



Florida Department of Transportation

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ANANTH PRASAD, P.E.
SECRETARY

July 15, 2014

Khoa Nguyen
Director, Office of Technical Services
Federal Highway Administration
545 John Knox Road, Suite 200
Tallahassee, Florida 32303

Re: State Specifications and Estimates Office
Section **943**
Proposed Specification: **9430000 Corrugated Steel Pipe and Pipe Arch (Including Underdrain).**

Dear Mr. Nguyen:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

These changes were proposed by Chase Knight of the Department's State Materials Office (SMO) to add the method for the testing and approval of gaskets, and for formatting.

Please review and transmit your comments, if any, within two weeks. Comments should be sent via email to SP965DS or daniel.scheer@dot.state.fl.us.

If you have any questions relating to this specification change, please call me at 414-4130.

Sincerely,

Signature on file

Daniel Scheer, P.E.
State Specifications Engineer

DS/dt

Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

CORRUGATED STEEL PIPE AND PIPE ARCH (INCLUDING UNDERDRAIN).

(REV ~~3-14-144-8-135-13-145-197-15-14~~)

**SECTION 943
CORRUGATED STEEL PIPE AND PIPE ARCH
(INCLUDING UNDERDRAIN)**

943-1 General Requirements.

Corrugated steel pipe, including round culvert pipe, pipe arch and underdrain and coupling bands for each type shall conform to AASHTO M36. *Except for underdrain, corrugated steel pipe including pipe arch shall be fabricated with helical corrugations with a minimum of two annular corrugations formed on each end of each pipe to accommodate a coupling band. Annular fabrication is not permitted unless specifically called for in the Plans or Specifications.* Provide *notarized* certification of the actual mean *inside* diameter *and lengths* of pipe shipped to the project. Include in the certification the minimum and maximum *inside* diameters used to certify the actual mean *inside* diameter. ~~The certification shall be attested to by a person having legal authority to bind the manufacturing company.~~

~~—————In addition, except for underdrain corrugated steel pipe including pipe arch shall be fabricated with helical corrugations with a minimum of two annular corrugations formed on each end of each pipe to accommodate a coupling band. Annular fabrication is not permitted unless specifically called for in the Plans or Specifications.~~

~~Ensure that~~ *Test* the pipe joints ~~have been tested at the plant~~ hydrostatically at the specified pressure using test methods in ASTM D3212 with the exceptions of Sections 7.3 and 7.4. In lieu of Section 7.4, deflect one side of the pipe to a 5% reduction in internal diameter using the parallel plate testing methodology of ASTM D2412. Load the deflected pipe to within 1/2 the actual pipe diameter from the centerline of the gasket or just beyond the end of the hugger band, whichever is greater. Ensure that the loading mechanism does not contact the hugger band or associated hardware. Testing *of pipe joints* shall be *done at the manufacturing plant and* witnessed by the Engineer *or designated representative.*

~~—————Test the gaskets in accordance with ASTM D3212. Testing of gaskets shall be witnessed by the Engineer.~~

943-2 Round Culvert Pipe.

For round culvert pipe used as sidedrain, unless shown otherwise in the Plans, the minimum thickness of the metal (including galvanizing - AASHTO M218, or aluminum coating - AASHTO M274), shall be as specified below.

TABLE I THICKNESS OF METAL FOR SIDEDRAIN PIPE		
Nominal Diameter (Inches)	Metal Sheet Gauge No.	Mean Thickness Metal (Inches)
6	18	0.0516

TABLE I THICKNESS OF METAL FOR SIDEDRAIN PIPE		
Nominal Diameter (Inches)	Metal Sheet Gauge No.	Mean Thickness Metal (Inches)
8	16	0.0635
10	16	0.0635
12	16	0.0635
15	16	0.0635
18	16	0.0635
21	16	0.0635
24	16	0.0635
30	14	0.0785
36	14	0.0785
42	12	0.1084
48	12	0.1084
54	12	0.1084
60	10	0.1382
66	10	0.1382
72	10	0.1382
78	8	0.1681
84	8	0.1681
90	8	0.1681
96 and over	8	0.1681

TABLE II PERMISSIBLE VARIATION IN THICKNESS OF METAL FOR PIPE AND CONNECTING BANDS		
Metal Sheet Gauge No	Mean Thickness of Metal (Inches)	Permissible Variation (Inches)
18	0.0516	0.007
16	0.0635	0.007
14	0.0785	0.008
12	0.1084	0.009
10	0.1382	0.009
8	0.1681	0.009

943-3 Pipe Arch.

For corrugated metal pipe arch, in addition to the requirements shown in AASHTO M36, thickness of the metal shall be as shown for the equivalent size round pipe in Tables I and II, above, and the fabrication of the pipe arch sections shall be such as to insure a substantially flat invert.

943-4 Alternate Connecting Bands.

In addition to the connecting bands as specified in AASHTO M36, alternate types of connecting bands are specified in 430-8.1.3, for use with the types of installations as shown.

