochloric acid, 5% solution of sulfuric acid and a saturated hydrogen sulfide solution for 30 days at ambient room temperature shall show no visible deterioration.

PART 3 EXECUTION

3.1 JOINTS

Joints shall be installed at locations indicated and as authorized.

3.1.1 Contraction Joints

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NOTE: Since contraction joint strips are difficult to align and maintain in alignment, the option for use of joint strips should be deleted where appearance is important or where concrete slabs will not be covered with subsequent toppings that will hide the joint.
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Contraction joints may be constructed by inserting tempered hardboard strips or rigid PVC or HIPS insert strips into the plastic concrete using a steel parting bar, when necessary, or by cutting the concrete with a saw after concrete has set. Joints shall be approximately 3 mm 1/8 inch wide and shall extend into the slab one-fourth the slab thickness, minimum, but

not less than 25 mm 1 inch.

3.1.1.1 Joint Strips

Strips shall be of the required dimensions and as long as practicable. After the first floating, the concrete shall be grooved with a tool at the joint locations. The strips shall be inserted in the groove and depressed until the top edge of the vertical surface is flush with the surface of the slab. The slab shall be floated and finished as specified. Working of the concrete adjacent to the joint shall be the minimum necessary to fill voids and consolidate the concrete. Where indicated, the top portion of the strip shall be sawed out after the curing period to form a recess for sealer. The removable section of PVC or HIPS strips shall be discarded and the insert left in place. True alignment of the strips shall be maintained during insertion.

3.1.1.2 Sawed Joints

Joint sawing shall be early enough to prevent uncontrolled cracking in the slab, but late enough that this can be accomplished without appreciable spalling. Concrete sawing machines shall be adequate in number and power, and with sufficient replacement blades to complete the sawing at the required rate. Joints shall be cut to true alignment and shall be cut in sequence of concrete placement. Sludge and cutting debris shall be removed.

3.1.2 Expansion Joints

Preformed expansion joint filler shall be used in expansion and isolation joints in slabs around columns and between slabs on grade and vertical surfaces where indicated. The filler shall extend the full slab depth, unless otherwise indicated. The edges of the joint shall be neatly finished with an edging tool of 3 mm 1/8 inch radius, except where a resilient floor surface will be applied. Where the joint is to receive a sealant, the filler strips shall be installed at the proper level below the finished floor with a slightly tapered, dressed and oiled wood strip temporarily secured to the top to form a recess to the size shown on the drawings. The wood strip shall be removed after the concrete has set. Contractor may opt to use a removable expansion filler cap designed and fabricated for this purpose in lieu of the wood strip. The groove shall be thoroughly cleaned of laitance, curing compound, foreign materials, protrusions of hardened concrete, and any dust which shall be blown out of the groove with oil-free compressed air.

3.1.3 Joint Sealant

Sawed contraction joints and expansion joints in slabs shall be filled with joint sealant, unless otherwise shown. Joint surfaces shall be clean, dry, and free of oil or other foreign material which would adversely affect the bond between sealant and concrete. Joint sealant shall be applied as recommended by the manufacturer of the sealant.

3.1.3.1 Joints With Preformed Compression Seals

Compression seals shall be installed with equipment capable of installing joint seals to the prescribed depth without cutting, nicking, twisting, or otherwise distorting or damaging the seal or concrete and with no more than 5 percent stretching of the seal. The sides of the joint and, if necessary, the sides of the compression seal shall be covered with a coating of lubricant. Butt joints shall be coated with liberal

applications of lubricant.

3.1.3.2 Joints With Field-Molded Sealant

Joints shall not be sealed when the sealant material, ambient air, or concrete temperature is less than 4 degrees C 40 degrees F. When the sealants are meant to reduce the sound transmission characteristics of interior walls, ceilings, and floors the guidance provided in ASTM C 919 shall be followed. Joints requiring a bond breaker shall be coated with curing compound or with bituminous paint. Bond breaker and back-up material shall be installed where required. Joints shall be primed and filled flush with joint sealant in accordance with the manufacturer's recommendations.

