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USACE / NAVFAC / AFCEA UFGS-03151A (September 2003)  
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Preparing Activity: USACE (CW) Superseding  
UFGS-03151A (September 2001)

## UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMLR dated 22 December 2004

Latest change indicated by CHG tags

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### SECTION 03151A

#### EXPANSION, CONTRACTION AND CONSTRUCTION JOINTS IN CONCRETE FOR CIVIL WORKS 09/03

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NOTE: This guide specification covers the requirements for materials, techniques and workmanship requirements for forming expansion, contraction and construction joints in concrete structures.

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.

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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.

ASME INTERNATIONAL (ASME)

ASME BPVC SEC IX	(2001) Boiler and Pressure Vessel Code; Section IX, Welding and Brazing Qualifications
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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 B 152/B 152M	(2000) Copper Sheet, Strip, Plate, and Rolled Bar
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 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

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 UNIT PRICES

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**NOTE: If Section 01270A MEASUREMENT AND PAYMENT is included in the project specifications, this paragraph title (UNIT PRICES) should be deleted from this section and the remaining appropriately edited subparagraphs below should be inserted into Section 01270A.**

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### 1.2.1 Waterstops

#### 1.2.1.1 Payment

Payment will be made for costs associated with waterstops, including labor, materials and use of all equipments and tools required to complete the waterstop work. No separate payment will be made for expansion and contraction joints which are included in the costs for the items to which work for expansion and contraction joints are incidental.

#### 1.2.1.2 Measurement

Waterstops will be measured for payment by the linear meter foot in place. In computing the quantity of the waterstops, no allowance will be made for laps. No separate measurement will be made for expansion and contraction joints which are included in the costs for the items to which work for expansion and contraction joints are incidental.

#### 1.2.1.3 Unit of Measure

Unit of measure: linear meter foot.

### 1.3 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-03 Product Data

Splicing Waterstops[; G][; G, [\_\_\_\_\_]]

Procedures for splicing waterstops shall be submitted for approval.

SD-04 Samples

Field Molded Sealants and Primer

Four L One gallon of field-molded sealant and 1 L one quart of primer (when primer is recommended by the sealant manufacturer) shall be provided for testing.

Waterstops[; G][; G, [\_\_\_\_\_]]

Waterstop materials and splice samples shall be submitted for inspection and testing and shall be identified to indicate manufacturer, type of material, size and quantity of material and shipment represented. Each materials sample shall be a piece not less than 300 mm 12 inches long cut from each 60 m 200 feet of finished waterstop furnished, but not less than a total of 1.2 linear meters 4 linear feet of each type and size furnished. For spliced segments of waterstops to be installed in the work, one spliced sample of each size and type for every 50 splices made in the factory and every 10 splices made at the job site shall be furnished for inspection and testing. The spliced 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 spliced sample shall be not less than 300 mm 12 inches long.

SD-06 Test Reports

Premolded Expansion Joint Filler Strips  
Compression Seals and Lubricant  
Metallic Waterstops

Certified manufacturer's test reports shall be provided for premolded expansion joint filler strips, compression seals and lubricant, and metallic waterstops to verify compliance with applicable specification.

## PART 2 PRODUCTS

### 2.1 MATERIALS

#### 2.1.1 Premolded Expansion Joint Filler Strips

Premolded expansion joint filler strips shall conform to ASTM D 1751 or ASTM D 1752, Type I, or resin impregnated fiberboard conforming to the physical requirements of ASTM D 1752.

#### 2.1.2 Joint Seals and Sealants

##### 2.1.2.1 Field Molded Sealants and Primer

Field molded sealants and primer shall conform to ASTM C 920, Type M, Grade NS or P, Class 25, Use [T] [NT] for horizontal joints and Type M, Grade NS, Class 25, Use NT for vertical joints. [Except, the joint sealant will perform for the same life cycle when continuously underwater. The manufacturer shall certify and submit test results supporting durability under this environment.] Bond breaker material shall be polyethylene tape, coated paper, metal foil or similar type materials. The back-up material shall be compressible, nonshrink, nonreactive with sealant, and nonabsorptive material type such as extruded butyl or polychloroprene foam rubber.

##### 2.1.2.2 Compression Seals and Lubricant

Compression seals shall conform to ASTM D 2628; lubricant for installation shall conform to ASTM D 2835.

#### 2.1.3 Waterstops

##### 2.1.3.1 Non-Metallic Waterstops

Rubber waterstops shall conform to COE CRD-C 513. Polyvinylchloride waterstops shall conform to COE CRD-C 572.

##### 2.1.3.2 Metallic Waterstops

a. Flexible Metal Waterstops - Copper waterstops shall conform to ASTM B 152/B 152M, temper soft annealed, 570 g 20 oz weight sheet. Stainless steel waterstops shall conform to ASTM A 167, Type 304L, No. 1 Finish or equivalent, annealed, 0.9525 mm 0.0375 inch (20 Gage) strip.

b. Flat Steel Waterstops - Flat steel waterstops shall conform to ASTM A 109/A 109M, temper No. 2, No. 2 edge, No. 1 Finish or ASTM A 1011/A 1011M, Grade D.

### 2.2 TESTS, INSPECTIONS, AND VERIFICATIONS

#### 2.2.1 Materials Tests

##### 2.2.1.1 Field-Molded Sealants

Samples of sealant and primer, when use of primer is recommended by the manufacturer, as required in paragraph FIELD MOLDED SEALANTS AND PRIMER, shall be tested by and at the expense of the Government for compliance with paragraph FIELD MOLDED SEALANTS AND PRIMER. If the sample fails to meet specification requirements, new samples shall be provided and the cost of

retesting will be deducted from payments due the Contractor at a rate of \$[\_\_\_\_\_] per sample.