943-5 Bituminous Coating and Paved Invert.

When bituminous coating is specified, the pipe, or pipe arch, shall be coated in accordance with the requirements of AASHTO M190, for Type A (Fully Bituminous Coated).

When bituminous coated and paved invert are specified the pipe or pipe arch shall be coated and paved in accordance with AASHTO M190, for Type C (Fully Bituminous Coated and Paved). The temperature of the asphalt at the time of coating and the duration of the pipe submerged time shall be optimized such that excess coating does not adhere to the pipe.

943-6 Paved Interior.

When bituminous coated and paved interior are called for, the coating and paving shall meet the requirements specified above for bituminous and paved invert (Type C), with the following additions and exceptions:

(a) The smooth pavement formed by the asphalt cement shall extend over the entire interior of the pipe.

(b) The exterior coating and the interior paving shall be applied.

(c) No markings will be required on the outside of the pipe to designate the center line of the top of the pipe.

(d) Lifting lugs shall be attached to the pipe, and shall be suitably placed to facilitate moving the pipe without damage to the exterior or interior bituminous material.

943-7 Basis of Acceptance of Bituminous Coating and Paving.

The acceptance of the bituminous coating, paved invert, and paved interior will be based on the manufacturer's certified mill tests.

943-8 Underdrain Pipe.

Corrugated metal pipe for underdrain shall conform to the requirements of AASHTO M36 except that Class IV pipe, as specified in Section 18.1.1.4 therein, shall not be used.

**CORRUGATED STEEL PIPE AND PIPE ARCH (INCLUDING UNDERDRAIN).
(REV 7-15-14)**

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Test the pipe joints hydrostatically at the specified pressure using test methods in ASTM D3212 with the exceptions of Sections 7.3 and 7.4. In lieu of Section 7.4, deflect one side of the pipe to a 5% reduction in internal diameter using the parallel plate testing methodology of ASTM D2412. Load the deflected pipe to within 1/2 the actual pipe diameter from the centerline of the gasket or just beyond the end of the hugger band, whichever is greater. Ensure that the loading mechanism does not contact the hugger band or associated hardware. Testing of pipe joints shall be done at the manufacturing plant and witnessed by the Engineer or designated representative.

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For round culvert pipe used as sidedrain, unless shown otherwise in the Plans, the minimum thickness of the metal (including galvanizing - AASHTO M218, or aluminum coating - AASHTO M274), shall be as specified below.

Nominal Diameter (Inches)	Metal Sheet Gauge No.	Mean Thickness Metal (Inches)
6	18	0.0516
8	16	0.0635
10	16	0.0635
12	16	0.0635
15	16	0.0635
18	16	0.0635
21	16	0.0635
24	16	0.0635
30	14	0.0785
36	14	0.0785

Nominal Diameter (Inches)	Metal Sheet Gauge No.	Mean Thickness Metal (Inches)
42	12	0.1084
48	12	0.1084
54	12	0.1084
60	10	0.1382
66	10	0.1382
72	10	0.1382
78	8	0.1681
84	8	0.1681
90	8	0.1681
96 and over	8	0.1681

Metal Sheet Gauge No	Mean Thickness of Metal (Inches)	Permissible Variation (Inches)
18	0.0516	0.007
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In addition to the connecting bands as specified in AASHTO M36, alternate types of connecting bands are specified in 430-8.1.3, for use with the types of installations as shown.

943-5 Bituminous Coating and Paved Invert.

When bituminous coating is specified, the pipe, or pipe arch, shall be coated in accordance with the requirements of AASHTO M190, for Type A (Fully Bituminous Coated).

When bituminous coated and paved invert are specified the pipe or pipe arch shall be coated and paved in accordance with AASHTO M190, for Type C (Fully Bituminous Coated and Paved). The temperature of the asphalt at the time of coating and the duration of the pipe submerged time shall be optimized such that excess coating does not adhere to the pipe.

943-6 Paved Interior.

When bituminous coated and paved interior are called for, the coating and paving shall meet the requirements specified above for bituminous and paved invert (Type C), with the following additions and exceptions:

- (a) The smooth pavement formed by the asphalt cement shall extend over the entire interior of the pipe.
- (b) The exterior coating and the interior paving shall be applied.
- (c) No markings will be required on the outside of the pipe to designate the center line of the top of the pipe.
- (d) Lifting lugs shall be attached to the pipe, and shall be suitably placed to facilitate moving the pipe without damage to the exterior or interior bituminous material.

943-7 Basis of Acceptance of Bituminous Coating and Paving.

The acceptance of the bituminous coating, paved invert, and paved interior will be based on the manufacturer's certified mill tests.

943-8 Underdrain Pipe.

Corrugated metal pipe for underdrain shall conform to the requirements of AASHTO M36 except that Class IV pipe, as specified in Section 18.1.1.4 therein, shall not be used.