



## Florida Department of Transportation

RICK SCOTT  
GOVERNOR

605 Suwannee Street  
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ANANTH PRASAD, P.E.  
SECRETARY

December 5, 2011

Monica Gourdine  
Program Operations Engineer  
Federal Highway Administration  
545 John Knox Road, Suite 200  
Tallahassee, Florida 32303

Re: Office of Design, Specifications  
Section **560**  
Proposed Specification: **5601100 Coating Structural Steel.**

Dear Ms. Gourdine:

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

These changes were proposed by Paul Vinik to require the unexposed side of sheet piles to be painted with inorganic zinc primer to enhance corrosion resistance.

Please review and transmit your comments, if any, within two weeks. Comments should be sent via Email to SP965RP or rudy.powell@dot.state.fl.us.

If you have any questions relating to this specification change, please call Rudy Powell, State Specifications Engineer at 414-4280.

Sincerely,

Rudy Powell, Jr., P.E.  
State Specifications Engineer

RP/cah

Attachment

cc: Calvin Johnson, Chief Civil Litigation  
Florida Transportation Builders' Assoc.  
State Construction Engineer

**COATING STRUCTURAL STEEL.****(REV 9-19-11)**

ARTICLE 560-11 (of the Supplemental Specification) is deleted and the following substituted:

**560-11 ~~Coal-Tar-Epoxy~~ Coating of Permanent ~~Bulkhead-Sheet, Pipe-Piles~~ and H Piles.**

**560-11.1 Surface Preparation:** Prepare the substrate in accordance with 560-7. Provide a depth of anchor profile in accordance with the manufacturer's product data sheet, but in no case less than 2.5 mils. Re-blast piles not coated during the same shift or if the surface to be coated no longer meets the requirements SSPC-SP 10.

**560-11.2 Application of Coating:** Unless otherwise shown in the Contract Documents, apply the inorganic zinc *primer to all surfaces of H and sheet piles and the exterior surface of pipe piles. Unless otherwise shown in the Contract Documents, apply* ~~and~~ coal tar-epoxy coatings to ~~all sides of H piles and~~ the exposed side of sheet ~~and pipe~~ piles from the top of the piles to a depth of five feet below the lower of the design ground surface or the design scour depth. Apply the inorganic zinc *primer* in accordance with this Section. Apply the coal tar-epoxy in accordance with the following specific requirements:

(1) Apply the coal tar-epoxy system in two coats. The time interval between the first coat and the second coat will be in strict accordance with the coating manufacturer's published specifications. Apply the first coat to yield a dry film thickness of 8 to 10 mils. Apply the second coat to attain a total dry film thickness of the two coats between 16 and 20 mils.

(2) Ensure that no portion of the coating is less than the specified minimum film thicknesses. The total minimum film thickness for any combination of coats will be the sum total of the averages of the specified thickness range of the individual coats.

(3) After applying the coating on the steel piles, the Engineer will thoroughly inspect the surfaces and make film thickness measurements at the approximate rate of one for each 25 ft<sup>2</sup> of area unless deficient thickness is found. In this case, the rate of sub-measurements will be increased as required to determine the extent of the deficient area.

**COATING STRUCTURAL STEEL.****(REV 9-19-11)**

ARTICLE 560-11 (of the Supplemental Specification) is deleted and the following substituted:

**560-11 Coating of Permanent Sheet, Pipe and H Piles.**

**560-11.1 Surface Preparation:** Prepare the substrate in accordance with 560-7. Provide a depth of anchor profile in accordance with the manufacturer's product data sheet, but in no case less than 2.5 mils. Re-blast piles not coated during the same shift or if the surface to be coated no longer meets the requirements SSPC-SP 10.

**560-11.2 Application of Coating:** Unless otherwise shown in the Contract Documents, apply the inorganic zinc primer to all surfaces of H and sheet piles and the exterior surface of pipe piles. Unless otherwise shown in the Contract Documents, apply coal tar-epoxy coatings to the exposed side of sheet piles from the top of the piles to a depth of five feet below the lower of the design ground surface or the design scour depth. Apply the inorganic zinc primer in accordance with this Section. Apply the coal tar-epoxy in accordance with the following specific requirements:

(1) Apply the coal tar-epoxy system in two coats. The time interval between the first coat and the second coat will be in strict accordance with the coating manufacturer's published specifications. Apply the first coat to yield a dry film thickness of 8 to 10 mils. Apply the second coat to attain a total dry film thickness of the two coats between 16 and 20 mils.

(2) Ensure that no portion of the coating is less than the specified minimum film thicknesses. The total minimum film thickness for any combination of coats will be the sum total of the averages of the specified thickness range of the individual coats.

(3) After applying the coating on the steel piles, the Engineer will thoroughly inspect the surfaces and make film thickness measurements at the approximate rate of one for each 25 ft<sup>2</sup> of area unless deficient thickness is found. In this case, the rate of sub-measurements will be increased as required to determine the extent of the deficient area.