#### 2.2.1.2 Non-Metallic Waterstops

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**NOTE: Testing of Non-Metallic Waterstops shall be performed by the Corps of Engineers Waterways Experiment Station.**  
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Samples of materials and splices as required in paragraph WATERSTOPS shall be visually inspected and tested by and at the expense of the Government for compliance with COE CRD-C 513 or COE CRD-C 572 as applicable. If a sample fails to meet the specification requirements, new samples shall be provided and the cost of retesting will be deducted from payments due the Contractor at the rate of \$[\_\_\_\_\_] per material sample retested and \$[\_\_\_\_\_] per spliced sample retested.

#### 2.2.2 Splicing Waterstops

##### 2.2.2.1 Procedure and Performance Qualifications

Procedure and performance qualifications for splicing waterstops shall be demonstrated in the presence of the Contracting Officer.

##### 2.2.2.2 Non-Metallic Waterstops

Procedure and performance qualifications for splicing non-metallic waterstops shall be demonstrated by the manufacturer at the factory and the Contractor at the job site by each making three spliced samples of each size and type of finished waterstop.

##### 2.2.2.3 Metal Waterstops

Procedure and performance qualifications for splicing metal waterstops shall be demonstrated at the job site by the Contractor. The brazing procedure, brazers and brazing operators for splicing copper waterstops shall be qualified in accordance with Part QB (Brazing), Article XI (Brazing, General Requirements), paragraph QB-170 (Peel Tests) and other applicable requirements of Articles XI, XII, and XIII of ASME BPVC SEC IX. The welding procedure and welders for splicing stainless steel waterstops shall be qualified in accordance with the manufacturer's recommendations.

### PART 3 EXECUTION

#### 3.1 INSTALLATION

Joint locations and details, including materials and methods of installation of joint fillers and waterstops, shall be as specified, as shown, and as directed. In no case shall any fixed metal be continuous through an expansion or contraction joint.

##### 3.1.1 Expansion Joints

Premolded filler strips shall have oiled wood strips secured to the top thereof and shall be accurately positioned and secured against displacement to clean, smooth concrete surfaces. The wood strips shall be slightly tapered, dressed and of the size required to install filler strips at the



desired level below the finished concrete surface and to form the groove for the joint sealant or seals to the size shown. Material used to secure premolded fillers and wood strips to concrete shall not harm the concrete and shall be compatible with the joint sealant or seals. The wood strips shall not be removed until after the concrete curing period. The groove shall be thoroughly cleaned of all 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.

#### 3.1.1.1 Joints With Field-Molded Sealant

Joints shall not be sealed when the sealant, air or concrete temperature is less than 4 degrees C 40 degrees F. Immediately prior to installation of field molded sealants, the joint shall be cleaned of all debris and further cleaned using water, chemical solvents or other means as recommended by the sealant manufacturer. The joints shall be dry prior to filling with sealant. 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.

#### 3.1.1.2 Joints With Preformed Compression Seals

The joint seals shall be installed with equipment which shall be capable of installing joint seals to the prescribed depth without cutting, nicking, twisting, or otherwise distorting or damaging the seal and with no more than five 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, and the seal shall be installed to the depth indicated with joint installation equipment. Butt joints shall be coated with liberal applications of lubricant.

#### 3.1.2 Contraction Joints

Joints requiring a bond breaker shall be coated with curing compound or with bituminous paint. Waterstops shall be protected during application of bond breaking material to prevent them from being coated.

#### 3.1.3 Waterstops

Waterstops shall be carefully and correctly positioned during installation to eliminate faulty installation that may result in joint leakage. The bottom of each waterstop shall be embedded a minimum of 150 mm 6 inches in firm rock or sealed to other cut-off systems. All waterstops shall be installed so as to form a continuous watertight diaphragm in each joint. Adequate provision shall be made to support and protect the waterstops during the progress of work. Any waterstop punctured or damaged shall be replaced or repaired at the Contractor's expense. The concrete shall be thoroughly consolidated in the vicinity of the waterstop. Suitable guards shall be provided to protect exposed projecting edges and ends of partially embedded waterstops from damage when concrete placement has been discontinued.

##### 3.1.3.1 Splices

Joints in waterstops shall be spliced together by qualified splicers using the approved splicing procedures to form a continuous watertight diaphragm. Splices shall be as followed:

- a. Non-Metallic Waterstops - All splices shall be made on a bench in a

temporary shop provided at the site of the installation or at the manufacturer's plant. A miter guide and portable power saw shall be used to cut the ends to be joined to insure good alignment and contact between joined surfaces. Continuity of the characteristic features of the cross section of the waterstop (ribs, tabular center axis, protrusions and the like) shall be maintained across the splice.

b. Rubber Waterstops - Splices shall be vulcanized in accordance with the approved procedure.

c. Polyvinylchloride Waterstops - Splices shall be made by heat sealing the adjacent surfaces in accordance with the approved procedure. A thermostatically controlled electrical heat source shall be used to make all splices. The correct temperature at which splices should be made will differ with the material concerned but the applied heat should be sufficient to melt but not char the plastic. Waterstops shall be reformed at splices with a remolding iron with ribs or corrugations to match the pattern of the waterstop. The spliced area, when cooled and bent by hand in as sharp an angle as possible, shall show no sign of separation.

d. Flexible Metal Waterstop - Splices in copper shall be lap joints made by the approved brazing procedure. Splices in stainless steel shall be made by the approved welding procedure. 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.

e. Flat Steel Waterstops - Splices shall be welded.

-- End of Section --