3.2 WATERSTOPS, INSTALLATION AND SPLICES

Waterstops shall be installed at the locations shown to form a continuous water-tight diaphragm. Adequate provision shall be made to support and completely protect the waterstops during the progress of the work. Any waterstop punctured or damaged shall be repaired or replaced. Exposed waterstops shall be protected during application of form release agents to avoid being coated. Suitable guards shall be provided to protect exposed projecting edges and ends of partially embedded waterstops from damage when concrete placement has been discontinued. Splices shall be made by certified trained personnel using approved equipment and procedures.

3.2.1 Copper And Stainless Steel

Splices in copper waterstops shall be lap joints made by brazing. Splices in stainless steel waterstops shall be welded using a TIG or MIG process utilizing a weld rod to match the stainless. All welds shall not be annealed to maintain physical properties. Carbon flame shall not be used in the annealing process. Damaged waterstops shall be repaired by removing damaged portions and patching. Patches shall overlap a minimum of 25 mm 1 inch onto undamaged portion of the waterstop.

3.2.2 Flat Steel

Splices in flat steel waterstops shall be properly aligned, butt welded, and cleaned of excessive material.

3.2.3 Non-Metallic

Fittings shall be shop made using a machine specifically designed to mechanically weld the waterstop. A miter guide, proper fixturing (profile dependant), and portable power saw shall be used to miter cut the ends to be joined to ensure good alignment and contact between joined surfaces. The splicing of straight lengths shall be done by squaring the ends to be joined. Continuity of the characteristic features of the cross section of the waterstop (ribs, tabular center axis, protrusions, etc.) shall be maintained across the splice.

3.2.3.1 Rubber Waterstop

Splices shall be vulcanized or shall be made using cold bond adhesive as recommended by the manufacturer. Splices for TPE-R shall be as specified for PVC.

3.2.3.2 Polyvinyl Chloride Waterstop

Splices shall be made by heat sealing the adjacent waterstop edges together using a thermoplastic splicing iron utilizing a non-stick surface specifically designed for waterstop welding. The correct temperature shall be used to sufficiently melt without charring the plastic. The spliced area, when cooled, shall show no signs of separation, holes, or other imperfections when bent by hand in as sharp an angle as possible.

3.2.3.3 Quality Assurance

Edge welding will not be permitted. Centerbulbs shall be compressed or closed when welding to non-centerbulb type. Waterstop splicing defects which are unacceptable include, but are not limited to the following: 1) Tensile strength less than 80 percent of parent section. 2) Free lap joints. 3) Misalignment of centerbulb, ribs, and end bulbs greater than 2 mm 1/16 inch. 4) Misalignment which reduces waterstop cross section more than 15 percent. 5) Bond failure at joint deeper than 2 mm 1/16 inch or 15 percent of material thickness. 6) Misalignment of waterstop splice resulting in misalignment of waterstop in excess of 13 mm in 3 m 1/2 inch in 10 feet. 7) Visible porosity in the weld area, including pin holes. 8) Charred or burnt material. 9) Bubbles or inadequate bonding. 10) Visible signs of splice separation when cooled splice is bent by hand at a sharp angle.

3.2.4 Non-Metallic Hydrophilic Waterstop Installation

Ends to be joined shall be miter cut with sharp knife or shears. The ends shall be adhered with cyanacryiate (super glue) adhesive. When joining hydrophilic type waterstop to PVC waterstop, the hydrophilic waterstop shall be positioned as shown on the drawings. A liberal amount of a single component hydrophilic sealant shall be applied to the junction to complete the transition.

3.2.5 Preformed Plastic Adhesive Installation

The installation of preformed plastic adhesive waterstops shall be a prime, peel, place and pour procedure. Joint surfaces shall be clean and dry before priming and just prior to placing the sealing strips. The end of each strip shall be spliced to the next strip with a 25 mm 1 inch overlap; the overlap shall be pressed firmly to release trapped air. During damp or cold conditions the joint surface shall be flashed with a safe, direct flame to warm and dry the surface adequately; the sealing strips shall be dipped in warm water to soften the material to achieve maximum bond to the concrete surface.

3.3 CONSTRUCTION JOINTS

Construction joints are specified in Section 03300A CAST-IN-PLACE STRUCTURAL CONCRETE except that construction joints coinciding with expansion and contraction joints shall be treated as expansion or contraction joints as applicable.

-- End of Section --